

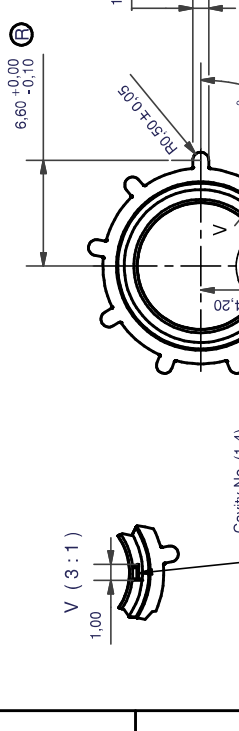
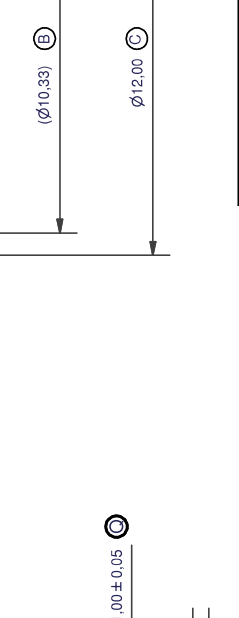
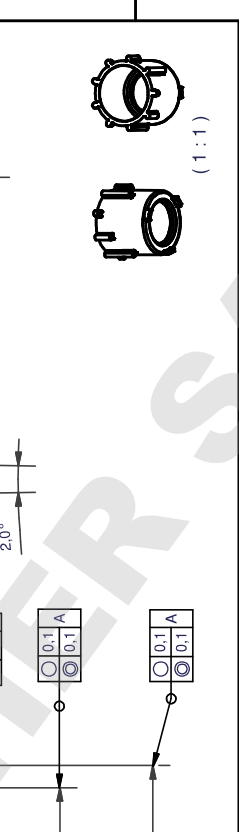
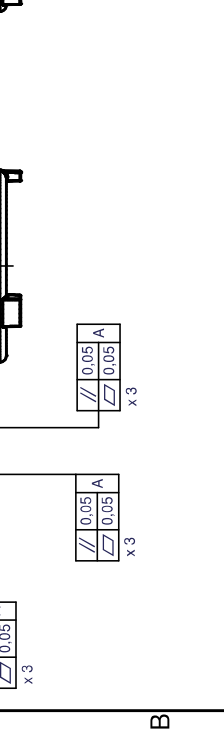
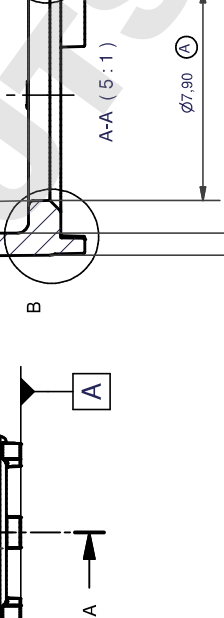
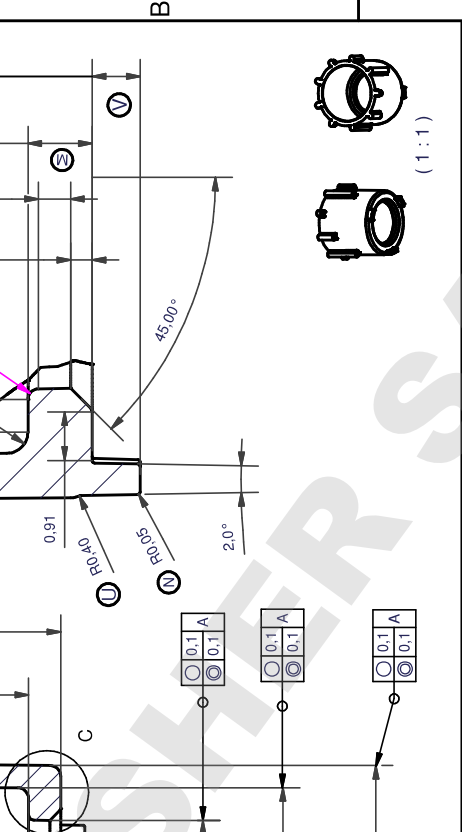
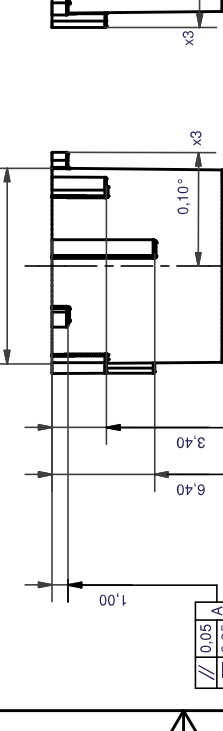
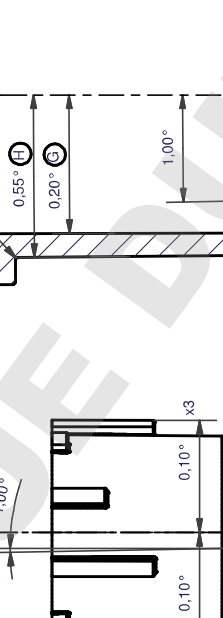
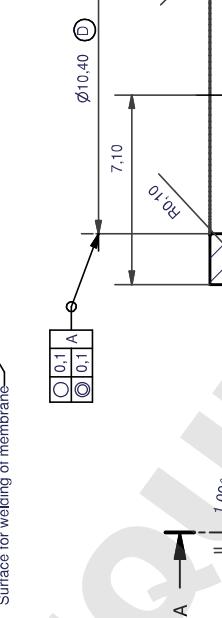
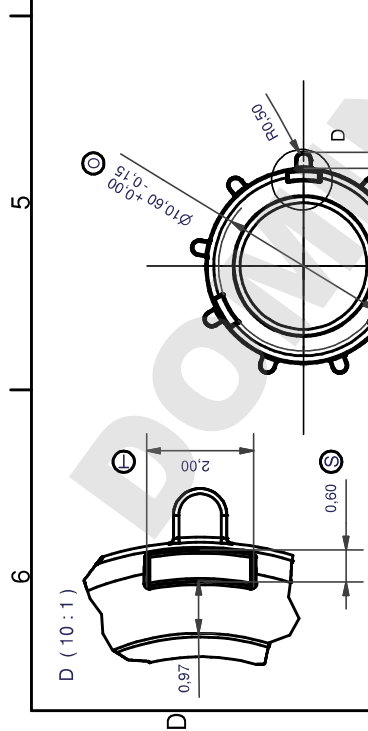
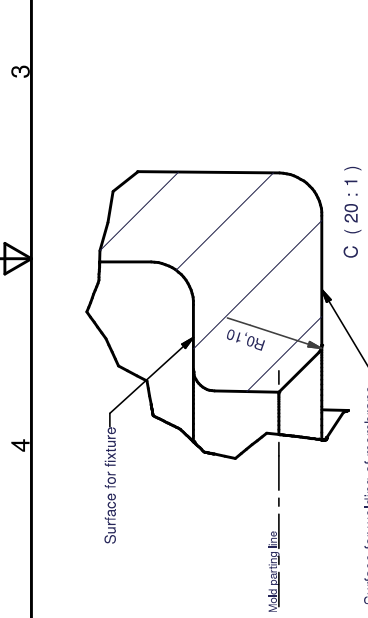
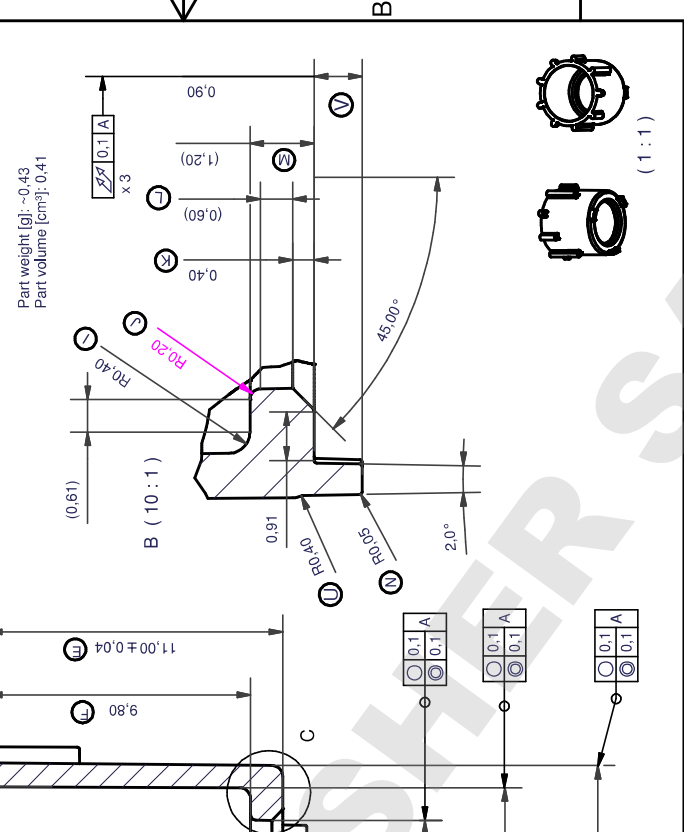
ZONE	REV	DESCRIPTION	DATE	APPROVED
N/A	1.0	Design Output	2005-02-07	kjp
D4	1.1	Weld director altered	2005-03-10	kjp
D4	1.2	Weld director removed	2005-06-02	kjp
B1	1.3	Measure M changed from 0.9 to 1.2mm Measure K changed from 0.3 to 0.6mm Measure V changed from 5 to 45 degree	08-03-2006	kjp
D5	1.3	Inlet lower removed	08-03-2006	kjp
B1	1.4	Measure K changed from 0.6 to 0.4mm	2006-03-15	kjp
N/A	1.5	Geometric tolerances altered the drawing	2006-04-02	kjp
N/A	1.6	Geometric tolerances changed to suppliers reported capability	2006-05-08	kjp
C4, C5	1.7	Draft on flanges changed according to supplier drawing	2006-10-06	brl
A5	1.7	Cavity no. added	2006-10-06	brl
N/A	1.8	Weld: Final design after final mould modifications	2007-05-03	brl

Tolerances unless otherwise specified:
 Without decimal [mm]: ±0.5
 One place decimal [mm]: ±0.1
 Two place decimal [mm]: ±0.05

Control measure for Cp/Cpk study:
 Measure: A

Measures & Tolerances to be found on drawing are on part basis - After finalized injection molding
 Measurement is given in SI Unit: [mm]

Part weight [g]: -0.43
 Part volume [cm³]: 0.41



Thermo Fisher
SCIENTIFIC

Roskilde Site - Kamstrupvej 90 - P.O.Box 280
 DK-4000 Roskilde - Denmark
 Tel +45 4631 2000 - Fax +45 4631 2042
 E-mail: info.nunc@thermofisher.com

www.nuncbrand.com

SUBJECT: 2nd gen TC insert for MD 24		CHANGE ORDER NO.:	VALID FROM:	APPROVED BY/DATE:	FORMAT:
DRAWN BY/DATE: KLP/2005-03-10		CO-1181	2008-06-04	HES-2008-05-14	A3
ITEM NUMBER:	MATERIAL:	DRAWING NO.:	VERSION:	PAGE TYPE:	SCALE:
	PS	3504	10	-M	3:1
METRIC mm 3:1					