

DRAWING NO. C245112XXX		REV L	Customer Drawing		REVISION HISTORY			
					REV	DESCRIPTION (ECO)	DATE	APPROVED
					K	ADD SUFFIX OPTION FOR CLEAR STEM ECO 11178	06/23/21	AK
					L	UPDATE SUFFIX OPTION TO READ 024 ECO 11899	10/11/22	SR

Technical drawing of a bag break off port. The drawing shows a side view of the device with various dimensions and labels. The dimensions are: (Ø 0.268) Ø 6.8mm, (Ø 0.256) Ø 6.5mm, (Ø 0.248) Ø 6.4mm, 1.22 (31mm), 1.76 ± 0.04 (45mm), and BREAK-OFF CONNECTOR 6.0MM. The labels are: ULTRASONIC WELD, LUER BODY SWABABLE, and STEM SWABABLE SEE NOTE 1.

NOTES:

- SUFFIX INDICATES MATERIAL AND STEM COLOR:
024 - CLEAR POLYCARBONATE, BLUE SILICONE STEM.
524 - CLEAR POLYCARBONATE, CLEAR SILICONE 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.
- LUER COMPATIBLE WITH ISO594-2, AND ISO80369-7.
- USAGE: WILL FIT 6.0MM (0.236") I.D. TUBING.

VALVE SPECIFICATION:

BACK PRESSURE: > 30 PSI (2.1 BAR) REF, 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.
POTENTIAL STERILIZATION: ETO; STEAM, AND GAMMA, BASED ON RAW MATERIAL SPECIFICATIONS.

3D rendering of the bag break off port, showing the device in a blue color. The device has a long, thin stem and a wider, cylindrical body. The stem is labeled "STEM SWABABLE SEE NOTE 1." and the body is labeled "LUER BODY SWABABLE".

QUALITY CRITERIA:

O.D. FLASH: 0.005 MAX. (0.13mm)
GATE VESTIGE: 0.01 MAX. (0.3mm)
EMBEDDED PARTICLES, BUBBLES, SPOTS, STAINS: 0.3mm ² MAX. NO MORE THAN 3 PER PART.

DRAWN BY PM		DATE 3-24-2006		HR® Halkey-Roberts®	
APPROVED BY		DATE		TITLE	
MATERIAL		FINISH		BAG BREAK OFF PORT 6.0mm	
THIRD ANGLE PROJECTION		SIZE A		DRAWING NO. C245112XXX	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR: ± 1° TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL ± .005		SCALE 2:1		DO NOT SCALE DRAWING	
MOLDED PARTS: GATES, PARTING LINES, AND FLASH PER QUALITY CRITERIA		SHEET 1 OF 2		REV L	
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BILL OF MATERIAL:

SUFFIX	LUER BODY	BREAKOFF 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
524	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118	CLEAR SILICONE 40 DUROMETER WACKER LR3003/40