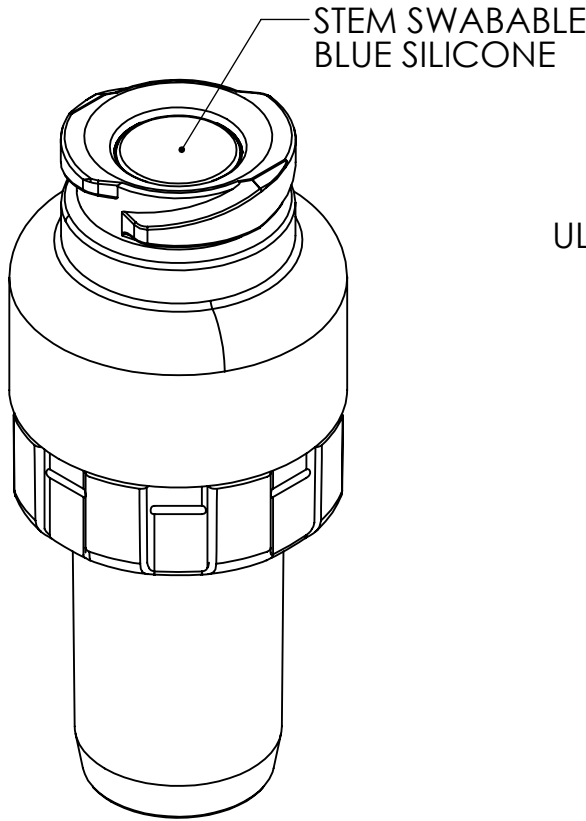


REVISION HISTORY			
REV	DESCRIPTION (ECO)	DATE	APPROVED
F	ADD UNDERCUT TO GROOVE AREA OF CONNECTOR ECO 12436	12/1/2023	DK
G	ADD SUFFIX 524 TO NOTE 1. ECO 12536	02/14/24	DK



ULTRASONIC
WELD

Ø0.135
(Ø 3.4mm)

0.44
(11.2mm)

Ø0.161
(4.1mm)

LUER BODY
SWABABLE
SEE NOTE 6.

(Ø0.276
Ø7.7mm)

1.00
(25.4mm)

0.06 x 15°
(1.5mm)

Ø0.270
(Ø 6.9mm)

CONNECTOR

NOTES:

- SUFFIX "XXX" INDICATES MATERIAL AND COLOR FOR LUER BODY CAP, AND STEM COLOR.
024 - POLYCARBONATE CLEAR, WITH BLUE STEM
024R - POLYCARBONATE RED, WIHT BLUE STEM
024B - POLYCARBONATE BLUE, WITH BLUE STEM
524 - POLYCARBONATE CLEAR, WITH CLEAR STEM
- CRITICAL DIMENSIONS ARE CIRCLED AND SUBJECT TO INSPECTION.
- DIMENSIONS IN PARENTHESES ARE FOR REFERENCE ONLY.
- ALL DIMENSIONS ARE IN INCHES WITH THE NOMINAL DIMENSION IN MILLIMETERS BELOW.
- REFERENCE USAGE: UNIT WILL FIT 6.6MM (0.260") I.D. TUBING.
- LUER COMPATIBLE WITH ISO594-2, AND ISO80369-7.

VALVE SPECIFICATION:

BACK PRESSURE: > 30 PSI, REF. (2.1BAR). (40 PSI NOMINAL).
BIOCOMPATABILITY: PASSES ISO 10993, PART 1.
MATERIALS: ALL MATERIALS ARE GAMMA RESISTANT, MEET USP CLASS VI: ARE DEHP FREE, AND NOT MADE WITH NATURAL RUBBER LATEX.
STERILIZATION: ETO, GAMMA, AND STEAM BASED ON RAW MATERIAL SPECIFICATIONS.

QUALITY CRITERIA


O.D. FLASH: 0.015 MAX (0.4mm)

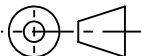
GATE VESTIGE: 0.01 MAX (0.3mm)

EMBEDDED PARTICLES, BUBBLES, SPOTS, STAINS: 0.3mm² MAX. NO MORE THAN 3 PER PART.

MOLDED PARTS:
GATES, PARTING LINES, AND FLASH PER QUALITY CRITERIA

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DRAWN BY	KH	DATE	7/18/2016
APPROVED BY	AK	DATE	1/18/2016
MATERIAL			
FINISH	N/A		
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR: ± 1° TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL ± .005		THIRD ANGLE PROJECTION 	



HR® Halkey-Roberts®

TITLE
Swabable Bag Access Port

DRAWING NO.
C245110XXX

SCALE
4:1

DO NOT SCALE DRAWING

SHEET
1 OF 2

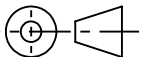
BILL OF MATERIAL:

SUFFIX	LUER BODY	CONNECTOR	STEM
024	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118	BLUE SILICONE 40 DUROMETER WACKER LR3003/40 DT COLOR, K75238
024R	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118 2% RED CLARIANT TRANSPARENT		
024B	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118 4% BLUE CLARIANT TRANSPARENT		
524	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118	CLEAR SILICONE 40 DUROMETER WACKER LR3003/40

MOLDED PARTS:
GATES, PARTING LINES, AND FLASH PER QUALITY CRITERIA

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UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGULAR: ± 1°
TWO PLACE DECIMAL ± .01
THREE PLACE DECIMAL ± .005

THIRD ANGLE PROJECTION


DRAWN BY: KH
APPROVED BY: AK
MATERIAL: SEE NOTES
FINISH: N/A

DATE: 7/18/2016
DATE: 1/18/2016

HR® Halkey-Roberts®

TITLE: Swabable Bag Access Port

SIZE: B
SCALE: 4:1

DRAWING NO. C245110XXX
DO NOT SCALE DRAWING

REV: G
SHEET: 2 OF 2