
**Injection containers and accessories —
Part 1:
Injection vials made of glass tubing**

*Réipients et accessoires pour produits injectables —
Partie 1: Flacons en verre étiré*

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 8362-1 was prepared by Technical Committee ISO/TC 76, *Transfusion, infusion and injection equipment for medical and pharmaceutical use*.

This second edition cancels and replaces the first edition (ISO 8362-1:1989), which has been technically revised.

ISO 8362 consists of the following parts, under the general title *Injection containers and accessories*:

- *Part 1: Injection vials made of glass tubing*
- *Part 2: Closures for injection vials*
- *Part 3: Aluminium caps for injection vials*
- *Part 4: Injection vials made of moulded glass*
- *Part 5: Freeze drying closures for injection vials*
- *Part 6: Caps made of aluminium-plastics combinations for injection vials*
- *Part 7: Injection caps made of aluminium-plastics combinations without overlapping plastics part*

Introduction

The purpose of this part of ISO 8362 is to specify the dimensions, capacities, form and requirements of glass vials intended for medical use. Containers made from glass tubing are considered to be suitable for the packaging and storage of injectable preparations until they are administered for medicinal purposes. Such containers may be made from different types of glass which can affect the chemical resistance properties; e.g., those made from borosilicate glass will have a very high level of chemical resistance whereas others made from soda-lime glass will have a lower, but adequate, chemical resistance for the purpose for which they are intended. The chemical resistance of the internal surface of containers made from soda-lime glass can be improved by means of a treatment during production aimed at producing a chemical resistance equal to that of those made from borosilicate glass for single use. This level of chemical resistance is maintained as long as the interior surface is not destroyed by chemical attack, in which case it is reduced to that of untreated soda-lime glass.

Because containers may be made from different types of glass and because it is the chemical behaviour of the internal surface which is important when they are filled with injectable preparations, it is essential to specify test procedures by which this performance can be measured. The procedures recommended in this part of ISO 8362 permit this performance based on the hydrolytic resistance to be measured and, from the result of measurement, it is possible to classify containers into their correct category. The procedure also allows containers to be tested and to determine, after an intermediate stage, whether the hydrolytic resistance is produced by the composition of the glass as a material or by a treatment of the internal surface.

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Injection containers and accessories —

Part 1: Injection vials made of glass tubing

1 Scope

This part of ISO 8362 specifies the form, dimensions and capacities of glass vials for injectable preparations. It also specifies the material from which such containers shall be made and the performance requirements of those containers.

This part of ISO 8362 applies to colourless or amber glass containers made from borosilicate or soda-lime glass, in the form of glass tubing, whether internally surface-treated or not, and intended for use in the packaging, storage or transportation of products intended for injection.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 719:1985, *Glass — Hydrolytic resistance of glass grains at 98 °C — Method of test and classification*

ISO 720:1985, *Glass — Hydrolytic resistance of glass grains at 121 °C — Method of test and classification*

ISO 1101:1983, *Technical drawings — Geometrical tolerancing — Tolerancing of form, orientation, location and run-out — Generalities, definitions, symbols, indications on drawings*

ISO 4802-1:1988, *Glassware — Hydrolytic resistance of the interior surfaces of glass containers — Part 1: Determination by titration method and classification*

ISO 4802-2:1988, *Glassware — Hydrolytic resistance of the interior surfaces of glass containers — Part 2: Determination by flame spectrometry and classification*

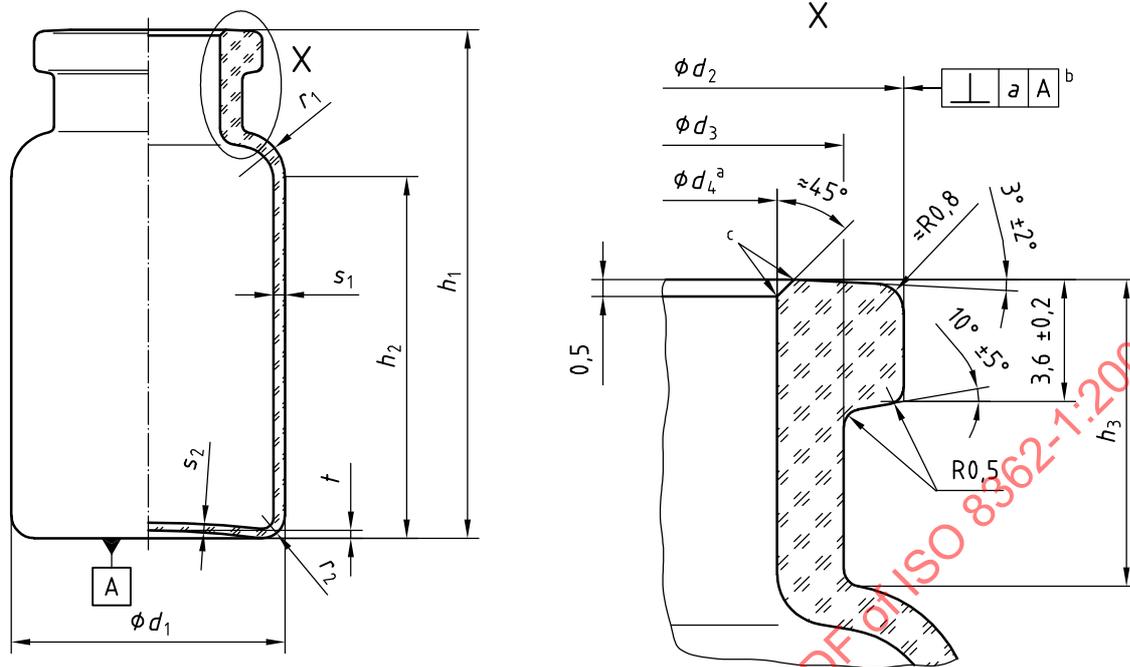
3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 4802-1 and ISO 4802-2 apply.

4 Dimensions

The dimensions of injection vials made of glass tubing shall be as shown in Figure 1 and as given in Table 1; the overflow capacity and mass shall be as given in Table 1.

Dimensions in millimetres



- a The opening of the vial should have a constant diameter, over the entire distance, h_3 , i.e. it should exhibit a cylindrical shape. A slightly conical shape can be accepted if the following requirements are fulfilled:
 - the truncated cone has the height, h_3 ;
 - the larger diameter is located at the flange;
 - the larger diameter does not exceed the smaller one by more than 0,3 mm.
- b The perpendicularity tolerance a (as defined in ISO 1101) is a limit for the deviation of the plumb-line through the centre of the bottom part and the axis of the vial at the upper edge of the flange; it is measured at the brim.
- c Edges slightly rounded.

Figure 1 — Typical example of injection vial made of glass tubing

Table 1 — Dimensions, overflow capacity and mass

Size designation of injection vial	Overflow capacity		a mm	d_1 mm	d_2 mm	d_3 mm	d_4 mm	h_1 mm	h_2 mm	h_3 mm	r_1 mm	r_2 mm	s_1 mm	s_2 mm	t mm	Mass g	
	ml	tol.															tol.
2R	4	$\pm 0,5$	1	16	$\pm 0,15$	13	10,5	7	35	22	8	2,5	1,5	0,6	0,7	5	
4R	6								45							32	6,1
6R	10								40							26	8,3
8R	11,5	± 1	1,2	22	$\pm 0,2$	16,5	12,6	$\pm 0,5$	8,5	$\pm 0,5$	3,5	2	1	$\pm 0,04$	0,7	9,4	
10R	13,5								45							31	10,2
15R	19	$\pm 1,5$	1,5	24	$\pm 0,25$	20	17,5	$\pm 0,7$	9	4,0	4,0	2	0,7	1	12,8		
20R	26								45						30	17,4	
25R	32,5								60						45	20	
30R	37,5	$\pm 1,5$	1,5	30	$\pm 0,25$	20	17,5	$\pm 0,7$	10	5,5	2,5	1,2	$\pm 0,05$	1	22,7		
									75						55		