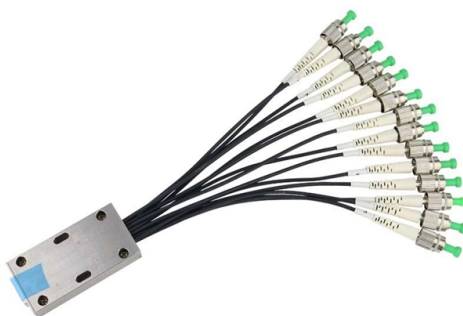


## Inspection Requirements for Spectrometers



### Overview

Do We Qualify or Validate a Spectrometer?

We critically review the qualification and validation approaches in the World Health Organization Technical Report.

### Key Takeaways

Spectrometer inspection and qualification require systematic procedures including design, installation, operational, and performance verification, aligned with ISO, ASTM, JIS, and pharmacopoeia standards.

- Design Qualification (DQ): Confirms that the spectrometer's design meets intended specifications and regulatory requirements before installation .
- Installation Qualification (IQ): Verifies that the instrument is installed correctly and functions according to manufacturer specifications .
- Operational Qualification (OQ): Ensures the instrument operates within defined parameters, including wavenumber precision, transmittance accuracy, linearity, resolution, and repeatability .



- Performance Qualification (PQ): Confirms the spectrometer performs reliably for its intended analytical applications, such as identity, purity, and quantitative measurements .

#### Inspection and Calibration Requirements

- Periodic and Motivated Checks: Instruments must undergo regular calibration and performance checks, including system suitability tests, as outlined in ISO 17025 and pharmacopoeia chapters (e.g., Ph. Eur. 2.2.24), .
- Reference Standards: Use certified reference materials such as polystyrene films for FTIR, or known peak substances (CO<sub>2</sub>, water vapor, ammonia) to verify wavenumber accuracy and transmittance .
- Transmittance Verification: 0% transmittance is checked using opaque samples, and 100% transmittance is verified without a sample to assess stray light and baseline accuracy .
- Linearity and Resolution: Calibration curves are created to confirm linearity of absorbance versus concentration, and resolution is tested using stable reference samples .
- Repeatability: Multiple measurements of the same sample are performed to ensure consistent results within prescribed tolerances .

#### Software and Data Integrity

- Software Validation: Integrated software must be validated for compliance with 21 CFR Part 11, GMP, and GLP standards. IQ and OQ processes are applied to software to ensure accurate data acquisition and processing .
- Data Integrity: Qualification of instruments and validation of software form the foundation of data integrity models, as described in USP and WHO TRS 1019 guidelines .

#### Compliance Standards

- ISO/IEC Guide 25: Provides requirements for calibration and testing laboratories, including documentation, traceability, and quality management .
- ASTM E1421-99: Specifies Level Zero and Level One tests for FTIR spectrometers, including power spectra comparison and long-term stability checks .
- JIS K0117: Defines general rules for infrared spectrophotometric analysis, including calibration and inspection methods .
- Pharmacopoeia Requirements: USP, European, Japanese, and Chinese pharmacopoeias provide specific tests and acceptance criteria for spectrometer performance .

#### Practical Considerations

- Professional Judgment: While guidelines provide standard procedures, laboratories may adapt methods based on instrument type, intended use, and risk assessment .

- Documentation: All qualification, calibration, and inspection activities must be thoroughly documented, including instrument records, calibration certificates, and software validation reports .
- Manufacturer or External Services: If qualification is performed externally, the laboratory remains responsible for ensuring compliance with applicable standards . By following these structured inspection and qualification requirements, laboratories can ensure spectrometers deliver accurate, reliable, and compliant analytical results.

## Article Content

### Optical Emission Spectroscopy | SPECTRO Analytical

Arc spark spectrometers can be used for many aspects of the production cycle including in-coming inspection of materials, metal

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