

# **ASHRAE Design Guide For Cleanrooms**

## Notes to Subcommittee Members:

1. The second draft of the "Table of Contents" shows a preliminary coverage of possible topics. The Contents and coverage will be subject to revising for continuous improvements by the authors, contributors and reviewers during the writing, editing, review and refinement processes.
2. A few modifications have been made from Draft 1 to reflect valuable suggestions from committee members: Each Section will have its own Bibliography List to allow readers in searching for related references only. Sustainability-related topics have been merged into a separate Chapter called "Cleanroom Design for Sustainability".
3. Book volume will be between 120,000-150,000 words, "Estimated Words" is tentatively assigned behind each Section title to allow authors to control the sizes of their respective Sections/Chapters to ensure the book properly structured and well balanced. Larger cleanroom market sectors will relatively have more coverage.

## **Table of Contents**

(Second Draft by W. Sun. 8/30/2008)

## **PREFACE**

## **ACKNOWLEDGEMENTS**

## **SECTION 1 – CLEANROOM FUNDAMENTALS** (18-22K words)

### **Chapter X Introduction**

- Cleanrooms and Clean Zones
- International Standards for Cleanroom Design
- Classification of Cleanrooms
- Class Required by Various Industries
- Cleanroom Airflow
- Sources of Contaminants Inside Cleanrooms
- Effect of Human Interference

### **Chapter X Airborne Particulate Contaminants**

- Properties of Airborne Particles
- Dispersion of Airborne Contaminants
- Particle Size Distribution
- Contamination Risks and Assessment
- Sampling Techniques
- Particle Counters
- Filtration Mechanisms
  - Fibrous Filters
  - Membrane Filters
- Type and Construction of High Efficiency Filters
- Testing of High Efficiency Filters
- Airborne Ultrafine Particles and Measurement
- Airborne Macroparticles and Measurement
- Statistical Analysis

### **Chapter X Surface Particulate Contaminants**

- Surface Particle Deposition
- Particle Adhesion to Surfaces
- Rate of Deposition of Non-volatile Residue (NVR)
- Particle Deposition Velocity
- Surface Particle Measurement
- Particle Identification and Electron Microscopy Scanning

Product Cleanliness Levels  
Surface Cleaning

**Chapter X Airborne Molecular Contamination**

Typical Contaminants  
Outgassed Organic Compounds from Cleanroom Materials and Components  
Classification  
Parameters for Consideration  
Measurement, Testing and Compliance

**Chapter X Liquidborne Contaminants**

Particles in Process Liquids  
Liquid-borne Particle Counters  
Liquid Filtration

**Chapter X Microbial Contaminations**

Principles of Bio-contamination Control  
Determine Airborne Bio-contamination Through Sampling  
Sampling Devices  
Evaluation and Expression of Sampling Data  
Determine Surface Bio-contamination  
Determine Bio-contamination in Liquids  
Cleaning and Disinfection

**Bibliography**

**SECTION 2 – CLEANROOM DESIGN AND ENVIRONMENTAL CONTROL SYSTEMS** (30-36K words)

**Chapter X Basic Requirements and Planning**

Contamination Control and Cleanliness Requirements  
Site Selection and Services Requirement  
Building Configurations and Plans  
Critical Flow Arrangements-Personnel, Material, Product and Waste  
Architectural and Structural Considerations  
Indoor Environmental Quality and Requirements  
Outdoor Emission Requirement  
Life Safety  
Security and Access Control  
Regulations  
Project Size, Scope, Budget and Schedule

**Chapter X Design Considerations**

Architectural Layout  
Airflow Patterns

- Unidirectional Flow
- Non-unidirectional Flow
- Mixed Flow

Air Patterns Effectiveness and Computer-Aided Flow Modeling  
Indoor Design Conditions  
Makeup Air  
Process Exhaust  
Filtration Systems  
Cooling and Heating Loads  
Determination of Required Room Air Change Rate and Air Velocity and Modeling  
Basic Primary, Secondary and Tertiary HVAC System Configurations

- Single Makeup System without Return Air
- Single Makeup System with Return Air
- Single Makeup System with Recirculating Fan
- Single Makeup System with Recirculating AHU System
- Single Makeup System with Recirculating Fan and Recirculating AHU System

Primary, Secondary and Tertiary System Variations, Psychrometric Analysis and Selection

Airflow Direction Control Between Rooms

- Room Pressure Differential Criteria
- Pressurization Systems and Design Basics
- Single Room Pressurization Methods
- Multiple-Room (Suite) Pressurization
- Pressurization Controls

Airlock Selections and Utilizations

Application of Mini-Environments

- Contamination Control Concepts
- Filtration and Airflow Management
- Environmental Control and Monitoring
- External and Facility Support

Applications of Other Separative and Transfer Devices

Submicron Contamination and Design Practices

Microorganisms (Viabiles) and Control Considerations

Fire Safety

Electrostatic Charge and Grounding

Cleanroom Lighting

Electrical Systems

Communication Systems

Noise and Vibration Controls

Sizing and Redundancy

#### **Chapter X Utility Services for Process**

Environmental, Health and Safety (EHS) Considerations

Dry Clean Compressed Air

Fume Exhaust and Scrubber System

Solvent System

Drain Waste Neutralization System

House Vacuum System

Process Cooling Water

Ultra-Pure Water System

Clean Steam System

Production and Transmission of High Purity Gases

Waste Gas Abatement Systems

Control of Volatile Organic Compounds

Fire Protection

#### **Chapter X Cleanroom Design for Sustainability**

Considerations for Sustainability

Energy Conservation & Cost-Saving Concepts

Energy Utilizations, Balance and Modeling

#### **Chapter X Cleanroom Construction**

Layout and Approval of Installations

Construction Materials and Surface Finishes

Integration in Design and Construction

#### **Bibliography**

### **SECTION 3 – TESTING, CERTIFICATION, COMMISSIONING AND QUALIFICATION** (12-16K words)

#### **Chapter X Cleanroom Testing, Certification & Commissioning**

Cleanroom Testing Standards

Testing Based on Occupancy States

- As-built
- At-rest
- Operational

Typical Cleanroom Testing Equipment and Instrumentation

Required (Basic) Test - Airborne Particle Counts for Classifications

Optional (Additional) Tests

- Airborne Particle Counts for Ultrafine Particles
- Airborne Particle Counts for Macroparticles
- Airflow Volume, Velocity and Uniformity
- Air Pressure Differences
- Installed Filter System Leakage
- Airflow Direction and Visualization
- Temperature, Humidity and Uniformities
- Electrostatic and Ion Generator
- Particle Surface Deposition
- Recovery
- Containment Leak
- Conductivity
- Airborne Microbial Counts
- Surface Microbial Counts
- Lighting Level and Uniformity
- Noise and Vibration Levels

Cleanroom Commissioning

## **Chapter X Cleanroom Qualifications**

Regulatory Validation Requirements

Various Qualification Protocols and Plans

## **Bibliography**

### **SECTION 4 – CLEANROOM OPERATIONS** (6-7K words)

#### **Chapter X Operation General Requirements**

Contamination (Particulate and Microbial) Control in Operation

Cleanroom Disciplines

Personnel Hygiene, Practices and Garments (Clothing, Masks, Gloves, and etc.)

Materials, Equipment and Machinery

Entry/Exit of Personnel, Material, Product and Waste

Cleaning and Decontamination

#### **Chapter X Methods for Verifying Cleanliness**

Ultraviolet Light

High Illuminance Oblique White Light

Continuous Flowing Duct Method

Reservoir Method

Contact Plate for Flat Surfaces

Swab for Non-Flat Surfaces

## **Bibliography**

### **SECTION 5 - CLEANROOMS IN SEMICONDUCTOR & MICROELECTRONIC FACILITIES** (15-18K words)

#### **Chapter X General Considerations**

Design Considerations for Semiconductor and Microelectronic Cleanrooms

Design Criteria and Indoor Air Quality

Filtration and Equipment

Environmental, Health and Safety & Risk Assessment

#### **Chapter X Design for Fabrication, Process and Manufacturing**

Semiconductor FAB Facilities

Microelectronic Product Manufacturing Facilities

Nanotech Facilities

Facility Planning and Architectural Plan

Typical Process Diagrams  
Spaces Configurations  
Airflow Arrangement in Semiconductor and Microelectronic Cleanrooms  
Particle Emissions from Equipment and Process  
Room Air Ionization  
Treatment of Airborne Molecular Contamination  
Design Considerations of Micro-vibration and Noise  
ESD Controls in Cleanroom Environments  
Off-Wafer Measurement of Contaminants  
On-Wafer Measurement of Particles and Molecular Contaminants  
Deposition of Molecular Contaminants in Gaseous Environments  
Organic Contamination Removal  
Gases and Chemicals

## **Bibliography**

### **SECTION 6 - CLEANROOM IN PHARMACEUTICAL AND MEDICAL DEVICES FACILITIES** (15-18K words)

#### **Chapter X General Considerations**

Design Considerations for Pharmaceutical Cleanrooms  
Current Good Manufacturing Practices (cGMP)  
Facility Planning and Architectural Plan  
Building Code Compliance  
Pharmaceutical Process Flow  
Mechanical Utilities and High Purity Water and Steam  
Containment/Isolation  
Environmental, Health and Safety & Risk Assessment

#### **Chapter X Design for Facilities**

Oral Solid Dosage Facilities  
Sterile Manufacturing Facilities  
API Facilities  
Lab Facilities  
Packaging Facilities  
Medical Devices Facilities  
Controls, Monitoring and Alarms

#### **Chapter X Qualifications**

Validations  
Qualification Plan and Acceptance Criteria  
GMP-Compliant Qualification Protocols

- Installation Qualification (IQ)
- Operational Qualification (OQ)
- Performance Qualification (PQ)

## **Bibliography**

### **SECTION 7 – CLEANROOMS IN HEALTHCARE & BIO-TECH FACILITIES** (10-12K words)

#### **Chapter X General Requirements**

Healthcare Facilities Design Guidelines and Standards  
Major Airborne Pathogens  
Infection Control Risk Assessment (ICRA)  
Airborne and Surface Microbial Contaminations  
Control of Particle and Microbiological Contaminations

- Sterilization
- Disinfection
- Radiation/UV Treatment
- Filtration

Architectural and Design Considerations  
Ventilation, Room Pressure and Filtration Requirements  
Certification and Qualifications

**Chapter X Cleanroom Technologies in Airborne Infection Control Spaces**

Operating Room  
Infection Isolation Room  
Protective Environment  
Critical-Care Room  
Pharmacy  
Bio-safety Labs  
Bio-tech Facilities

**Bibliography**

**SECTION 8 – CLEANROOMS IN AEROSPACE, OPTICAL, AUTOMOTIVE, FOOD PROCESSING & OTHER INDUSTRIES** (10-14K words)

**Chapter X Cleanrooms in Aerospace Industries**

**Chapter X Cleanrooms in Optical Devices Industries**

**Chapter X Cleanrooms in Automotive Industries**

**Chapter X Cleanrooms in Food Processing Industries**

**Chapter X Other Cleanroom Applications**

**Bibliography**

**TERMINOLOGY** (3-4K words)