

<b>SUBJECT</b>	<b>STANDARD SPECIFICATION</b>	<b>SHEET #</b>	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
<b>Strength of assemblies</b>	The assembling withstand (gluing, fit-pressing, soldering, welding) is characterized by the destructive seal strength.	
	<b>Cannula/stylet outer diameter</b> [mm]	<b>Minimum destructive seal strength</b> [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
<b>Leak-proof of assemblies</b>	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.	
<b>Surface finishing</b>	Standard criteria for surface finishing for products manufactured by UNIMED: <ul style="list-style-type: none"> <li>- Cannula or stylet outer surface roughness: <math>Ra_{max}</math> 0.4.</li> <li>- Cannula inner surface roughness: <math>Ra_{max}</math> 0.7.</li> <li>- Machining surfaces roughness: <math>Ra_{max}</math> 0.8.</li> <li>- Surfaces smooth, without defect, homogenous, without coloration with an unaided eye visual verification at 30 cm.</li> </ul>	
<b>Marking</b>	Needle: Marking of the outer diameter in mm and gauge. Other: No marking.	No marking.
<b>Labelling</b>	Label with the following information: <ul style="list-style-type: none"> <li>- Unimed logo and address.</li> <li>- Unimed reference.</li> <li>- Lot number.</li> <li>- Quantity.</li> </ul>	
<b>Packaging</b>	Packaging in carton box between douflines. Packaging in a dozen in plastic box per dozen.	Packaging in carton box between douflines.
<b>Shipping</b>	Product shipping: <ul style="list-style-type: none"> <li>- Incoterms: EXW</li> <li>- Shipping company: UPS Express Saver</li> </ul>	

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

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