

SUBJECT	STANDARD SPECIFICATION	SHEET #	SPECSTANDARD.FIE
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The table below lists the standard specifications applied to products manufactured by UNIMED.
Customized specifications can be applied according to the customer's request.

	UNIMED product (<i>industrial</i>)	Customer product																				
Strength of assemblies	The assembling withstand (gluing, fit-pressing, soldering, welding) is characterized by the destructive seal strength.																					
	<table border="1"> <thead> <tr> <th>Cannula/stylet outer diameter [mm]</th> <th>Minimum destructive seal strength [kg]</th> </tr> </thead> <tbody> <tr> <td>$\varnothing < 0.50$</td> <td>2.5</td> </tr> <tr> <td>$0.50 \leq \varnothing < 0.70$</td> <td>3.5</td> </tr> <tr> <td>$0.70 \leq \varnothing < 0.80$</td> <td>4.5</td> </tr> <tr> <td>$0.80 \leq \varnothing < 0.90$</td> <td>5.5</td> </tr> <tr> <td>$0.90 \leq \varnothing < 1.40$</td> <td>8.0</td> </tr> <tr> <td>$1.40 \leq \varnothing < 2.50$</td> <td>10.0</td> </tr> <tr> <td>$2.50 \leq \varnothing < 3.10$</td> <td>11.0</td> </tr> <tr> <td>$3.10 \leq \varnothing < 4.00$</td> <td>12.0</td> </tr> <tr> <td>$4.00 \leq \varnothing$</td> <td>13.0</td> </tr> </tbody> </table>	Cannula/stylet outer diameter [mm]	Minimum destructive seal strength [kg]	$\varnothing < 0.50$	2.5	$0.50 \leq \varnothing < 0.70$	3.5	$0.70 \leq \varnothing < 0.80$	4.5	$0.80 \leq \varnothing < 0.90$	5.5	$0.90 \leq \varnothing < 1.40$	8.0	$1.40 \leq \varnothing < 2.50$	10.0	$2.50 \leq \varnothing < 3.10$	11.0	$3.10 \leq \varnothing < 4.00$	12.0	$4.00 \leq \varnothing$	13.0	
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Leak-proof of assemblies	The tightness of an assembly is tested by injecting pressurized air at 4 bar into the product immersed in a water bath for 5 to 10 seconds. During this time no air bubble visible to unaided eye shall come off the assembly area.																					
Surface finishing	<p>Standard criteria for surface finishing for products manufactured by UNIMED:</p> <ul style="list-style-type: none"> - Machining surfaces roughness: Ra_{max} 0.8. - Surfaces smooth, without defect, homogenous, without coloration with an unaided eye visual verification at 30 cm. <p>Standard criteria for surface finishing for products manufactured by UNIMED:</p> <ul style="list-style-type: none"> - Cannula or stylet outer surface roughness: Ra_{max} 0.4. - Cannula inner surface roughness: Ra_{max} 1.6. - Cannula with thick wall inner surface roughness: Ra_{max} 3.2. - Ends can be deformed by cutting. (<i>for references 200.010 and 200.020</i>) - Surfaces smooth and without damage with an unaided eye visual verification at 30 cm. Surface marks from manufacturing of the raw material* are acceptable. <p><i>* Raw material is delivered under the following references: 200.010, 200.010-A, 200.010-R, 200.020 and 200.020-A</i></p>																					
Marking	<p>Needle: Marking of the outer diameter in mm and gauge.</p> <p>Other: No marking.</p>	No marking.																				
Labelling	<p>Label with the following information:</p> <ul style="list-style-type: none"> - Unimed logo and address. - Unimed reference. - Lot number. - Quantity. 																					
Packaging	<p>Packaging in carton box between douflines.</p> <p>Packaging in a dozen in plastic box per dozen.</p>	Packaging in carton box between douflines.																				
Shipping	<p>Product shipping:</p> <ul style="list-style-type: none"> - Incoterms: EXW - Shipping company: UPS Express Saver 																					

All this information are for reference only. They have no legal or contractual commitment Unimed SA.

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