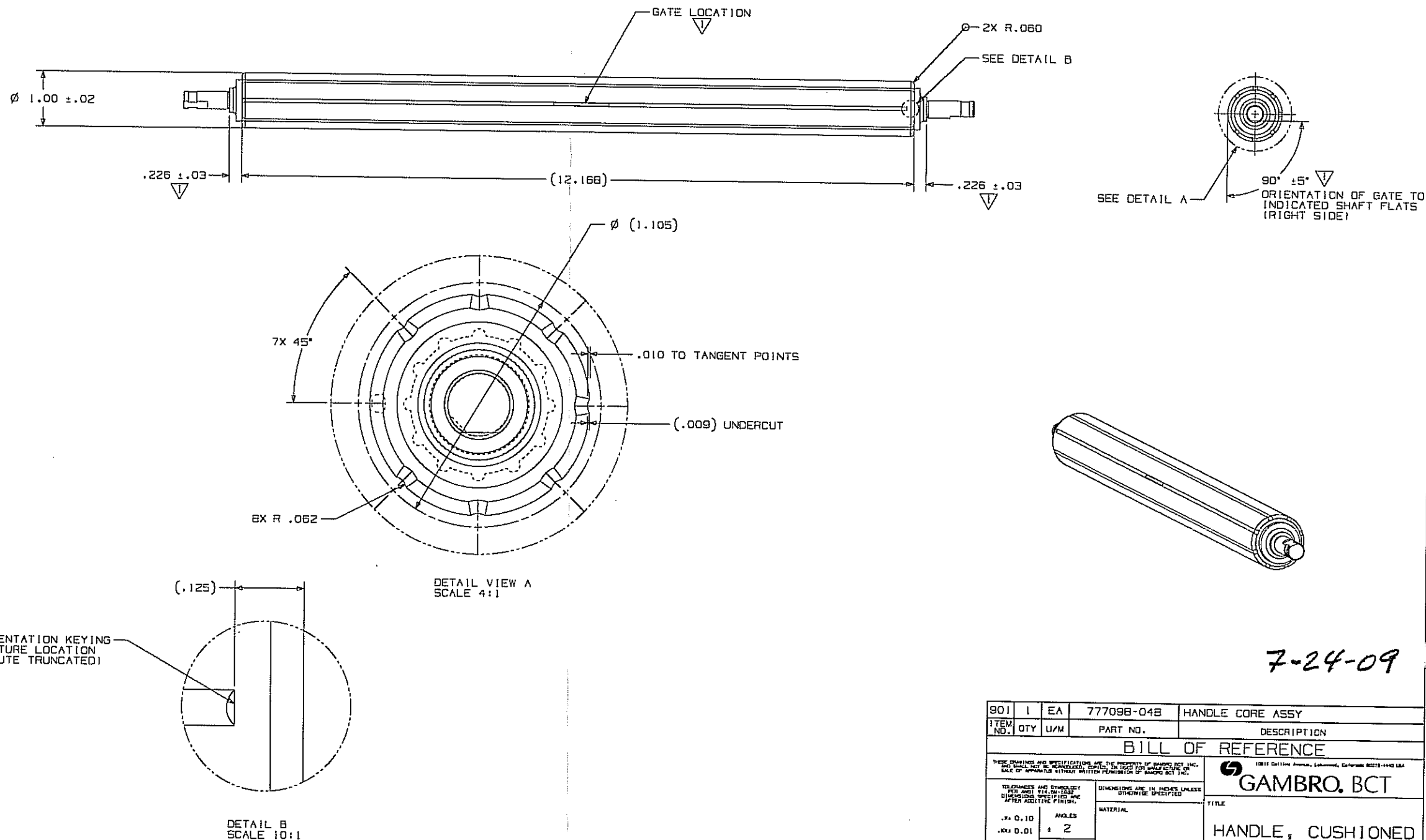


GAMBRO BCT GENERAL SPECIFICATIONS FOR MOLDED PLASTIC PARTS	
1. SURFACE APPEARANCE	
A. GENERAL APPEARANCE UNLESS OTHERWISE SPECIFIED	
<input type="checkbox"/> NO. 1: EXTRA HIGH LUSTER	
<input type="checkbox"/> NO. 2: HIGH LUSTER	
<input type="checkbox"/> NO. 3: FINE BRUSH	
<input type="checkbox"/> NO. 4: MEDIUM BRUSH	
<input type="checkbox"/> NO. 5: FINE MATTE	
<input type="checkbox"/> NO. 6: COARSE MATTE	
<input type="checkbox"/> NO. 7: NOT CRITICAL (MINIMUM MOLD SURFACE POLISH TO ASSURE PART RELEASE FROM MOLD)	
NOTE: FINISHES 1-6 ARE STANDARD SPI-SPE FINISHES	
B. SURFACE APPEARANCE SPECIFIED IS:	
<input type="checkbox"/> FOR PART FUNCTION	
<input type="checkbox"/> DECORATIVE	
2. DIMENSIONS & TOLERANCES UNLESS OTHERWISE SPECIFIED	
FILLETS SHOWN SHARP: 0.000 R MIN TO 0.005 R MAX	
FILLETS SHOWN ROUNDED: 0.005 R MIN TO 0.010 R MAX	
OUTSIDE CORNERS SHOWN SHARP: 0.000 R MIN, 0.005 R MAX	
OUTSIDE CORNERS SHOWN ROUNDED: 0.005 R MIN, 0.010 R MAX	
DRAFT FOR ROUND HOLES AND BOSSES 2.0° MAX INCLUDED ANGLE	
DRAFT FOR OTHER SURFACES 1.0° MAX PER SIDE	
NOTE: FLATNESS 1/16" SPECIFICATIONS ARE APPLIED WITH PERFECT FORM NOT REQUIRED AT WUC	
3. IDENTIFICATION MARKINGS	
A. CAVITY MARK	
<input type="checkbox"/> EACH CAVITY OF A MULTIPLE MOLD IS TO BE IDENTIFIED BY A CAVITY MARK	
<input type="checkbox"/> IF CAVITY IS REPLACED, THE REPLACEMENT MUST BEAR A MARK DIFFERENT FROM ANY OTHER INCLUDING THE ORIGINAL	
<input type="checkbox"/> LOCATION OF THE CAVITY MARK IS SPECIFIED IF CRITICAL	
B. MOLDERS MARK	
<input type="checkbox"/> LOCATION OF MOLDERS MARK IS SPECIFIED IF CRITICAL	
C. GAMBRO PART NUMBER	
<input type="checkbox"/> IS NOT TO BE MOLDED ON PARTS	
<input type="checkbox"/> IS TO BE MOLDED ON PARTS, LOCATION AS SPECIFIED	
4. MOLDING DEFECTS INCLUDE:	
<input type="checkbox"/> BLACK SPECKS, EMBEDDED FOREIGN MATERIAL, OR ENTRAPPED AIR BUBBLES > .030" (1.761)	
<input type="checkbox"/> MORE THAN 3 SPECKS PER PART > .010" (1.251)	
<input type="checkbox"/> OTHER	
5. EJECTOR PIN MARKS, UNLESS OTHERWISE SPECIFIED	
<input type="checkbox"/> PIN MARKS ACCEPTABLE TO: RAISED, DEPRESSED	
<input type="checkbox"/> PIN MARK FLASH MUST BE REMOVED	
<input type="checkbox"/> SOLID PIN MARK FLASH ACCEPTABLE TO: MAX	
<input type="checkbox"/> SPECIAL RECESSES: PIN MARK AND PIN MARK FLASH NOT TO EXCEED DEPTH OF RECESS	
6. NO PARTING LINE, GATE, FLASH OR EJECTOR PINS IN NOTED AREA	
NOTE: LOCATION OF GATES AND EJECTOR PINS TO BE APPROVED BY GAMBRO BCT PRODUCT ENGINEERING GROUP	
7. GATE, UNLESS OTHERWISE SPECIFIED	
<input type="checkbox"/> GATE MUST BE REMOVED FLUSH TO .010" (1.251) BELOW SURFACE OF PART	
<input type="checkbox"/> "TUNNEL" OR SUB-GATE ACCEPTABLE	
<input type="checkbox"/> RECESSED GATES ACCEPTABLE IF BELOW SURFACE	
<input type="checkbox"/> GATE PERMITTED TO: MAX HEIGHT	
8. FLASH, UNLESS OTHERWISE SPECIFIED	
<input type="checkbox"/> FLASH PERMITTED TO: MAX	
<input type="checkbox"/> HOLES AND THROUGH OPENINGS, INCLUDING FLASH, MUST BE WITHIN SIZE TOLERANCE	
9. CLEANLINESS	
<input type="checkbox"/> PARTS TO BE FREE OF OIL, WAX, DUST	
<input type="checkbox"/> SPECIAL CLEANING REQUIRED PER NOTE ON DRAWING	
<input type="checkbox"/> NOT CRITICAL, AS MOLDED	
<input type="checkbox"/> USE OF MOLD RELEASE IS NOT DESIRABLE, MOLD RELEASE AGENT, IF NECESSARY, MUST BE APPROVED BY GAMBRO BCT.	
10. PACKING & SHIPPING: SHIP ON PALLETS IF PRACTICAL	
<input type="checkbox"/> STANDARD CARTON WEIGHT, 110 KG (50 LBS) MAX	
<input type="checkbox"/> SPECIAL PACKING, AS SPECIFIED ON DRAWING	
<input type="checkbox"/> PACKED IN LAYERS WITH SEPARATORS	
<input type="checkbox"/> MAY BE PACKED IN BULK, 44 KG (100 LBS) MAX PER CARTON	
<input type="checkbox"/> DOUBLE PLASTIC BAGGED, FREE OF DEBRIS AND HOLES	
<input type="checkbox"/> SINGLE PLASTIC BAGGED, FREE OF DEBRIS AND HOLES	
11. GENERAL WALL THICKNESS TO BE 0.080 MIN UNLESS OTHERWISE SPECIFIED	
12. MATERIAL SPECIFICATIONS	
A. PERCENT REGRIND ALLOWED (MUST BE WITHIN SPECIFIED LOT)	
<input type="checkbox"/> 0	
<input type="checkbox"/> UNDER 10%	
<input type="checkbox"/> UNDER 25%	
<input type="checkbox"/> UNDER 50%	
<input type="checkbox"/> 100% REGRIND ALLOWED	
<input type="checkbox"/> OTHER: % MAX	
B. RESIN LOT NUMBER TRACEABILITY	
<input type="checkbox"/> MUST BE MARKED ON THE PACKAGE WITH EACH SHIPMENT OF PARTS	
C. SHIFT AND MANUFACTURE DATE	
<input type="checkbox"/> TO BE SPECIFIED (MAY BE INCLUDED IN RESIN LOT DESIGNATION)	
D. FOR MEDICAL USE, TO BE TESTED AT GAMBRO BCT FOR MATERIAL TOXICITY ACCORDING TO THE FOLLOWING FUNCTION:	
<input type="checkbox"/> BLOOD CONTACT	
<input type="checkbox"/> POSSIBLE BLOOD CONTACT	
<input type="checkbox"/> FLUID CONTACT	
E. OTHER ADDITIVES ALLOWED	
<input type="checkbox"/> NOTED ON DRAWING	
13. MISMATCH: THE TOTAL MISMATCH PLUS THE ASSOCIATED FLASH AT THE PARTING LINES	
<input type="checkbox"/> .015" (1.381) MAX	
<input type="checkbox"/> .020" (1.511) MAX	
<input type="checkbox"/> OTHER: 0.005 MAX	
14. SINKS: DEFECTS ARE:	
<input type="checkbox"/> WHERE LENGTH IS LESS THAN TWICE ITS DEPTH, OR EDGES ARE SHARP, OR DEPTH IS > .030" (1.761), OR DEPTH IS > 50% OF WALL THICKNESS	
<input type="checkbox"/> SPECIFIED ON DRAWING	
15. <input checked="" type="checkbox"/> INDICATES KEY FEATURE/DIMENSION TO BE CHECKED AT INCOMING INSPECTION	

- NOTES:
- DIMENSIONS NOT SPECIFIED ON THE DRAWING ARE CONTAINED IN THE DATABASE FOR THIS PART NUMBER AND REVISION.
 - INDICATES KEY DIMENSION/FEATURES TO BE CHECKED AT INCOMING I.C.
 - TOOLING CHANGES AFTER APPROVED FIRST ARTICLE INSPECTION REQUIRE APPROVAL FROM CODE BCT.
 - MATERIAL:
SANTOPRENE THERMOPLASTIC ELASTOMER GRADE 201-73 (73 SHORE A),
COLOR OPTIA DARK BLUE (PMS 7574C, COLOR MATCH SAMPLE)

REV	REVISION DESCRIPTION	BY	DATE	ECO #
A	INITIAL RELEASE, SIM TO 777098-036	MG	09/14/00	BCT017752



UG DWG

901	1	EA	777098-048	HANDLE CORE ASSY
ITEM NO.	QTY	U/M	PART NO.	DESCRIPTION
BILL OF REFERENCE				
THESE DRAWINGS AND SPECIFICATIONS ARE THE PROPERTY OF GAMBRO BCT, INC. NO PARTS, MATERIALS, OR SERVICES ARE TO BE USED IN THE MANUFACTURE OF ANY PRODUCT WITHOUT WRITTEN PERMISSION OF GAMBRO BCT, INC.				
TOLERANCES AND DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE:		DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		
.XX ± 0.10		Holes		
.XX ± 0.01		± 2		
.XX ± 0.005		SURF. FINISH		
.XX ± 0.0020		ORIGINATOR		
DATE		DATE		
SIZE	SCALE	DO NOT SCALE	DATE	DATE
D 1:1	SCALE	DO NOT SCALE	C HAKE	12/00/00
PART NO.				REV
777094-415				A 1/1

7-24-09 408

