MEDICAL PACKAGING TRANSITION PROJECT
CELL DESCRIPTORS
METRIC UNITS
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## Metric Units

**EO**
- Pouches and Bags
- FFS
- Rigid Tray

**Gamma**
- Pouches and Bags
- FFS
- Rigid Tray

**Electron Beam**
- Pouches and Bags
- FFS

**Steam**
- Pouches and Bags
- Rigid Tray

**Dry Heat**
- Rigid Tray

**Low Temperature H₂O₂**
- Pouches and Bags
- Rigid Tray
<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chevron peel pouch</td>
<td>EO deep draw</td>
</tr>
<tr>
<td></td>
<td>Number of cycles: 2</td>
</tr>
<tr>
<td>Top Web</td>
<td>Total time <em>per cycle</em> (excluding pre- and post-conditioning):</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>12 hours and 0 minutes</td>
</tr>
<tr>
<td>Oliver-Tolas® XHale® 109P Coated</td>
<td>EO exposure time <em>per cycle</em>: 3 hours and 0 minutes</td>
</tr>
<tr>
<td>Bottom Web</td>
<td>EO concentration: 560 mg/L</td>
</tr>
<tr>
<td>Oliver-Tolas®</td>
<td>Maximum temperature: 54°C</td>
</tr>
<tr>
<td>12 micron PET/51 micron LDPE Film</td>
<td>Maximum relative humidity: 90%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: 51 mbar/min</td>
</tr>
</tbody>
</table>
DuPont™ Tyvek® 1073B – Coated – Pouch – EO

Metric Units

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® CR27 EU Coated

**Bottom Web**

12 micron PET/50 micron LDPE Film

**Sterilization**

EO deep draw

Number of cycles: 1
Total time per cycle (excluding pre- and post-conditioning): 8 hours and 16 minutes
EO exposure time per cycle: 4 hours and 2 minutes
EO concentration: 1455 mg/L
Maximum temperature: 52°C
Maximum relative humidity: 70%
Maximum pressure rate change: 62 mbar/min
## DuPont™ Tyvek® 1073B – Coated – Header bag – EO

### Metric Units

<table>
<thead>
<tr>
<th><strong>Package Configuration</strong></th>
<th><strong>Sterilization</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Header bag</strong></td>
<td><strong>EO deep draw</strong></td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td><strong>Number of cycles:</strong> 2</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td><strong>Total time per cycle (excluding pre- and post-conditioning):</strong> 8 hours and 30 minutes</td>
</tr>
<tr>
<td>Amcor Flexibles Inc. Coated</td>
<td><strong>EO exposure time per cycle:</strong> ~3-4 hours and 0 minutes</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td><strong>EO concentration:</strong> 465 mg/L</td>
</tr>
<tr>
<td>Amcor Flexibles Inc.</td>
<td><strong>Maximum temperature:</strong> 70°C</td>
</tr>
<tr>
<td>102 micron PE/Nylon/PE Bag Film</td>
<td><strong>Maximum relative humidity:</strong> ~100%</td>
</tr>
<tr>
<td></td>
<td><strong>Maximum pressure rate change:</strong> 138 mbar/min</td>
</tr>
</tbody>
</table>
DuPont™ Tyvek® 1073B – Coated – Header bag – EO

Metric Units

Package Configuration

Header bag

Top Web

DuPont™ Tyvek® 1073B
Perfecseal® CR27 EU Coated

Bottom Web

130 micron transparent and white PE films

Sterilization

EO shallow draw

Number of cycles: 1
Total time per cycle (excluding pre- and post-conditioning): >18 hours and 10 minutes
EO exposure time per cycle: >14 hours and 0 minutes
EO concentration: >194 mg/L
Maximum temperature: 45°C
Maximum relative humidity: 95%
Maximum pressure rate change: 35 mbar/min
DuPont™ Tyvek® 1073B – Coated – Pouch – EO

Metric Units

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® CR27 Coated

**Bottom Web**

102 micron Multi-layer Nylon/PE Coex Film

**Sterilization**

EO shallow draw

- Number of cycles: 2
- Total time per cycle (excluding pre- and post-conditioning): 13 hours and 0 minutes
- EO exposure time per cycle: 10 hours and 0 minutes
- EO concentration: 770 mg/L
- Maximum temperature: 48°C
- Maximum relative humidity: 81%
- Maximum pressure rate change: 49 mbar/min
DuPont™ Tyvek® 1073B – Coated – Header bag – EO

Metric Units

**Package Configuration**

Header bag

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® HCW CR27 Coated

**Bottom Web**

ShielLD™ 36604-O
102 micron Nylon/PE Bag Film

**Sterilization**

EO deep draw

Number of cycles: 1

Total time *per cycle* *(including* pre- and post-conditioning)*: 27 hours and 0 minutes

EO exposure time *per cycle*: 3 hours and 0 minutes

EO concentration: **600 mg/L**

Maximum temperature: **66°C**

Maximum relative humidity: ~**100%**

Maximum pressure rate change: **69 mbar/min**
DuPont™ Tyvek® 1073B – Coated – Pouch – EO

Metric Units

Package Configuration

Chevron peel pouch

Top Web

DuPont™ Tyvek® 1073B
Oliver-Tolas® SealScience® TPT-0270 Coated

Bottom Web

Oliver-Tolas® TPF-0524
25 micron Biax Nylon/76 micron LLDPE Film

Sterilization

EO deep draw

Number of cycles: 2
Total time per cycle (excluding pre- and post-conditioning): 16 hours and 25 minutes
EO exposure time per cycle: 8 hours and 10 minutes
EO concentration: 518 mg/L
Maximum temperature: 56°C
Maximum relative humidity: 90%
Maximum pressure rate change: 71 mbar/min
### Package Configuration

**Chevron peel pouch**

### Top Web

- DuPont™ Tyvek® 1073B
- Oliver-Tolas® Uncoated

### Bottom Web

- Oliver-Tolas® TPF-0501A
- 12 micron PET/51 micron LDPE Film

### Sterilization

**EO deep draw**

- Number of cycles: 2
- Total time *per cycle* (excluding pre- and post-conditioning): 16 hours and 25 minutes
- EO exposure time *per cycle*: 8 hours and 10 minutes
- EO concentration: 518 mg/L
- Maximum temperature: 56°C
- Maximum relative humidity: 90%
- Maximum pressure rate change: 71 mbar/min
**DuPont™ Tyvek® 1073B – Uncoated – Pouch – EO**

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
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</thead>
<tbody>
<tr>
<td><strong>Chevron peel pouch</strong></td>
<td><strong>EO deep draw</strong></td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td>Number of cycles: 3</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Total time per cycle (excluding pre- and post-conditioning):</td>
</tr>
<tr>
<td>Mangar Industries Uncoated</td>
<td>~6 hours and 45 minutes</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td>EO exposure time per cycle: ~5 hours and 0 minutes</td>
</tr>
<tr>
<td>12 micron PET/51 micron LDPE Film</td>
<td>EO concentration: 600 mg/L</td>
</tr>
<tr>
<td></td>
<td>Maximum temperature: 54°C</td>
</tr>
<tr>
<td></td>
<td>Maximum relative humidity: 75%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: 34 mbar/min</td>
</tr>
</tbody>
</table>
DuPont™ Tyvek® 1073B – Uncoated – Pouch – EO

### Metric Units

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<tr>
<td><strong>Chevron peel pouch</strong></td>
<td><strong>EO deep draw</strong></td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td>Number of cycles: 2</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Total time <em>per cycle</em> (including pre- and post-conditioning): &gt;16 hours and 0 minutes</td>
</tr>
<tr>
<td>Mangar Industries Uncoated</td>
<td>EO exposure time <em>per cycle</em>: &gt;6 hours and 0 minutes</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td>EO concentration: &gt;500 mg/L</td>
</tr>
<tr>
<td>25 micron Biax Nylon/51 micron PE Film</td>
<td>Maximum temperature: ~55°C</td>
</tr>
<tr>
<td></td>
<td>Maximum relative humidity: ~90%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: 34 mbar/min</td>
</tr>
</tbody>
</table>
DuPont™ Tyvek® 1073B – Uncoated – Pouch – EO

### Package Configuration

<table>
<thead>
<tr>
<th>Top Web</th>
<th>Bottom Web</th>
</tr>
</thead>
<tbody>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Perfecflex® 35891-K</td>
</tr>
<tr>
<td>Perfecseal® Uncoated</td>
<td>23 micron OPET/76 micron PE Film</td>
</tr>
</tbody>
</table>

### Sterilization

**EO deep draw**

- Number of cycles: 2
- **Total time per cycle (excluding pre- and post-conditioning):** 8-12 hours and 0 minutes
- EO exposure time per cycle: 2 hours and 0 minutes
- EO concentration: **640 - 720 mg/L**
- Maximum temperature: **52°C**
- Maximum relative humidity: **60%**
- Maximum pressure rate change: **55 mbar/min**
# DUPONT MEDICAL PACKAGING TRANSITION PROJECT

## DuPont™ Tyvek® 1073B – Uncoated – Pouch – EO

### Metric Units

<table>
<thead>
<tr>
<th><strong>Package Configuration</strong></th>
<th><strong>Sterilization</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Chevron peel pouch</strong></td>
<td><strong>EO deep draw</strong></td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td>Number of cycles: 1</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Total time <em>per cycle</em> <em>(including pre- and post-conditioning)</em>: 29-30 hours and 0 minutes</td>
</tr>
<tr>
<td>Beacon Converters® Uncoated</td>
<td>EO exposure time <em>per cycle</em>: 5-6 hours and 0 minutes</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td>EO concentration: 500 mg/L</td>
</tr>
<tr>
<td>Beacon Converters® A29™</td>
<td>Maximum temperature: 49°C</td>
</tr>
<tr>
<td>25 micron Biax Nylon/76 micron Peelable PE Film</td>
<td>Maximum relative humidity: 75%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: 34 mbar/min</td>
</tr>
</tbody>
</table>
DuPont™ Tyvek® 1073B – Uncoated – Pouch – EO

**Metric Units**

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1073B
Amcor Flexibles Inc. Uncoated

**Bottom Web**

Amcor Flexibles Inc.
12 micron PET/Adhesive/51 micron LDPE Film

**Sterilization**

EO deep draw

Number of cycles: 3
Total time per cycle (excluding pre- and post-conditioning): 
~13 hours and 45 minutes
EO exposure time per cycle: 3-4 hours and 0 minutes
EO concentration: ~660 mg/L
Maximum temperature: 57°C
Maximum relative humidity: 90%
Maximum pressure rate change: 111 mbar/min
**DuPont™ Tyvek® 1073B – Uncoated – Pouch – EO**

**Metric Units**

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1073B  
Mangar Industries Uncoated

**Bottom Web**

25 micron Nylon/  
51 micron Peelable LDPE/Allegro® T Film

**Sterilization**

EO deep draw

- Number of cycles: 2
- Total time per cycle (excluding pre- and post-conditioning): 13 hours and 12 minutes
- EO exposure time per cycle: 4 hours and 0 minutes
- EO concentration: 650 mg/L
- Maximum temperature: 45°C
- Maximum relative humidity: 100%
- Maximum pressure rate change: 30 mbar/min
**DuPont™ Tyvek® 1059B – Uncoated – Header bag – EO**

**Metric Units**

**Package Configuration**

Kwikbreathe™ True Header Bag

**Top Web**

DuPont™ Tyvek® 1059B  
Printpack Inc. Uncoated

**Bottom Web**

Printpack Inc.  
102 micron LLDPE-mULDPE Films

**Sterilization**

EO shallow draw

Number of cycles: 2  
Total time per cycle (excluding pre- and post-conditioning):  
~13 hours and 30 minutes  
EO exposure time per cycle: 7 hours and 0 minutes  
EO concentration: ~500 mg/L  
Maximum temperature: 60°C  
Maximum relative humidity: 80%  
Maximum pressure rate change: 68 mbar/min
DuPont™ Tyvek® 1059B – Uncoated – Pouch – EO

Metric Units

Package Configuration

Chevron peel pouch

Top Web

DuPont™ Tyvek® 1059B
Amcor Flexibles Inc. Uncoated

Bottom Web

Amcor Flexibles Inc.
12 micron PET/58 micron LLDPE/EVA Film

Sterilization

EO deep draw

Number of cycles: 3
Total time per cycle (excluding pre- and post-conditioning): 12 hours and 0 minutes
EO exposure time per cycle: 4 hours and 30 minutes
EO concentration: 600 mg/L
Maximum temperature: 60°C
Maximum relative humidity: 85%
Maximum pressure rate change: 80 mbar/min
DuPont™ Tyvek® 1059B – Uncoated – Pouch – EO

Metric Units

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1059B
Mangar Industries Uncoated

**Bottom Web**

12 micron PET/51 micron LDPE Film

**Sterilization**

EO deep draw

Number of cycles: 2
Total time per cycle (excluding pre- and post-conditioning): 8-10 hours and 0 minutes
EO exposure time per cycle: 2 hours and 0 minutes
EO concentration: 370 mg/L
Maximum temperature: 54°C
Maximum relative humidity: 55%
Maximum pressure rate change: 51 mbar/min
DuPont™ Tyvek® 1059B – Uncoated – Pouch – EO

Metric Units

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1059B  
Beacon Converters® Uncoated

**Bottom Web**

Beacon Converters® A24™  
23 micron PET/51 micron PE Film

**Sterilization**

EO deep draw

Number of cycles: 1  
Total time *per cycle* (excluding pre- and post-conditioning): 11 hours and 40 minutes  
EO exposure time *per cycle*: 5 hours and 0 minutes  
EO concentration: 610 mg/L  
Maximum temperature: 54°C  
Maximum relative humidity: 85%  
Maximum pressure rate change: 34 mbar/min
**DuPont™ Tyvek® 1059B – Uncoated – Vent bag – EO**

**Metric Units**

<table>
<thead>
<tr>
<th><strong>Package Configuration</strong></th>
<th><strong>Sterilization</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Vent bag</strong></td>
<td><strong>EO shallow draw</strong></td>
</tr>
<tr>
<td></td>
<td>Number of cycles: 1</td>
</tr>
<tr>
<td></td>
<td>Total time <em>per cycle</em> <em>(excluding pre- and post-conditioning)</em>: 13 hours and 0 minutes</td>
</tr>
<tr>
<td></td>
<td>EO exposure time <em>per cycle</em>: 6 hours and 0 minutes</td>
</tr>
<tr>
<td></td>
<td>EO concentration: <strong>1000 mg/L</strong></td>
</tr>
<tr>
<td></td>
<td>Maximum temperature: <strong>60°C</strong></td>
</tr>
<tr>
<td></td>
<td>Maximum relative humidity: <strong>85%</strong></td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: <strong>44 mbar/min</strong></td>
</tr>
</tbody>
</table>

**Top Web**

DuPont™ Tyvek® 1059B  
Amcor Flexibles Inc. Uncoated

**Bottom Web**

Amcor Flexibles Inc.  
Durable Coex Film with Linear Tear Properties
### DuPont™ Tyvek® 1059B – Uncoated – Pouch – EO

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chevron peel pouch</td>
<td>EO deep draw</td>
</tr>
<tr>
<td></td>
<td>Number of cycles: 2</td>
</tr>
<tr>
<td></td>
<td>Total time <em>per cycle</em> (including pre- and post-conditioning): 20 hours and 0 minutes</td>
</tr>
<tr>
<td></td>
<td>EO exposure time <em>per cycle</em>: 2 hours and 0 minutes</td>
</tr>
<tr>
<td></td>
<td>EO concentration: 500 mg/L</td>
</tr>
<tr>
<td></td>
<td>Maximum temperature: 63°C</td>
</tr>
<tr>
<td></td>
<td>Maximum relative humidity: 100%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: 45 mbar/min</td>
</tr>
</tbody>
</table>

**Top Web**

- DuPont™ Tyvek® 1059B
- Perfecseal® Uncoated

**Bottom Web**

- Perfecflex® 35793-E
- 12 micron PET/38 micron PE Film
DuPont™ Tyvek® 1059B – Uncoated – Pouch – EO

Metric Units

Package Configuration

Chevron peel pouch

Top Web

DuPont™ Tyvek® 1059B
Beacon Converters® Uncoated

Bottom Web

Beacon Converters® A20™
12 micron PET/51 micron LDPE Film

Sterilization

EO deep draw

Number of cycles: 1
Total time per cycle (excluding pre- and post-conditioning): 11 hours and 30 minutes
EO exposure time per cycle: 6 hours and 0 minutes
EO concentration: >560 mg/L
Maximum temperature: 60°C
Maximum relative humidity: 80%
Maximum pressure rate change: 68 mbar/min
DuPont™ Tyvek® 1073B – Coated – FFS flexible blister – EO

Metric Units

**Package Configuration**

FFS flexible blister

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® SBP2000 Coated

**Bottom Web**

PerfecForm® ESE 35850-O
102 micron EVA/Surlyn®/EVA Forming Film

**Sterilization**

EO shallow draw

Number of cycles: 1

Total time *per cycle* (excluding pre- and post-conditioning): 10 hours and 8 minutes

EO exposure time *per cycle*: 4 hours and 5 minutes

EO concentration: **600 - 650 mg/L**

Maximum temperature: **60°C**

Maximum relative humidity: **80%**

Maximum pressure rate change: **34 mbar/min**
# DUPONT MEDICAL PACKAGING TRANSITION PROJECT

## DuPont™ Tyvek® 1073B – Coated – FFS rigid blister – EO

### Metric Units

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>FFS rigid blister</td>
<td>EO deep draw</td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td>Number of cycles: 1</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Total time per cycle (excluding pre- and post-conditioning): 11 hours and 30 minutes</td>
</tr>
<tr>
<td>Perfecseal® CR27 EU Coated</td>
<td>EO exposure time per cycle: 4 hours and 0 minutes</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td>EO concentration: 600 mg/L</td>
</tr>
<tr>
<td>500 micron PETG Forming Film</td>
<td>Maximum temperature: 46°C</td>
</tr>
<tr>
<td></td>
<td>Maximum relative humidity: 80%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: 35 mbar/min</td>
</tr>
</tbody>
</table>

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DuPont™ Tyvek® 1073B – Coated – FFS flexible blister – EO

Metric Units

**Package Configuration**

FFS flexible blister

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® CR27 EU Coated

**Bottom Web**

Multi-layer (Nylon, EvOH, others) Forming Film

**Sterilization**

EO shallow draw

Number of cycles: 1
Total time *per cycle* (including pre- and post-conditioning): 8 hours and 0 minutes
EO exposure time *per cycle*: 2 hours and 0 minutes
EO concentration: 590 mg/L
Maximum temperature: 55°C
Maximum relative humidity: 80%
Maximum pressure rate change: 33 mbar/min
### DuPont™ Tyvek® 1073B – Coated – FFS flexible blister – EO

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>FFS flexible blister</td>
<td>EO shallow draw</td>
</tr>
<tr>
<td></td>
<td>Number of cycles: 2</td>
</tr>
<tr>
<td></td>
<td>Total time per cycle (excluding pre- and post-conditioning): ~12 hours and 30 minutes</td>
</tr>
<tr>
<td></td>
<td>EO exposure time per cycle: ~6 hours and 0 minutes</td>
</tr>
<tr>
<td></td>
<td>EO concentration: 520 mg/L</td>
</tr>
<tr>
<td></td>
<td>Maximum temperature: 60°C</td>
</tr>
<tr>
<td></td>
<td>Maximum relative humidity: ~100%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: ~68 mbar/min</td>
</tr>
</tbody>
</table>

**Top Web**

- DuPont™ Tyvek® 1073B
- Oliver-Tolas® XHale® 27HT-7 Coated

**Bottom Web**

- 152 micron Surlyn®/PE Flex Forming Film
DuPont™ Tyvek® 1073B – Coated – FFS flexible blister – EO

**Metric Units**

### Package Configuration

<table>
<thead>
<tr>
<th>Top Web</th>
<th>Bottom Web</th>
</tr>
</thead>
<tbody>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>203 micron EVA/Surlyn®/EVA Forming Film</td>
</tr>
<tr>
<td>Oliver-Tolasa® XHale® 10MP Coated</td>
<td></td>
</tr>
</tbody>
</table>

### Sterilization

- **EO deep draw**
  - Number of cycles: 2
  - Total time *per cycle* (excluding pre- and post-conditioning): 8-12 hours and 0 minutes
  - EO exposure time *per cycle*: 2 hours and 0 minutes
  - EO concentration: 640-720 mg/L
  - Maximum temperature: 52°C
  - Maximum relative humidity: 60%
  - Maximum pressure rate change: 55 mbar/min
DuPont™ Tyvek® 1073B – Coated – FFS flexible blister – EO

**Metric Units**

**Package Configuration**

FFS flexible blister

**Top Web**

DuPont™ Tyvek® 1073B
Oliver-Tolas® XHale® 10MP Coated

**Bottom Web**

500 micron PET GAG Forming Film

**Sterilization**

EO deep draw

- Number of cycles: 1
- Total time per cycle (excluding pre- and post-conditioning): 9 hours and 45 minutes
- EO exposure time per cycle: 6 hours and 0 minutes
- EO concentration: 257 mg/L
- Maximum temperature: 50°C
- Maximum relative humidity: 70%
- Maximum pressure rate change: 33 mbar/min
**DuPont™ Tyvek® 1059B – Coated – FFS flexible blister – EO**

**Metric Units**

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<tr>
<th>Package Configuration</th>
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<tbody>
<tr>
<td>FFS flexible blister</td>
<td>EO deep draw</td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td>Number of cycles: 1</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1059B</td>
<td>Total time per cycle (excluding pre- and post-conditioning): 8 hours and 30 minutes</td>
</tr>
<tr>
<td>Perfecseal® SBP2000 Coated</td>
<td>EO exposure time per cycle: 1 hours and 30 minutes</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td>EO concentration: 69 mg/L</td>
</tr>
<tr>
<td>PPC 1325-T 203 micron Forming Film</td>
<td>Maximum temperature: 60°C</td>
</tr>
<tr>
<td></td>
<td>Maximum relative humidity: 75%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: 34 mbar/min</td>
</tr>
</tbody>
</table>
**DuPont™ Tyvek® 1059B – Coated – FFS flexible blister – EO**

**Metric Units**

---

**Package Configuration**

- FFS flexible blister

**Top Web**

- DuPont™ Tyvek® 1059B
- Amcor Flexibles Inc. Coated

**Bottom Web**

- PPC 1325-TLS
- 102 micron Forming Film

---

**Sterilization**

- EO deep draw

  - Number of cycles: 2
  - Total time per cycle (excluding pre- and post-conditioning): 8–10 hours and 0 minutes
  - EO exposure time per cycle: 2 hours and 0 minutes
  - EO concentration: 370 mg/L
  - Maximum temperature: 54°C
  - Maximum relative humidity: 55%
  - Maximum pressure rate change: 51 mbar/min
### Package Configuration

**FFS rigid blister**

**Top Web**

DuPont™ Tyvek® 1059B  
Oliver-Tolas® XHale® NP34 Coated

**Bottom Web**

Pacur™ 406 micron PETG Forming Film

### Sterilization

**EO shallow draw**

- Number of cycles: 3
- Total time *per cycle* *(including pre- and post-conditioning)*: 31 hours and 0 minutes
- EO exposure time *per cycle*: 13 hours and 10 minutes
- EO concentration: 1000 mg/L
- Maximum temperature: 49°C
- Maximum relative humidity: ~88%
- Maximum pressure rate change: 45 mbar/min
DuPont™ Tyvek® 1059B – Uncoated – FFS flexible blister – EO

Metric Units

**Package Configuration**

FFS flexible blister

**Top Web**

DuPont™ Tyvek® 1059B
Rollprint Inc. Uncoated

**Bottom Web**

40 micron Nylon / 70 micron EVA Forming Film

**Sterilization**

EO deep draw

- Number of cycles: 2
- Total time *per cycle* (excluding pre- and post-conditioning): 18 hours and 30 minutes
- EO exposure time *per cycle*: 14 hours and 42 minutes
- EO concentration: 667 mg/L
- Maximum temperature: 52°C
- Maximum relative humidity: 70%
- Maximum pressure rate change: 84 mbar/min
## Dupont™ Tyvek® 1059B – Uncoated – FFS flexible blister – EO

### Metric Units

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>FFS flexible blister</td>
<td>EO deep draw</td>
</tr>
<tr>
<td></td>
<td>Number of cycles: 2</td>
</tr>
<tr>
<td></td>
<td>Total time <em>per cycle</em> (excluding pre- and post-conditioning): 8-12 hours and 0 minutes</td>
</tr>
<tr>
<td></td>
<td>EO exposure time <em>per cycle</em>: 2 hours and 0 minutes</td>
</tr>
<tr>
<td></td>
<td>EO concentration: 640 - 720 mg/L</td>
</tr>
<tr>
<td></td>
<td>Maximum temperature: 52°C</td>
</tr>
<tr>
<td></td>
<td>Maximum relative humidity: 60%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: 55 mbar/min</td>
</tr>
</tbody>
</table>

**Top Web**

- Dupont™ Tyvek® 1059B
- Perfecseal® Uncoated

**Bottom Web**

- PerfecForm® ICE® 30655-W
- 152 micron Nylon Forming Film
**DuPont™ Tyvek® 1059B – Uncoated – FFS flexible blister – EO**

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
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</thead>
<tbody>
<tr>
<td>FFS flexible blister</td>
<td><strong>EO deep draw</strong></td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td></td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1059B</td>
<td>Number of cycles: 2</td>
</tr>
<tr>
<td>Perfecseal® Uncoated</td>
<td>Total time <em>per cycle</em> (excluding pre- and post-conditioning):</td>
</tr>
<tr>
<td></td>
<td>8-10 hours and 0 minutes</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td>EO exposure time <em>per cycle</em>: 2 hours and 0 minutes</td>
</tr>
<tr>
<td>PerfecForm® ICE® 30655-EE</td>
<td>EO concentration: 370 mg/L</td>
</tr>
<tr>
<td>203 micron Nylon Forming Film</td>
<td>Maximum temperature: 54°C</td>
</tr>
<tr>
<td></td>
<td>Maximum relative humidity: 55%</td>
</tr>
<tr>
<td></td>
<td>Maximum pressure rate change: 51 mbar/min</td>
</tr>
</tbody>
</table>
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – EO

Package Configuration

Thermoformed tray with coated lid

Top Web

DuPont™ Tyvek® 1073B
Perfecseal® CR27 Coated

Bottom Web

889 micron PETG tray

Sterilization

EO deep draw

Number of cycles: 1
Total time per cycle (excluding pre- and post-conditioning): 20 hours and 5 minutes
EO exposure time per cycle: ~5 hours and 0 minutes
EO concentration: 443-512 mg/L
Maximum temperature: 57°C
Maximum relative humidity: 90%
Maximum pressure rate change: 34 mbar/min
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – EO

**Metric Units**

**Package Configuration**

Thermoformed tray with coated lid

---

**Top Web**

DuPont™ Tyvek® 1073B  
Amcor Flexibles Inc. Coated

---

**Bottom Web**

508 micron PVC tray

---

**Sterilization**

EO deep draw

Number of cycles: 1

Total time per cycle (excluding pre- and post-conditioning): 8 hours and 6 minutes

EO exposure time per cycle: ~4 hours and 30 minutes

EO concentration: 760 mg/L

Maximum temperature: 49°C

Maximum relative humidity: 75%

Maximum pressure rate change: 34 mbar/min
**DuPont® Tyvek® 1073B – Coated – Thermoformed tray – EO**

**Metric Units**

---

### Package Configuration

Thermoformed tray with coated lid

---

### Top Web

DuPont® Tyvek® 1073B  
Oliver-Tolas® XHale® 18B Coated

---

### Bottom Web

635 micron PETG tray

---

### Sterilization

EO deep draw

- Number of cycles: 3
- Total time per cycle (excluding pre- and post-conditioning): 4 hours and 15 minutes
- EO exposure time per cycle: 0 hours and 30 minutes
- EO concentration: 720-1027 mg/L
- Maximum temperature: 56°C
- Maximum relative humidity: 90%
- Maximum pressure rate change: 670 mbar/min
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – EO

Metric Units

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B  
Oliver-Tolas® SealScience® TPT-021C Coated

**Bottom Web**

635 micron PETG tray

**Sterilization**

EO shallow draw

Number of cycles: 2

Total time *per cycle* (excluding pre- and post-conditioning): 6 hours and 45 minutes

EO exposure time *per cycle*: 4 hours and 0 minutes

EO concentration: **550 mg/L**

Maximum temperature: **54°C**

Maximum relative humidity: **75%**

Maximum pressure rate change: **51 mbar/min**
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – EO

**Metric Units**

### Package Configuration

**Thermoformed tray with coated lid**

### Top Web

- DuPont™ Tyvek® 1073B
- Oliver-Tolas® XHale® 10MP Coated

### Bottom Web

- 600 micron PETG tray

### Sterilization

**EO deep draw**

- Number of cycles: 1
- Total time *per cycle* *(excluding pre- and post-conditioning)*: 6 hours and 22 minutes
- EO exposure time *per cycle*: 4-5 hours and 0 minutes
- EO concentration: **888 mg/L**
- Maximum temperature: **53°C**
- Maximum relative humidity: **80%**
- Maximum pressure rate change: **113 mbar/min**
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – EO

Metric Units

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® SBP2000 EU Coated

**Bottom Web**

700 micron PETG tray

**Sterilization**

EO shallow draw

- Number of cycles: 1
- Total time *per cycle* (excluding pre- and post-conditioning): 9 hours and 30 minutes
- EO exposure time *per cycle*: 3 hours and 0 minutes
- EO concentration: 584 mg/L
- Maximum temperature: 45°C
- Maximum relative humidity: 75%
- Maximum pressure rate change: 43 mbar/min
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – EO

Metric Units

**Package Configuration**
Thermoformed tray with coated lid

**Top Web**
DuPont™ Tyvek® 1073B
Oliver-Tolas® XHale® 18B Coated

**Bottom Web**
1000 micron PS tray

**Sterilization**
EO shallow draw
- Number of cycles: 2
- Total time per cycle (excluding pre- and post-conditioning): 6-9 hours and 0 minutes
- EO exposure time per cycle: 6-9 hours and 0 minutes
- EO concentration: 520 mg/L
- Maximum temperature: 60°C
- Maximum relative humidity: 60%
- Maximum pressure rate change: 100 mbar/min
DuPont™ Tyvek® 1073B — Coated — Thermoformed tray — EO

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® SBP2001 Coated

**Bottom Web**

762 micron HIPS tray

**Sterilization**

EO deep draw

- Number of cycles: 3
- Total time per cycle (excluding pre- and post-conditioning): 12 hours and 10 minutes
- EO exposure time per cycle: 5 hours and 30 minutes
- EO concentration: >661 mg/L
- Maximum temperature: 57°C
- Maximum relative humidity: 60%
- Maximum pressure rate change: 51 mbar/min
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – EO

Metric Units

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B
Oliver-Tolas® XHale® 18B Coated

**Bottom Web**

762 micron PS tray

**Sterilization**

EO deep draw

- Number of cycles: 1
- Total time per cycle (including pre- and post-conditioning): 22 hours and 0 minutes
- EO exposure time per cycle: ~2 hours and 0 minutes
- EO concentration: 585 mg/L
- Maximum temperature: 52°C
- Maximum relative humidity: ~100%
- Maximum pressure rate change: 62 mbar/min
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – EO

**Package Configuration**
Thermoformed tray with coated lid

**Top Web**
DuPont™ Tyvek® 1073B
Oliver-Tolas® SealScience® TPT-0260 Coated

**Bottom Web**
700 micron PETGAG tray

**Sterilization**
EO shallow draw
- Number of cycles: 2
- Total time per cycle (excluding pre- and post-conditioning): 9 hours and 30 minutes
- EO exposure time per cycle: 4 hours and 0 minutes
- EO concentration: >350 mg/L
- Maximum temperature: 55°C
- Maximum relative humidity: 65%
- Maximum pressure rate change: 40 mbar/min
**DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – EO**

**Metric Units**

<table>
<thead>
<tr>
<th><strong>Package Configuration</strong></th>
<th><strong>Sterilization</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Thermoformed tray with coated lid</td>
<td>EO deep draw</td>
</tr>
<tr>
<td>Top Web</td>
<td>Number of cycles: 3</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Total time per cycle (excluding pre- and post-conditioning): ~4 hours and 30 minutes</td>
</tr>
<tr>
<td>Oliver-Tolas® XHale® 18B Coated</td>
<td>EO exposure time per cycle: 1 hours and 15 minutes</td>
</tr>
<tr>
<td>Bottom Web</td>
<td>EO concentration: &gt;700 mg/L</td>
</tr>
<tr>
<td>762 micron PVC tray</td>
<td>Maximum temperature: 55°C</td>
</tr>
</tbody>
</table>

**Sterilization**

- EO deep draw
- Number of cycles: 3
- Total time per cycle (excluding pre- and post-conditioning): ~4 hours and 30 minutes
- EO exposure time per cycle: 1 hours and 15 minutes
- EO concentration: >700 mg/L
- Maximum temperature: 55°C
- Maximum relative humidity: 85%
- Maximum pressure rate change: 100 mbar/min
DuPont™ Tyvek® 1073B – Coated – Pouch – Gamma

**Metric Units**

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® CR27 Coated

**Bottom Web**

PerfecForm® ICE® 30652-O
102 micron Nylon Film

**Sterilization**

Gamma

Number of Exposures: 1
Minimum total dose of 21 kGy
Maximum total dose of 40 kGy
**DUPONT MEDICAL PACKAGING TRANSITION PROJECT**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chevron peel pouch</td>
<td>Gamma</td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td>Number of Exposures: 1</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Minimum total dose of 25 kGy</td>
</tr>
<tr>
<td>Perfecseal® CR27 Coated</td>
<td>Maximum total dose of 45 kGy</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td></td>
</tr>
<tr>
<td>Perfecflex® 35791-E</td>
<td></td>
</tr>
<tr>
<td>12 micron PET/38 micron PE Film</td>
<td></td>
</tr>
</tbody>
</table>
DuPont™ Tyvek® 1073B – Uncoated – Pouch – Gamma

Metric Units

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1073B
Beacon Converters® Uncoated

**Bottom Web**

Beacon Converters® A20™
12 micron PET/51 micron LDPE Film

**Sterilization**

Gamma

Number of Exposures: 2
Minimum total dose of **50 kGy**
Maximum total dose of **70 kGy**
**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1073B  
PeelMaster™ Uncoated

**Bottom Web**

PeelMaster™  
12 micron PET/51 micron LDPE Film

**Sterilization**

Gamma  
Number of Exposures: 1  
Minimum total dose of 25 kGy  
Maximum total dose of 40 kGy
DuPont™ Tyvek® 1073B – Uncoated – Pouch – Gamma

Metric Units

Package Configuration

Chevron peel pouch

Top Web

DuPont™ Tyvek® 1073B
Mangar Industries Uncoated

Bottom Web

25 micron Biax Nylon/51 micron PE Film

Sterilization

Gamma

Number of Exposures: 1
Minimum total dose of 25 kGy
Maximum total dose of 40 kGy
DuPont™ Tyvek® 1073B – Coated – FFS flexible blister – Gamma

### Package Configuration

| FFS flexible blister |

### Top Web

| DuPont™ Tyvek® 1073B  
| Perfecseal® SBP2000 Coated |

### Bottom Web

| PerfecForm® ESE 35850-MM  
| 254 micron EVA/Surlyn®/EVA Forming Film |

### Sterilization

| Gamma |

| Number of Exposures: 1  
| Minimum total dose of 25 kGy  
| Maximum total dose of 40 kGy |
**DuPont™ Tyvek® 1073B – Coated – FFS flexible blister – Gamma**

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>FFS flexible blister</td>
<td>Gamma</td>
</tr>
<tr>
<td></td>
<td>Number of Exposures: 2</td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td>Minimum total dose of 95 kGy</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Maximum total dose of 110 kGy</td>
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<tr>
<td>Perfecseal® SBP2000 Coated</td>
<td></td>
</tr>
</tbody>
</table>

**Bottom Web**

- PerfecForm® ESE 35850-O
- 102 micron EVA/Surlyn®/EVA Forming Film
**DuPont™ Tyvek® 1073B – Coated – FFS flexible blister – Gamma**

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>FFS flexible blister</td>
<td>Gamma</td>
</tr>
<tr>
<td>Top Web</td>
<td>Number of Exposures: 2</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Minimum total dose of 55 kGy</td>
</tr>
<tr>
<td>Perfecseal® CR27 Coated</td>
<td>Maximum total dose of 70 kGy</td>
</tr>
</tbody>
</table>

**Bottom Web**

Amcor Flexibles Inc.
305 micron EVA/Ionomer/EVA Forming Film
DuPont™ Tyvek® 1059B – Coated – FFS flexible blister – Gamma

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
</tr>
</thead>
<tbody>
<tr>
<td>FFS flexible blister</td>
</tr>
</tbody>
</table>

**Top Web**

DuPont™ Tyvek® 1059B
Perfecseal® SBP2000 Coated

**Bottom Web**

Amcor Flexibles Inc.
254 micron Coex Metalloocene Forming Film

**Sterilization**

Gamma

Number of Exposures: 1
Minimum total dose of 25 kGy
Maximum total dose of 40 kGy
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Gamma

Metric Units

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B
Oliver-Tolas® XHale® 10MP Coated

**Bottom Web**

800 micron PETG tray

**Sterilization**

Gamma

Number of Exposures: 2
Minimum total dose of 54 kGy
Maximum total dose of 72 kGy
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Gamma

Metric Units

Package Configuration
Thermoformed tray with coated lid

Top Web
DuPont™ Tyvek® 1073B
Perfecseal® CR27 Coated

Bottom Web
1270 micron PETG tray

Sterilization
Gamma
Number of Exposures: 1
Minimum total dose of 25 kGy
Maximum total dose of 45 kGy
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Gamma

Metric Units

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B
Amcor Flexibles Inc. Coated

**Bottom Web**

1016 micron PETG tray

**Sterilization**

Gamma

Number of Exposures: 2
Minimum total dose of 50 kGy
Maximum total dose of 80 kGy
**DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Gamma**

**Metric Units**

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B Amcor Flexibles Inc. Coated

**Bottom Web**

508 micron PETG tray

**Sterilization**

Gamma

Number of Exposures: 1
Minimum total dose of 21 kGy
Maximum total dose of 40 kGy
**DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Gamma**

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B  
Perfecseal® HCW CR27 Coated

**Bottom Web**

1016 micron PETG tray

**Sterilization**

Gamma  
Number of Exposures: 1  
Minimum total dose of 25 kGy  
Maximum total dose of 40 kGy
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Gamma

Metric Units

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® HCW CR27 Coated

**Bottom Web**

1016 micron PETG tray

**Sterilization**

Gamma

Number of Exposures: Cumulative
Minimum total dose of 100 kGy
Maximum total dose of 133 kGy
**DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Gamma**

**Metric Units**

<table>
<thead>
<tr>
<th><strong>Package Configuration</strong></th>
<th><strong>Sterilization</strong></th>
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</thead>
<tbody>
<tr>
<td>Thermoformed tray with coated lid</td>
<td>Gamma</td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td>Number of Exposures: 1</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Minimum total dose of 50 kGy</td>
</tr>
<tr>
<td>Oliver-Tolas® XHale® 18B Coated</td>
<td>Maximum total dose of 80 kGy</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td></td>
</tr>
<tr>
<td>635 micron PETG tray</td>
<td></td>
</tr>
</tbody>
</table>
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Gamma

Metric Units

Package Configuration
Thermoformed tray with coated lid

Top Web
DuPont™ Tyvek® 1073B
Oliver-Tolas® SealScience® TPT-0260 Coated

Bottom Web
640 micron PETG tray

Sterilization
Gamma
Number of Exposures: 1
Minimum total dose of 43 kGy
Maximum total dose of 55 kGy
DuPont™ Tyvek® 1073B – Uncoated – Pouch – Electron-beam

Metric Units

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chevron peel pouch</td>
<td>Electron-beam</td>
</tr>
</tbody>
</table>

**Top Web**

DuPont™ Tyvek® 1073B
Beacon Converters® Uncoated

**Bottom Web**

Beacon Converters® A23™
23 micron PET/51 micron LDPE Film

Number of Exposures: 1
Minimum total dose of 28 kGy
Maximum total dose of 42 kGy
DuPont™ Tyvek® 1073B – Uncoated – Pouch – Electron-beam

Metric Units

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1073B  
Mangar Industries Uncoated

**Bottom Web**

25 micron Biax Nylon/51 micron PE Film

**Sterilization**

Electron-beam  
Number of Exposures: 1  
Minimum total dose of 25 kGy  
Maximum total dose of 65 kGy
**DUPONT MEDICAL PACKAGING TRANSITION PROJECT**

---

**DuPont™ Tyvek® 1073B – Coated – FFS rigid blister – Electron-beam**

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
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</thead>
<tbody>
<tr>
<td>FFS rigid blister</td>
<td>Electron-beam</td>
</tr>
<tr>
<td><strong>Top Web</strong></td>
<td>Number of Exposures: 1</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Minimum total dose of 26 kGy</td>
</tr>
<tr>
<td>Oliver-Tolas® XHale® 18B Coated</td>
<td>Maximum total dose of 50 kGy</td>
</tr>
<tr>
<td><strong>Bottom Web</strong></td>
<td></td>
</tr>
<tr>
<td>1016 micron HIPS Forming Film</td>
<td></td>
</tr>
</tbody>
</table>

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DuPont™ Tyvek® 1073B – Coated – FFS flexible blister – Electron-beam

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
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<tbody>
<tr>
<td>FFS flexible blister</td>
<td>Electron-beam</td>
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<tr>
<td></td>
<td>Number of Exposures: 1</td>
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<tr>
<td></td>
<td>Minimum total dose of 18 kGy</td>
</tr>
<tr>
<td></td>
<td>Maximum total dose of 45 kGy</td>
</tr>
</tbody>
</table>

**Top Web**

DuPont™ Tyvek® 1073B  
Perfecseal® CR27 Coated

**Bottom Web**

Amcor Flexibles Inc.  
254 micron Ionomer/ULDPE/EVA Forming Film
DuPont™ Tyvek® 1059B – Coated – FFS flexible blister – Electron-beam

Metric Units

**Package Configuration**

FFS flexible blister

**Top Web**

DuPont™ Tyvek® 1059B
Perfecseal® SBP2000 Coated

**Bottom Web**

Amcor Flexibles Inc.
254 micron Coex Metallocene Forming Film

**Sterilization**

Electron-beam

- Number of Exposures: 1
- Minimum total dose of 21 kGy
- Maximum total dose of 51 kGy
DuPont™ Tyvek® 1073B – Uncoated – Weld seal bag – Steam

Metric Units

**Package Configuration**

Weld seal bag

**Top Web**

DuPont™ Tyvek® 1073B
Oliver-Tolas® Uncoated

**Bottom Web**

Oliver-Tolas® TPF-0545A
76 micron HDPE Film

**Sterilization**

Steam

Number of cycles: 1
Total time *per cycle*: 2 hours and 0 minutes
Steam exposure time *per cycle*: ~0 hours and 30 minutes
Maximum temperature: ~123°C
Maximum pressure: 1239 mbarA
DuPont™ Tyvek® 1073B – Uncoated – Pouch – Steam

Metric Units

**Package Configuration**

Chevron peel pouch

**Top Web**

DuPont™ Tyvek® 1073B
Oliver-Tolas® Uncoated

**Bottom Web**

Oliver-Tolas® TPF-0563B
12 micron PET/
51 micron Polyolefin Peelable Sealant Film

**Sterilization**

Steam

- Number of cycles: 1
- Total time *per cycle*: 2 hours and 0 minutes
- Steam exposure time *per cycle*: ~0 hours and 30 minutes
- Maximum temperature: ~123°C
- Maximum pressure: 1239 mbarA
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Steam

**Metric Units**

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B
Oliver-Tolas® Osurance® Zone Coated

**Bottom Web**

508 micron PC tray

**Sterilization**

Steam

- Number of cycles: 3
- Total time *per cycle*: 3 hours and 0 minutes
- Steam exposure time *per cycle*: ~0 hours and 45 minutes
- Maximum temperature: ~125°C
- Maximum pressure: 2339 mbarA
### DUPONT MEDICAL PACKAGING TRANSITION PROJECT

**DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Steam**

**Metric Units**

<table>
<thead>
<tr>
<th>Package Configuration</th>
<th>Sterilization</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thermoformed tray with coated lid</td>
<td>Steam</td>
</tr>
<tr>
<td>Top Web</td>
<td>Number of cycles: 1</td>
</tr>
<tr>
<td>DuPont™ Tyvek® 1073B</td>
<td>Total time <em>per cycle</em>: 1 hours and 30 minutes</td>
</tr>
<tr>
<td>Oliver-Tolas® XHale® 24AL Coated</td>
<td>Steam exposure time <em>per cycle</em>: 0 hours and 30 minutes</td>
</tr>
<tr>
<td>Bottom Web</td>
<td>Maximum temperature: 122°C</td>
</tr>
<tr>
<td>635 micron PC tray</td>
<td>Maximum pressure: 2200 mbarA</td>
</tr>
</tbody>
</table>
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Steam

Metric Units

Package Configuration
Thermoformed tray with coated lid

Top Web
DuPont™ Tyvek® 1073B
Oliver-Tolas® Osurance® 24AL Coated

Bottom Web
762 micron PC tray

Sterilization
Steam

Number of cycles: 3
Total time per cycle: ~2 hours and 1 minutes
Steam exposure time per cycle: ~0 hours and 46 minutes
Maximum temperature: ~123°C
Maximum pressure: 2202 mbarA
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Dry Heat

Metric Units

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B
Oliver-Tolas® Osurance® Zone Coated

**Bottom Web**

762 micron PC tray

**Sterilization**

Dry Heat

Number of cycles: 1

Total time *per cycle*: 36 hours and 0 minutes

Dry Heat exposure time *per cycle*: 34 hours and 0 minutes

Maximum temperature: 122°C
DuPont™ Tyvek® 1073B – Coated – Pouch – Low Temperature Oxidative

Metric Units

**Package Configuration**

<table>
<thead>
<tr>
<th>Top Web</th>
<th>Bottom Web</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chevron peel pouch</td>
<td>12 micron PET/50 micron PE Film</td>
</tr>
</tbody>
</table>

**Sterilization**

- Low temperature oxidative sterilization ($\text{H}_2\text{O}_2$)
  - Number of cycles: 2
  - Total time *per cycle*: ~3 hours and 10 minutes
  - $\text{H}_2\text{O}_2$ exposure time *per cycle*: ~1 hours and 2 minutes
  - Sterilant concentration: 59%
  - Maximum temperature: ~65°C
DuPont™ Tyvek® 1073B – Coated – Thermoformed tray – Low Temperature Oxidative Sterilization

**Package Configuration**

Thermoformed tray with coated lid

**Top Web**

DuPont™ Tyvek® 1073B
Perfecseal® HCW CR27 Coated

**Bottom Web**

1016 micron PETG tray

**Sterilization**

Low temperature oxidative sterilization (C$_2$H$_4$O$_3$)

- Number of cycles: 2
- Total time per cycle: ~3 hours and 15 minutes
- C$_2$H$_4$O$_3$ exposure time per cycle: ~2 hours and 0 minutes
- Sterilant concentration: 5%
- Maximum temperature: 55°C