

ASEPTIC FILTER VENT VALVE AND PORT FOR INTEGRITY TESTING

This application claims priority of U.S. Provisional Application Serial No. 62/097,761 filed December 30, 2014, the disclosure of which is incorporated herein by
5 reference.

Field of the Disclosure

The present disclosure generally relates to filtration of gas and liquid media. In particular, the present disclosure relates to a filtration device comprising an integrated
10 aseptic valve and port for integrity testing.

BACKGROUND

High purity filtration of aqueous media, such as in the fields of biotechnology, chemistry, electronics, pharmaceuticals, and the food and beverage industries requires
15 the use of sophisticated filter modules that are not only capable of a high degree of separation, but that will tend to prevent contamination of the environment, of the medium to be filtered, and of the resulting filtrate. This is designed to prevent unwanted, often dangerous organisms, such as bacteria or viruses, as well as environmental contaminants, such as dust, dirt, and the like from entering into the process stream and
20 end product. Similarly, filter capsules help to prevent contamination of a highly validated clean room due to exposure from the contents of the process stream. To ensure sterility, it would be desirable to have a completely sealed system. However this is not always possible with the processes that take place in production.

To ensure sterility of the filtrate, filter modules must maintain their integrity
25 throughout the filtration process. Accordingly, integrity testing of sterilizing filters is a fundamental requirement of critical process filtration applications in the pharmaceutical industry. General guidelines require integrity testing of filter modules after filtration, and recommend integrity testing of filter modules prior to use. Typically this testing is initially
30 performed after sterilization to ensure that the filter is not damaged; accordingly, care must be taken to ensure that sterility of the filter, and thus the filtrate, is not compromised.

Post-processing, the filter integrity test may be performed again either *in situ* or separated from the assembly and tested in a separate room to determine whether the filter was compromised during use. This information can be used to alert operators to a potential problem immediately after processing, and to quickly take corrective action. Further, FDA
5 guidelines require that integrity testing documentation be included with batch product records.

There are a variety of methods of integrity testing, including the diffusion test and the pressure hold test. The diffusion test measures the rate of gas transfer through a filter
10 to be tested. At differential gas pressures below the bubble point, gas molecules migrate through water-filled pores of a wetted membrane following Fick's Law of Diffusion. The gas diffusional flow rate for a filter is proportional to the differential pressure and the total surface area of the filter. At a pressure approximately 80% of the minimum bubble point, the gas which diffuses through the filter membrane can be measured to determine a filter's
15 integrity. A diffusional flow reading exceeding a value stated by the manufacturer indicates a variety of problems, including an incorrect temperature, wrong pore size, incompletely wetted membrane, non-integral membrane or seal, or inadequate stabilization time. The pressure hold test, also known as the pressure decay or pressure drop test, is a variation of the diffusion test. In this test, a highly accurate gauge is used
20 to monitor upstream pressure changes due to gas diffusion through the filter. Because there is no need to measure gas flow downstream of the filter, any risk to downstream sterility is eliminated.

Typically, integrity testing is performed with specialized integrity testing hardware.
25 Examples include the Integritest® 4 Series Automated Filter Integrity Test Instrument (commercially available from EMD Millipore Corporation) and the Sartocheck® line of filter integrity testing systems (commercially available from Sartorius Corporation). To perform integrity testing of a filter module installed in an assembly, an end user would attach the integrity testing hardware to a secondary aseptic connection located upstream of the filter capsule. To ensure that no contaminants are introduced, the secondary aseptic
30 connection may comprise a Lynx ST Valve (commercially available from EMD Millipore

Corporation) and an aseptic phobic filter between the capsule filter and the integrity testing equipment. Using clamps or other means, the end user isolates the desired integrity testing flow path from other components of the assembly and activates the integrity testing equipment, which performs the integrity test and provides the result.

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However, integrity testing is sensitive to a variety of factors related to the composition and complexity of an assembly. A typical flow path for integrity testing on an assembly may include various tubing, flex points, T-connections, gaskets, and other components between the integrity test hardware and a filter capsule. Integrity testing may stress these components, leading to false integrity test failures that are a result of loose connections or compression. Thus, it may not be clear whether the integrity test is testing the filter or the isolated flow path. Further, including new connections to support integrity testing hardware presents new failure points and increases the complexity of the system. Moreover, attaching integrity testing hardware to components downstream of the filter increases the likelihood of contamination.

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In light of the above, a need exists for an improved device, system, and method for performing integrity testing of filter assemblies.

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SUMMARY

The problems of the prior art are addressed by a novel design for a filter capsule containing a filter element. The filter capsule includes an integrity test assembly comprising an aseptic port and valve on the upstream side of the capsule that can be used to perform an integrity test of an internal filter element. In this way, integrity testing is performed as close as possible to the filter element, and problems associated with performing integrity testing farther upstream or downstream of the filter are minimized or eliminated. Further, the integrity test assembly is an aseptic connection that can withstand multiple actuations without compromising sterility.

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In one embodiment, a filter capsule that supports direct integrity testing of an internal filter element includes a filter housing having an inlet port, an outlet port spaced

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from the inlet port, a passage or housing volume between the inlet port and the outlet port and containing a filter element. The filter capsule further includes a vent assembly and an integrity test assembly. In some embodiments, the vent assembly and integrity test assembly present an aseptic connection. In certain embodiments, the integrity test
5 assembly further comprises a body having a bore formed through at least a portion of its interior and having a cam slot. A movable plunger contained within the bore includes a cam contained within the cam slot and an actuator such as a handle to move the plunger between a closed position and an open position. One or more seals are located between the plunger and the bore to form a fluid tight seal. In certain embodiments, there are
10 multiple seals, including a shut-off seal, an outside seal, and a sterility seal.

In certain embodiments, a disposable or single use filtration assembly includes an integrity testing device, a source of fluid to be processed, a holding container, and a filtration device. The filtration device includes an inlet port in fluid communication with
15 said source of fluid and an outlet port in fluid communication with said holding container. The filtration device further includes a filter element, an aseptic vent port, and an aseptic integrity test assembly. In some embodiments, the integrity test assembly includes a body having a bore formed through a portion of its interior, a plunger within the bore, an actuator such as a handle to move the plunger between a closed position and an open
20 position. The integrity test assembly further includes a shut-off seal, an outside seal, and a sterility seal. Integrity testing of the filtration device and filter element may be performed by attaching the integrity testing hardware to the integrity test assembly and then actuating the integrity test assembly.

25 In yet another embodiment, a method for performing an integrity test of a filter element via a port of a filter capsule includes attaching a gas line to an integrity test assembly on a filter capsule, pressuring the filter capsule, measuring a resulting pressure change, and determining whether the pressure change indicates that a filter contained within the filter capsule has been compromised. In one embodiment, the pressure change
30 is measured downstream of the filter element; in certain embodiments, the pressure change is measured upstream.

BRIEF DESCRIPTION OF THE DRAWINGS

For a better understanding of the present disclosure, reference is made to the accompanying drawings, which are incorporated herein by reference and in which:

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FIG. 1 is a diagram of a filtration assembly;

FIG. 2 is a cross-sectional view of a filter capsule;

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FIG. 3 is a side view of a filter capsule according to an embodiment of the disclosure;

FIGS. 4A-B are perspective views of an inlet housing including an integrity test assembly;

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FIGS. 5A-B are perspective views of an outlet end cap including a vent port;

FIG. 6 is a cross-sectional view of the filter capsule of FIG. 3;

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FIG. 7 is a cross-sectional view of an integrity test assembly according to the disclosure in the closed position;

FIG. 8 is a cross-sectional view of an integrity test assembly according to the disclosure in the open position;

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FIGS. 9A-C are side views of the exterior of an integrity test assembly as it transitions from an open position to a closed position;

FIG. 10A-B are perspectives views of the body and plunger of the integrity test assembly of FIGS. 7-8; and

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FIG. 11 is a cross-sectional view of the integrity test assembly of FIGS. 7-8; and

FIG. 12 is a cross-sectional view of an integrity test assembly according to another embodiment of the disclosure.

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DETAILED DESCRIPTION

FIG. 1 illustrates an example of a filtration assembly **10** for aseptically processing a fluid solution. The filtration assembly **10** may either be disposable (i.e., single use) or reusable. The filtration assembly **10** includes a secure sterile connection **12** for attachment to a container holding a solution to be processed. Once the sterile connection **12** is actuated, solution flows through tubing **14** or the like to a filter capsule **16**. In this example, the filter capsule **16** contains a sterilizing filter that effectively removes viruses, bacteria, and any other contaminants from the solution. For example, the filter capsule **16** may be an Opticap disposable capsule sterilizing filter, commercially available from EMD Millipore Corporation. Excess gas and liquid may be vented or sampled through vent valves **18** on the filter capsule, and stored in a venting container such as bag **20**. Filtrate then proceeds to a sterile holding container such as bag **22**. The filtrate may also be sampled by a sampling container such as bag **24**. Finally, filtrate proceeds to a dosing loop **26** for a pump (not shown), such as a peristaltic pump, and to a final connection **28**. The final connection **28** may be surrounded by a protective bag **29**, which helps to ensure that the final connection **28** does not become contaminated prior to being transferred to a sterile filling area for further processing.

As noted above, to ensure sterility of the final filtered product, sterilizing filters must be integrity tested after processing. In one example, to perform an integrity test of the filter capsule **16**, a gas line **30** is positioned in fluid communication with the tubing **14** upstream of the filter capsule **16** through a secondary aseptic connection **32**. To ensure sterility, the secondary aseptic connection **32** may include an aseptic phobic filter and a Lynx ST valve (commercially available from EMD Millipore Corporation) or the like. A measurement device is then positioned upstream of the gas line **30**, a bag **34** is placed

downstream of the filter to capture excess air, gas, and liquid, and a desired flow path starting from gas line **30**, to the filter capsule **16**, and ending at the bag **34** is isolated using clamps or other means. The gas line **30** is activated and deactivated after a period of time, and a decay in pressure over time is measured by the measurement device. The resulting data is compared to known acceptable values for the filter element contained within the filter capsule **16**. If the integrity test indicates that the filter element has not been compromised, then it can be safely assumed that the filtrate to be dispensed by the final connection **28** is sterile.

Conventional filter capsules, and in particular the vent ports, are prone to issues. FIG. 2 provides a cross-sectional view of the filter capsule **16** of FIG. 1. The filter capsule **16** comprises a housing **36** having an inlet port **42** and an outlet port **44** spaced from the inlet port **42**. Within the housing **36** is a housing volume comprising a passage running longitudinally between the inlet port **42** and outlet port **44**. A filter element **40** is housed within the housing volume and is sealed to the outlet port **44**, such that a fluid entering the inlet port **42** must pass through the filter element **40** before exiting the outlet port **44**, thus filtering and sterilizing the fluid downstream of the filter capsule **16**. Excess gas and fluid may be vented or sampled through either of vent valves **18**, each of which includes two seals, an exterior seal **48** and an interior seal **49**, to prevent external contamination. However, the vent valves **18** are not intended for multiple actuations, and may break after repeated use. The vent valves **18** are also prone to accidental contact with exterior surfaces, and may thus become contaminated. For example, contact with exterior surfaces may lead to contamination of the exterior seal **48**. As the vent valve **18** is actuated, the exterior seal **48** rides within the body of the vent valve **18** and contaminates the interior surface, potentially leading to contamination of the interior seal **49**. Contamination of the interior seal **49** leads to contamination of the filter environment and process stream. Contact with exterior surfaces may also cause the vent valve **18** to break if sufficient force is encountered.

FIG. 3 illustrates a filter capsule **50** according to one embodiment of the present disclosure. The filter capsule **50** comprises a housing **52**, inlet housing **54** with an inlet

port **56**, outlet end cap **58** with an outlet port **60**, and a vent assembly **62**. In certain embodiments, the housing **52** is generally cylindrical to prevent an uneven distribution of pressure within. In use, the inlet port **56** and outlet port **60** are connected to a filtration assembly (such as that shown in FIG. 1) and used to filter the product from a fluid container to remove viruses, bacteria, or other contaminants, for example. The vent assembly **62** may be used to vent the filter capsule or sample the fluid therein. In some embodiments, the vent assembly **62** is aseptic. Further, in certain embodiments, the housing **52** is formed from molded plastic. However, in other embodiments, stainless steel may be used.

In this embodiment, the outlet end cap **58** is thermally sealed to the housing **52**. However, in certain embodiments, the outlet end cap **58** and housing **52** may comprise a single component. Similarly, in this embodiment, the inlet housing **54** is molded together with the housing **52**; however, in certain embodiments, the inlet housing **54** and housing **52** may be separately formed and then bonded together. Various combinations are possible within the scope of the disclosure. Further, while the filter element **40** of this embodiment is heat sealed to the outlet end cap **58**, in certain embodiments the filter element **40** may be a removable and replaceable element. Still other embodiments include housings **52** comprising steel or other materials that allow for a reusable, as opposed to a single-use, filter capsule **50**.

In comparison to the filter capsule **16** of FIGS. 1-2, the filter capsule **50** may include several additional components. In certain embodiments, the housing **52** includes feet **64** connected to the housing near the inlet housing **54** and outlet end cap **58**. Each foot **64** can function as a resting point for the filter capsule **50** when it is placed horizontally on a surface, thus stabilizing the filter capsule **50** and preventing accidental or unwanted movement. In this embodiment, the feet **64** comprise a looped member and therefore may also be used to fasten or otherwise secure the filter capsule **50** within an assembly. The filter capsule **50** may also include a handle **66** at each end of the housing **52**, which can be used for manipulating and transporting the filter capsule **50** but also protects the

filter capsule and ports from accidental contact with exterior surfaces, thus helping to prevent contamination.

Additionally, in certain embodiments, the filter capsule **50** includes an integrity test assembly **100** formed in the inlet housing **54** near the inlet port **56**. Like the vent assembly **62**, the integrity test assembly **100** can be used for venting and sampling the contents of the filter capsule **50** prior to filtration. Further, the integrity test assembly **100** may be used as a direct aseptic connection that facilitates a variety of integrity test methods, such as air/water diffusion, bubble point, and/or water intrusion tests. When actuated to an open position, the integrity test assembly **100** may be connected to integrity testing hardware, such as a gas line. When the integrity test is complete, the integrity test assembly **100** may then be closed and the hardware removed, without impacting sterility of the product within. Thus, the integrity test assembly **100** provides a direct aseptic connection to a filter capsule that can be leveraged for integrity testing, venting, or sampling. Further, the integrity test assembly **100** reduces the integrity testing flow path to nearly zero by providing an aseptic connection directly to the filter element **40** itself.

In this embodiment, the integrity test assembly **100** is formed as a part of the inlet housing **54**. Thus, the integrity test assembly **100** is an integral component of the filter capsule **50**. Attempting to remove the integrity test assembly **100** from the filter capsule **50** will irreversibly damage or contaminate the filter capsule **50**, thus rendering the filter capsule **50** unsuitable for use within a filtration assembly. However, in certain embodiments, the integrity test assembly **100** may be removable.

FIGS. 4A-B illustrate an embodiment of an inlet housing **54** of the filter capsule **50** in further detail. In these views, only the inlet housing **54** containing the inlet port **56**, integrity test assembly **100**, foot **64**, and handle **66** is shown. While this view shows the inlet housing **54** separate from the housing **52**, in this embodiment the inlet housing **54** and housing **52** are comprised of a single component. However, in certain embodiments, the inlet housing **54** may be a separately formed and removable component.

As shown in FIG. 4A, the handle **66** is connected to each side of the filter capsule **50**. The handle **66** serves several purposes. For example, the handle **66** can be used to manipulate or install the filter capsule **50** in a filtration assembly (such as the assembly of FIG. 1) without accidental contact with the integrity test assembly **100**, thus helping to maintain sterility. The handle **66** also protects the integrity test assembly **100** from accidental contact with outside components, or if the filter capsule **50** is inadvertently dropped. Further, the handle **66** can also be used as a foot to support the filter capsule **50** when the filter capsule **50** is placed horizontally. For example, if the filter capsule **50** is placed on its side or is knocked over when initially standing on its feet **64**, the filter capsule **50** will come to rest on the handle **66**, rather than on the integrity test assembly **100**.

However, in some situations, the handle **66** may interfere with closely situated components within an assembly, and thus be an unwanted component. Accordingly, in certain embodiments, the handle **66** may be omitted from the filter capsule **50**. However, in certain embodiments, as shown in FIG. 4B, the handle **66** may be a separately formed and removable element. In this case, the handle **66** may releasably snap onto the inlet housing **54** via a handle notch **68** and between guiding ridges **70**. The handle notch **68** and guiding ridges **70** retain the handle **66** in a desired position. In the embodiment shown, the guiding ridge **70** tapers inwardly near the receiving notch so as not to interfere with the graspable portion of the handle **66**. In some embodiments, the handle **66** may then be removed by urging the edges of the handle **66** away from the handle notch **68**. Accordingly, the handle **66** may be repeatedly removed and reattached to the inlet housing **54**.

However, in certain embodiments, the handle **66** may not be removable. Rather, in these embodiments, the handle **66** is provided separately from the filter capsule **50** and may only be snapped in place and secured to the filter capsule **50** if so desired by the end user. In the non-removable embodiment, attempted removal of the handle **66** will result in breakage of either the handle **66** or the inlet housing **54** or both. For example,

one means of permanently attaching or securing the handle **66** to the inlet housing **54** is by a heat stake rivet.

Similarly, FIGS. 5A-B illustrate an embodiment of an outlet end cap **58** shown
5 separated from the housing **52**. The outlet end cap **58** has two feet **64** in comparison to the single foot **64** of inlet housing **54**; however, any number of feet **64** may be used for either component. The outlet end cap **58** also features a handle **66** that may be removable or otherwise attachable and reattachable via a handle notch **68** and guiding ridges **70**. The guiding ridge **70** tapers inwardly near the handle notch **68** so as not to
10 interfere with the graspable portion of the handle **66**. In this embodiment, as shown, the handle **66** protects the vent assembly **62**.

FIG. 6 illustrates a cross-sectional view of an embodiment of a filter capsule **50**. Similar to the filter capsule **16** of FIGS. 1-2, within the filter capsule **50** is a filter element
15 **40**. In certain embodiments, the filter element **40** is sealed to the outlet port **60** of the outlet end cap **58**, such that a fluid entering the inlet port **56** from upstream must pass through the filter element **40** before exiting through the outlet port **60**, thus filtering the fluid. The filter element **40** may comprise any kind of filter, including pleated filters, hydrophobic filters, hydrophilic filters, or sterilizing filters. The vent assembly **62** and
20 integrity test assembly **100** may have a similar design, and each includes a connection **72**, **102**; a connector actuator such as a handle **74**, **104**; and one or more seals **76**, **106**. In certain embodiments, the connection **72** on the vent assembly **62** is a barb connection, which may be attached to plastic tubing connected to a venting or sampling container such as a bag. To vent or sample the contents of the filter capsule **50**, the vent assembly
25 **62** is actuated such as by rotating the connector actuator or handle **74**, thus opening the vent assembly **62**. The integrity test assembly **100** has a larger diameter than the vent assembly **62**, so as to provide sufficient flow characteristics necessary for integrity testing. In this embodiment, the connection **102** on the integrity test assembly **100** is a TC connection, which may be attached to a gas line, integrity testing hardware, or a venting
30 or sampling bag. Similar to the vent assembly **62**, the integrity test assembly **100** may be actuated by rotating the handle **104**. The one or more seals **76**, **106** on each port ensure

sterility of the contents of the filter capsule **50** despite multiple actuations, making each port aseptic. Further, while in this embodiment the vent assembly **62** uses a barb connection and the integrity test assembly **100** uses a TC connection, various connections are within the scope of the disclosure. For example, in certain embodiments, Luer connections or other forms of connections may be used in either the vent assembly **62** or integrity test assembly **100**.

In certain embodiments, an integrity test assembly **100** is provided on both the inlet housing **54** and outlet end cap **58**. Alternately, the outlet end cap **58** may have an integrity test assembly **100**, and the inlet housing has only a vent assembly **62**. Either the integrity test assembly **100** or vent assembly **62** may also be present elsewhere on the housing **52** or on an assembly. For example, an integrity test assembly **100** and/or vent assembly **62** may be located downstream of the filter capsule **50**. As noted previously, the integrity test assembly **100** is an integral component of the filter capsule **50** and may not be removed. However, in certain embodiments, the integrity test assembly **100** may be removable. Various embodiments, locations, and numbers of the integrity test assembly **100** and vent assembly **62** are within the scope of the disclosure.

FIGS. 7-8 illustrate cross-sectional views of certain embodiments of an integrity test assembly **100** in the closed and open positions, respectively. As noted above, the integrity test assembly **100** may be of similar construction as the vent assembly **62**; however, the integrity test assembly **100** has a greater diameter to provide sufficient flow characters to facilitate integrity testing. Of course, the integrity test assembly **100** may also be used for aseptic venting or sampling, just like the vent assembly **62**. In the embodiment shown, the integrity test assembly **100** comprises an opening or port on the filter capsule **50** having a body **108** extending from the inlet housing **54**. The body **108** defines a bore **110** and comprises three sections. A first section **112** of the body **108** closest to the filter capsule **50** has a first inner diameter that is smaller than the inner diameter of a second section **116**. A transition section **114** between the first section **112** and second section **116** has an inner diameter that increases linearly from the first section **112** to the second section **116**. While in this embodiment the inner diameter of the

transition portion increases linearly, in other embodiments the inner diameter may increase non-linearly, such as exponentially or via a step function. The body **108** further comprises a receiving notch **118** in communication with a cam slot **120**. In this embodiment, the receiving notch **118** is a raised portion of the body **108** that is formed over the cam slot **120**. As will be explained further below, the receiving notch **118** is configured to receive a cam, such that the cam may enter the cam slot **120**.

The integrity test assembly **100** further comprises a valve that can be actuated to an open position and a closed position, thus facilitating fluid or gas transfer either into or out of the filter capsule **50**. The valve comprises a plunger **128** positioned within the bore **110**, creating a fluid tight seal between the body **108** and plunger **128** via one or more seals **132**, **134**, **136** such as O-rings. The plunger **128** has a shape corresponding to the bore **110**. The plunger comprises a cam **125** (as shown in FIG. 9), which in the embodiment shown, extends radially from the plunger body and is configured to fit and track within the cam slot **120**. In this embodiment, the cam **125** and cam slot **120** define the linear extent of movement of the plunger **128** within the bore **110**. Rotating a connector actuator or handle **104** causes the cam **125** to traverse the cam slot **120**. In this embodiment, the integrity test assembly **100** is in the closed position when the cam **125** is in a portion of the cam slot **120** closest to the inlet housing **54**; similarly, the integrity test assembly **100** is in the open position when the cam **125** is in a portion of the cam slot **120** farthest from the inlet housing **54**.

The plunger **128** has a diameter configured to match the configuration of the body **108**. In this embodiment, the plunger **128** comprises three portions corresponding to the three sections **112**, **114**, **116** of the body **108**. Similar to the sections of the body **108**, a first portion **122** has an outer diameter that is smaller than the outer diameter of a second portion **126**. A transition portion between the first portion **122** and second portion **126** has an outer diameter that is configured to match the configuration of the transition section **114** of the bore **110**. For example, in this embodiment, the diameter of the transition section increases linearly from the outer diameter of the first portion **122** to the outer diameter of the second portion **126**. As will be explained in further detail below, the

plunger **128** acts as a valve and cooperates with the body **108** to actuate the integrity test assembly **100**. During actuation of the integrity test assembly **100** to an open position, the plunger **128** traverses the bore **110** such that the first portion **122** of the plunger **128** aligns with the transition section **114** of the body **108**, creating a fluidic channel in communication with the interior of the filter capsule **50**. When the integrity test assembly **100** is actuated to a closed position, the plunger **128** traverses the bore **110** such that the first portion **122** of the plunger **128** aligns with the first section **112** of the body **108**, thus closing the fluid channel.

Further, in this embodiment, the plunger **128** comprises one or more cavities **142**. The cavities **142** help to reduce friction during translation of the plunger **128** within the bore **110**. In certain embodiments, the cavities **142** may be larger, smaller, have different shapes, or not be present.

Various seals are arranged along the length of the plunger **128** to form a fluid tight seal between various portions of the plunger **128** and the body **108**. In this embodiment, the integrity test assembly **100** includes three seals: a shut-off seal **132**, an outside seal **134**, and a sterility seal **136**. As shown, the seals are contained in annular grooves **138** formed in the plunger **128**. In various embodiments, the seals **132**, **134**, **136** may be O-rings, either pre-formed and retained within the annular grooves **138**, or formed in place in the annular grooves **138**. However, if desired, different configurations of seals and their placements can be used. For example, seals may be held in grooves in the inner surface of the bore **110**.

Within the plunger **128** is an axial channel **130**, which is in communication with the connection **102**. The axial channel **130** is further in communication with a radial channel **144** located between the shut-off seal **132** and outside seal **134**. In this embodiment, the axial channel **130** and radial channel **144** together form a T-shaped fluidic channel that may be used to transfer fluid, gas, or other substances into or out of the filter capsule **50** when the integrity test assembly **100** is actuated to an open position.

In the closed position (as shown in FIG. 7), the radial channel **144** is not in communication with the interior of the filter capsule **50** due to the shut-off seal **132** being in contact with the first section **112** of the body **108**, and fluid within the filter capsule **50** is contained. In this position, the sections **112**, **114**, **116** of the body **108** are respectively aligned with the corresponding portions **122**, **124**, **126** of the plunger **128**. Rotating the connector actuator or handle **104** urges the cam **125** along the cam slot **120**, causing the plunger **128** to move towards an open position (as shown in FIG. 8). In the open position, the plunger **128** has moved laterally away from the filter capsule **50** such that the first portion **122** of the plunger **128** is aligned with the transition section **114** of the body **108**. This creates an open space between the shut-off seal **132** and transition section **114**, thus forming a fluidic connection between the contents of the filter capsule **50** and the radial channel **144**. Thus, fluid within the filter capsule **50** may exit through the created open space, into the radial channel **144**, into the axial channel **130**, and out through the connection **102**. Similarly, a gas or fluid may be provided to the filter capsule **50** along the same path. To enter the closed position and re-establish a seal between the shut-off seal **132** and first inner section **112**, the connector actuator or handle **104** is rotated in the opposite direction.

To use the integrity test assembly **100** for venting or sampling, tubing and a venting or sampling container such as a bag are aseptically connected to the connection **102**. The integrity test assembly **100** is then actuated to the open position by rotating the connector actuator or handle **104**. The contents of the filter capsule **50** may then traverse the radial channel **144** and axial channel **130**, exiting via the connection **102**. Once venting or sampling is complete, the integrity test assembly **100** is actuated to the closed position, and the tubing and venting or sampling container is removed. The vent assembly **62** may be used in a similar manner. Once venting or sampling is complete, the integrity test assembly **100** may then enter the closed position by appropriately actuating the connector actuator or handle **104**. This may be accomplished by rotating the connector actuator or handle **104** in the opposite direction, thus placing the shut-off seal **132** back into contact with the surface of the bore **110** at the first section **112** and

reestablishing the liquid-tight seal between the plunger **128** and bore **110** (as shown in FIG. 7).

The integrity testing assembly **100** provides numerous advantages for testing the integrity of the filter element **40** when compared to previous approaches. If pre-filtration integrity testing is desired, a gas line or other integrity testing hardware is aseptically attached to the connection **102**. The integrity test assembly **100** is then actuated to an open position, creating an aseptic fluid connection between the integrity testing hardware and contents of the filter capsule **50**. The gas line or integrity testing hardware is then activated, thus pressurizing the contents of the filter capsule **50**. To perform a diffusion test, the resulting increase in pressure downstream is measured and compared to known values for the filter element. To perform a pressure drop test, the decrease in pressure over time upstream of the filter element is similarly measured and compared to known values. If the filter meets the known values, it can be safely assumed that the filter element is not compromised.

The integrity test assembly **100** may then be actuated to a closed position, and the gas line or integrity testing hardware may be removed without compromising the process stream. Once the filtration process is complete, this process may be repeated to determine whether the filter was compromised during filtration, and thus whether the resulting filtrate is sterile. Despite multiple actuations and multiple rounds of integrity testing, the integrity test assembly **100** remains aseptic and prevents contamination of the process stream. Further in contrast to the prior art, the use of a filter capsule **50** with an integrated integrity test assembly **100** results in the advantage that no additional components for integrity testing are required upstream of the filter capsule **50**. Each of these additional components represented an additional failure or contamination point. Further, these additional components did not ensure sterility through multiple actuations or rounds of integrity testing. In contrast, the present disclosure features an integral integrity test connection that maintains sterility despite multiple actuations, and is located directly at the filter capsule itself, the desired point of interest.

FIGS. 9A-C are side views of an embodiment of an integrity test assembly **100**, illustrating the cam slot **120** in further detail. FIG. 9A illustrates the integrity test assembly **100** in an open position. As previously described, in the open position, the transition portion **124** of the plunger **128** is aligned with the first section **112** of the body **108**. In this embodiment, the cam slot **120** comprises five segments: an open segment **146**, first transition segment **148**, receiving segment **150**, second transition segment **152**, and closed segment **154**. In the open position, the cam **125** is located in the open segment **146** of the cam slot **120**. The open segment **146** is sized to accommodate the cam **125**, and has a slope perpendicular to the longitudinal axis of the plunger **128**. Thus, as the cam **125** traverses the open segment **146**, its position along the longitudinal axis of the body **108** does not change. This feature is useful because it enables the integrity test assembly **100** to enter the open position prior to the cam **125** reaching the end of the cam slot **120**, thus ensuring that the integrity test assembly **100** is fully opened, but allowing for additional rotation of the handle **104** after entering the open position. Further, the open segment **146** may comprise a detent **156** slowing movement of the cam **125** within the open segment **146**, providing tactile feedback to an end user that the integrity test assembly **100** has entered the open position.

To begin closing the valve, the connector actuator or handle **104** is rotated, causing the cam **125** to enter the first transition segment **148**. The first transition segment **148** has a path that is sloped towards the filter capsule **50**. As the cam **125** traverses the first transition segment **148**, the plunger **128** begins to enter the closed position, such that the transition portion **124** of the plunger **128** begins to align with the first section **112** of the body **108**. As shown in FIG. 9B, continuing to rotate the handle **104** causes the cam **125** to then enter the receiving segment **150**. Halfway between the open and closed positions, the receiving segment **150** is in communication with the receiving notch **118**. Thus, when the plunger **128** is first positioned within the bore **110** (e.g., during manufacture of the filter capsule **50**), the cam **125** is in the receiving segment **150**. Like the open segment **146**, the receiving segment **150** has a slope perpendicular to the longitudinal axis of the plunger **128** such that the plunger **128** does not move towards or away from the filter capsule **50** as the cam **125** traverses the receiving segment **150**. Thus, an end user may

slightly rotate the handle **104** without causing the plunger **128** to move towards the open or closed positions, providing a finer degree of control.

Continuing to rotate the connector actuator or handle **104** causes the cam **125** to enter the second transition segment **152**. Like the first transition segment **148**, the second transition segment **152** has a path that is sloped towards the filter capsule **50**. As shown in FIG. 9C, the second transition segment **152** is connected to the closed segment **154**. Like the open segment **146** and receiving segment **150**, the closed segment **154** has a slope perpendicular to the longitudinal axis of the plunger **128** such that the plunger **128** does not move towards or away from the filter capsule **50** as the cam **125** traverses the closed segment **154**. Similarly, this feature is useful because it enables the integrity test assembly **100** to enter the closed position prior to the cam **125** reaching the end of the cam slot **120**, thus ensuring that the integrity test assembly **100** is fully closed and allowing additional rotation of the handle **104** after entering the closed position. Further, the closed segment **154** may also comprise a detent **156** slowing movement of the cam **125** within the closed segment **154**, providing tactile feedback to an end user that the integrity test assembly **100** has entered the closed position. The combination of detent **156** and additional rotation without exiting the closed position is particularly useful because it minimizes inadvertent opening (and the potential for contamination) of the integrity test assembly **100**.

In certain embodiments, additional cams and cam slots may be used. For example, in certain embodiments, an integrity test assembly **100** comprises a pair of cams within cam slots disposed 180 degrees from one another along the body of an integrity test assembly. In certain embodiments, cam slots may be longer or shorter depending on the level of actuation desired per rotation of a connector actuator or handle. In certain embodiments, a plunger may enter the closed or open positions only on reaching a respective end of a cam slot. Various embodiments are considered to be within the scope of the disclosure.

FIG. 10 is a perspective view illustrating the integrity test assembly **100** with the plunger **128** separated from the bore **110**. In this embodiment, the plunger **128** is a molded plastic component formed of polyethersulfone, a relatively strong material that helps make the integrity test assembly **100** robust and less susceptible to bending, breaking, melting, or other modes of failure. The plunger **128** contains annular grooves **138** in which the seals **132**, **134**, **136** are placed. The shut-off seal **132** is located in the first portion **122**, whereas the outside seal **134** and sterility seal **136** are located in the second portion **126**. As previously noted, the transition portion **124** has a diameter that transitions linearly between that of the first portion **122** and second portion **126**. However, in other embodiments, the transition portion **124** may transition in a different manner or be absent from the plunger **128**. Further, the plunger **128** includes a cam **125** and an indicator strip **140**.

To build the integrity test assembly **100**, the plunger **128** is inserted into the bore **110** such that the cam **125** enters the receiving notch **118**. Rotating the handle **104** about the longitudinal axis of the integrity test assembly **100** causes the cam **125** to follow the path of the cam slot **120**, thus limiting the length of travel of the plunger **128** within the bore **110**. As described above, in this embodiment the cam slot **120** comprises a single cam slot **120** having multiple segments extending about the diameter of the body **108**. However, in certain embodiments, the cam slot **120** may comprises two cam slots on each side of the body **108**. Additionally, the use of the receiving notch **118** is beneficial because it allows for an elongated cam **125** that may extend through and protrude from the cam slot **120**, preventing accidental slippage of the cam **125** out of the cam slot **120** and into the bore **110**.

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An indicator strip **140** is another useful feature that readily indicates to an end user whether the plunger **128** is in either the open or closed positions. In this embodiment, the indicator strip **140** is placed on the plunger **128** such that it is visible only when the integrity test assembly **100** is in the open position, placing the portion of the plunger **128** having the indicator strip **140** outside of the bore **110**. Thus, an end user may view the indicator strip **140** and understand that the integrity test assembly **100** is in the open position.

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Similarly, an end user may understand that an inability to view the indicator strip **140** means that the integrity test assembly **100** is closed.

FIG. 11 is a cross-sectional view of an integrity test assembly **100** in the open position and highlights the benefits of the use of the outside seal **134** and sterility seal **136**. In the open position, sterile liquid within the filter capsule **50** may flow past the shut-off seal **132**, into the radial channel **144**, through the axial channel **130**, and out of the integrity test assembly **100** via the connection **102**. Typically, outside air and external contaminants are prevented from coming into contact with the sterile liquid by the outside seal **134**. However, after multiple actuations, some contamination may pass the outside seal **134** as the plunger **128** rides within the bore **110**. The provision of the sterility seal **136** as an additional seal upstream of the outside seal **134** prevents this form of contamination by defining a “safe area” between the outside seal **134** and sterility seal **136** in which the sterility seal **136** may ride, but the outside seal **134** never comes into contact. Thus, the outside seal **134** never comes into contact with a surface touched by the sterility seal **136**, and therefore is less likely to experience contamination. This feature helps ensure that the integrity test assembly **100** (and if desired, vent assembly **62**) provide an aseptic connection to the contents of the filter capsule **50**. Further, compared to the vent valves **18** of previous filter capsules **16**, this feature provides the integrity test assembly **100** and vent assembly **62** to remain aseptic despite repeated actuations.

As noted above, this aseptic property allows the integrity test assembly **100** to be used for a variety of purposes. For example, the integrity test assembly **100** may be used for venting of built-up gas within the filter capsule **50**. Alternately, the integrity test assembly **100** may be used for sampling of media within the filter capsule **50**. For both of these purposes, the integrity test assembly **100** ensures that despite multiple actuations, the contents of the filter capsule remain sterile and not exposed to the outside environment. Further, the integrity test assembly **100** may function as a valve, allowing for an integrity test connection that can be removed from the filter capsule **50** without compromising product sterility. Providing an integrity test assembly **100** directly on the

filter capsule **50** greatly simplifies the design of an assembly, as the need to set up a connection upstream for integrity testing hardware is eliminated. Further, the use of a sterility seal **136** in both the vent assembly **62** and integrity test assembly **100** helps to ensure an aseptic connection, thus reducing the risk of product and environmental contamination.

In certain embodiments, the integrity test assembly **100** may be a removable, replaceable, or single-use component. For example, rather than being molded directly to the inlet housing **54**, the integrity test assembly **100** may include a sanitary flange that may be mated to a corresponding port on the filter capsule **50**.

In certain embodiments, the axial channel **130** and/or radial channel **144** may be formed in a separate element, as opposed to within the plunger **128**. For example, as shown in the embodiment of FIG. 12, the bore **110** may include an auxiliary port **158** located between the shut-off seal **132** and outside seal **134**. Tubing **160** or the like is then connected to the auxiliary port **158**. Actuating the integrity test assembly **100** then allows fluid to flow past the shut-off seal **132** and out the auxiliary port to a downstream component or other device, or alternately to be used as a connection for integrity testing. In certain embodiments, the radial channel **144** and axial channel **130** may comprise a single fluid channel. In certain embodiments, multiple channels may be used to create a fluidic connection between the interior of the filter capsule **50** and the connection **102**.

As described above, seals may be mounted on the plunger **128**. However, if desired, different configurations of seals and their placements can be used. For example, at least some seals may be held in grooves of the bore **110** as opposed to the plunger **128**. In another embodiment, the outside seal **134** and sterility seal **136** may be replaced with a single linear or gland seal that covers a similar distance between the outside seal **134** and sterility seal **136**, such that one end of the seal never comes into contact with a surface of the bore **110** in contact with the other end of the seal.

In the disclosed embodiments above, the integrity test assembly **100** is formed of a plastic material including polyethersulfone. The integrity test assembly **100** may be formed by machining the body **108** and plunger **128** and then applying the necessary seals and the like, or preferably by molding the body **108** and the plunger **128** separately and assembling them together with the necessary seals and other components. The integrity test assembly **100** may be made of a variety of plastic materials. For example, in the embodiment disclosed, the inlet housing **54** and body **108** are formed from polypropylene. However, the plunger **128** is formed from polyethersulfone, which results in a plunger **128** that is stronger and having better dimensional stability. However, a variety of materials may be used for any of these components. Similarly, other components of the filter capsule **50** may comprise a variety of materials.

Further, it should be noted that various features of the above embodiments and disclosure may be combined with one another to form various filter assemblies, capsules, and ports. The present disclosure is not to be limited in scope by the specific embodiments described herein. Indeed, other various embodiments of and modifications to the present disclosure, in addition to those described herein, will be apparent to those of ordinary skill in the art from the foregoing description and accompanying drawings. Thus, such other embodiments and modifications are intended to fall within the scope of the present disclosure. Furthermore, although the present disclosure has been described herein in the context of a particular implementation in a particular environment for a particular purpose, those of ordinary skill in the art will recognize that its usefulness is not limited thereto and that the present disclosure may be beneficially implemented in any number of environments for any number of purposes. Accordingly, the claims set forth below should be construed in view of the full breadth and spirit of the present disclosure as described herein.

What is claimed is:

1. A filter capsule that supports direct integrity testing of an internal filter element, comprising:

5 a filter housing comprising an inlet port, an outlet port spaced from the inlet port, a housing volume between the inlet port and the outlet port and containing a filter element, a vent assembly, and an integrity test assembly, wherein said integrity test assembly comprises a valve for connection to integrity testing hardware, a body having a bore formed through at least a portion of its interior, the bore including a cam slot; a
10 movable plunger positioned within the bore, the plunger having a shape corresponding to that of the bore, the movable plunger further comprising:

an outer surface;

a cam formed on the outer surface and contained within the cam slot; and an actuator to move the plunger within the bore between a closed position and an open
15 position; one or more seals between the plunger and the body to form a liquid fluid tight seal between various portions of the plunger and the body; wherein the cam remains within the cam slot as the plunger moves between the closed position and the open position.

20 2. The filter capsule of claim 1, wherein the vent assembly and integrity test assembly are aseptic.

3. The filter capsule of claim 1, wherein a fluid passes from the inlet port to the outlet port through the filter element, and the integrity test assembly is located on an
25 upstream side of the filter element.

4. The filter capsule of claim 1, wherein the one or more seals are arranged along the outer surface of the plunger to form a liquid fluid tight seal between various portions of the plunger and the body.

5. The filter capsule of claim 1, wherein the one or more seals comprise a shut-off seal, an outside seal, and a sterility seal.

6. The filter capsule of claim 5, wherein the outside seal and the sterility seal are arranged along the outer surface of the plunger such that the portion of body in contact with the outer seal never comes into contact with the sterility seal as the plunger moves between the closed position and the open position.

7. The filter capsule of claim 1, wherein the outside seal and the sterility seal comprise a single seal.

8. The filter capsule of claim 1, wherein the seals comprise O-rings.

9. The filter capsule of claim 1, wherein the plunger further comprises a fluid channel in fluid communication with the passage of the filter capsule when the plunger is in the open position.

10. The filter capsule of claim 1, wherein the body has a first section having a first inner diameter, a second section having a second inner diameter greater than the first inner diameter, and a transition section between the first and second sections having a tapering inner diameter along its length from the first section to the second section which is a progression of the difference in diameters between the first inner diameter and the second inner diameter.

11. The filter capsule of claim 10, wherein the progression of the difference in diameters is a linear progression.

12. The filter capsule of claim 1, further comprising an indicator strip on the integrity test assembly.

13. The filter capsule of claim 12, wherein the indicator strip is located on the plunger.

14. The filter capsule of claim 1, further comprising a first handle protecting the integrity test assembly from accidental contact, and a second handle protecting the vent assembly from accidental contact.

15. The filter capsule of claim 1, further comprising feet.

16. A system for integrity testing a single-use filtration assembly, comprising:
an integrity testing device;
a source of a fluid to be processed;
a holding container; and
a filtration device, said filtration device comprising an inlet port in fluid communication with said source of fluid to be processed, an outlet port in fluid communication with said holding container, a filter element, an aseptic vent assembly, and an aseptic integrity test assembly, said integrity test assembly comprising:
a body having a bore formed through at least a portion of its interior;
a plunger contained within the bore, the plunger having a shape corresponding to that of the bore;
an actuator to move said plunger between a closed position and an open position;
a shut-off seal, an outside seal, and a sterility seal;
wherein said integrity testing device is attached to said integrity test assembly to facilitate integrity testing of said filter element.

17. A method of performing an integrity test of a filter element through a port of a filter capsule, comprising:
attaching a gas line to an integrity test assembly on a filter capsule, said integrity test assembly comprising a port and a valve providing fluid communication to an interior of the filter capsule;

actuating the integrity test assembly to an open position;
pressurizing the filter capsule using the gas line;
measuring a resulting pressure change; and

5 determining whether the measured pressure change indicates that a filter within
the filter capsule has been compromised, wherein said resulting pressure change is
measured upstream of the filter element.

18. The method of claim 17, further comprising:

actuating the integrity test assembly to a closed position;
10 after actuating the integrity test assembly to a closed position, using the filter
capsule to filter a product;

after using the filter capsule to filter a product:

actuating the integrity test assembly to the open position;
pressurizing the filter capsule using the gas line;
15 measuring a second resulting pressure change; and
determining whether the second measured pressure change indicates that
the filter within the filter capsule has been compromised after using the filter
capsule to filter a product;

wherein the integrity test assembly remains aseptic after each actuation.

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