

# PET (Polyethylene Terephthalate) Heat Shrink Tubing (PHST) Specification Standard Requirements for Webstore parts

<b>General Manufacturing Requirements/Conditions</b>	<ul style="list-style-type: none"> <li>Manufactured in an ISO 14644 Class 8 (Class 100,000) Controlled Environment (CE).</li> <li>All manufactured lots are lot controlled and fully traceable to the raw material polymer.</li> <li>All measurement equipment is calibrated and traceable to NIST standards.</li> <li>All manufacturing equipment is validated and on a regular PM schedule.</li> <li>Stored in conditions to protect from damage, heat, and moisture.</li> <li>Manufactured with no release agents or process agents.</li> </ul>
<b>Dimensional Requirements</b>	<ul style="list-style-type: none"> <li>ID and Wall thickness is inspected per the part specification.</li> </ul>
<b>Visual/Functional Requirements</b>	<ul style="list-style-type: none"> <li>Visual inspection is performed with the unaided eye under normal room lighting, at a distance of 12 – 18 inches.</li> <li>Free of cuts, tears, pinholes, or other obvious physical damage.</li> <li>Free of process aids, grease, oil, or dirt.</li> <li>Free of embedded particulate or loose particulate/contamination &gt; 0.2 mm<sup>2</sup></li> <li>Small kinks are acceptable and will “shrink out” of the tubing. Excessive kinking or full bends are unacceptable.</li> <li>Minor zipper lines/die lines are acceptable and will “shrink out of the tubing. Excessive zipper lines/die lines are unacceptable.</li> <li>Each lot is tested and guaranteed for its ability to shrink a minimum of 15% from the minimum ID.</li> </ul>
<b>Inspection Sampling</b>	<ul style="list-style-type: none"> <li>Each PHST/Cut Lot is inspected per Nordson MEDICAL’S standard sampling plan, unless otherwise specified (and agreed upon).</li> </ul>
<b>Packaging Requirements</b>	<ul style="list-style-type: none"> <li>PHST is packaged in a manner that provides adequate protection from damage and contamination during customary conditions of shipping, handling, and storage.</li> <li>Customer is responsible for all damage to shrink tubing that occurs during removal from the box. Nordson MEDICAL’s unboxing instructions must be followed.</li> </ul>
	<ul style="list-style-type: none"> <li>Each polybag/container of product is marked legibly with the following information: <ul style="list-style-type: none"> <li>Lot Number</li> <li>Item Number and Revision Level</li> <li>Quantity</li> </ul> </li> <li>The inner polybag/container is labeled with the product identification (unless otherwise specified).</li> </ul>
<b>Certificate of Compliance (C of C)</b>	<ul style="list-style-type: none"> <li>A signed and dated certification documenting the product’s conformance to the required specification accompanies each lot and contains the following information (at a minimum): <ul style="list-style-type: none"> <li>Statement of Compliance</li> <li>Product Description</li> <li>Item Number and Revision Level</li> <li>Reference Item Number (if applicable)</li> <li>Lot Number</li> <li>Quantity Shipped</li> <li>Signature of Quality Representative</li> </ul> </li> </ul>

REFERENCE: QA0033