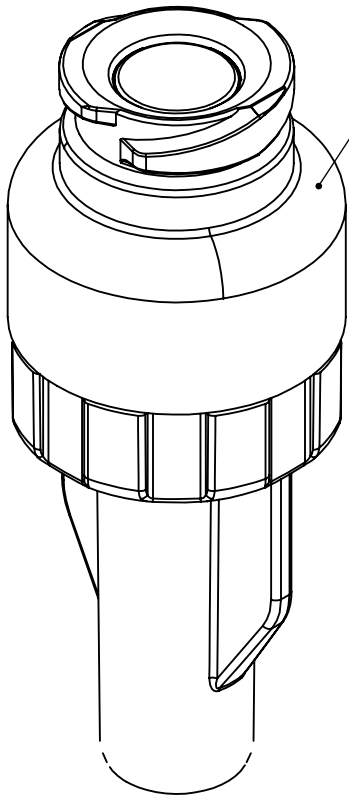


REVISION HISTORY			
REV	DESCRIPTION (ECO)	DATE	APPROVED
A	NEW DRAWING ECO 7199	9/21/16	KJS
B	ADD ISO80369-7 TO NOTE ECO 8017	4/27/18	AK



SEE NOTE 1. FOR LUER BODY
SWABABLE CAP COLOR

STEM SWABABLE
BLUE SILICONE

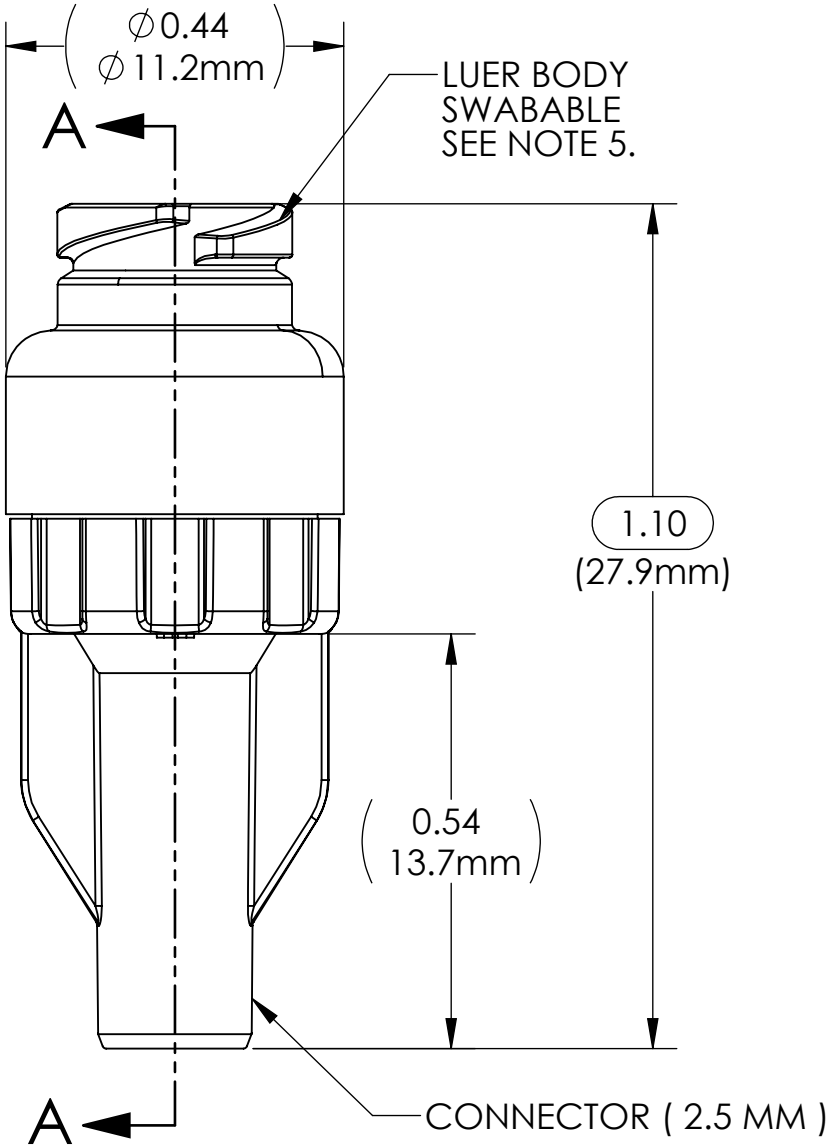
ULTRASONIC
WELD

$\phi 0.085 \pm .003$
($\phi 2.2\text{mm}$)

0.50
12.7mm

$\phi 0.098 \pm .003$
($\phi 2.5\text{mm}$)

SECTION A-A



NOTES:

- SUFFIX INDICATES LUER BODY CAP COLOR AND MATERIAL:
24 - CLEAR POLYCARBONATE
24R - CLEAR POLYCARBONATE WITH RED LUER BODY CAP.
- CRITICAL DIMENSIONS ARE CIRCLED AND SUBJECT TO INSPECTION.
- DIMENSIONS IN PARENTHESES ARE REFERENCE ONLY.
- ALL DIMENSIONS ARE IN INCHES WITH NOMINAL DIMENSIONS IN MILLIMETERS BELOW.
- LUER COMPATIBLE WITH ISO594-2, AND ISO80369-7.

VALVE SPECIFICATION:

BACK PRESSURE: > 30 PSI, REF. (2.1 BAR). (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; AND GAMMA, 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

PROPRIETARY AND CONFIDENTIAL
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DRAWN BY	DMC	DATE	9/21/16
APPROVED BY		DATE	
MATERIAL	ERROR!:Material		
FINISH	ERROR!:Finish		
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR: ± 1° TWO PLACE DECIMAL ± .01 THREE PLACE DECIMAL ± .005		THIRD ANGLE PROJECTION	
			

		TITLE	
Tube End Port 2.5 mm		REV	
DRAWING NO. C2455250XXX		B	
DO NOT SCALE DRAWING		SHEET 1 OF 2	

DRAWING NO. C2455250XXX		REV B	Customer Drawing		REVISION HISTORY			
REV		DESCRIPTION (ECO)		DATE		APPROVED		
A		NEW DRAWING ECO 7199		9/21/16		KJS		
B		ADD ISO80369-7 TO NOTE ECO 8017		4/27/18		AK		

BILL OF MATERIAL:

SUFFIX	LUER BODY	CONNECTOR	STEM
24	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118	BLUE SILICONE 40 DUROMETER WACKER LR3003/40 DT COLOR, K75238
24R	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118 WITH RED COLORANT	CLEAR POLYCARBONATE MAKROLON Rx 1805 451118	BLUE SILICONE 40 DUROMETER WACKER LR3003/40 DT COLOR, K75238

DRAWN BY

ERROR!:Author

DATE

9/21/16

APPROVED BY

DATE

MATERIAL

FINISH

MOLDED PARTS:

GATES, PARTING LINES, AND FLASH PER QUALITY CRITERIA

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UNLESS OTHERWISE SPECIFIED:

DIMENSIONS ARE IN INCHES

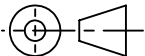
TOLERANCES:

ANGULAR: ± 1°

TWO PLACE DECIMAL ± .01

THREE PLACE DECIMAL ± .005

THIRD ANGLE PROJECTION



SIZE

B

SCALE

4:1

TITLE

Tube End Port 2.5 mm

DRAWING NO.

C2455250XXX


REV

B

SHEET

2 OF 2

DO NOT SCALE DRAWING

 Halkey-Roberts