



VALUE PLASTICS, INC.

A NORDSON COMPANY

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Product Change #: PCN221

Posting Date: *November 26, 2013*

Description of Change:

The geometry of the grip will be changed from a circular design to a rectangular design which will allow the parts to be sub-gated.

Reason:

The goal of this ECO is to improve the manufacturability of this part by switching from a tab gate to a sub gate tool design. A sub-gate will use the retraction of the tool to separate the part from the runner instead of a post-mold separation.

Parts Affected: (See Table 1 Below)

Effective Date: January 3, 2014

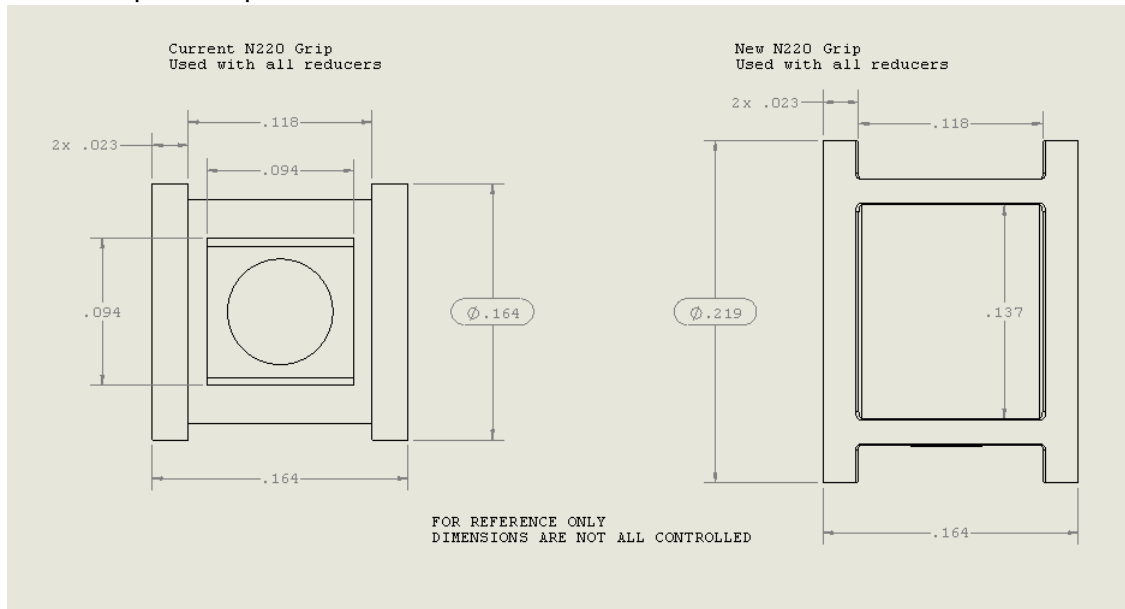
Implementation Procedure:

Rolling Change

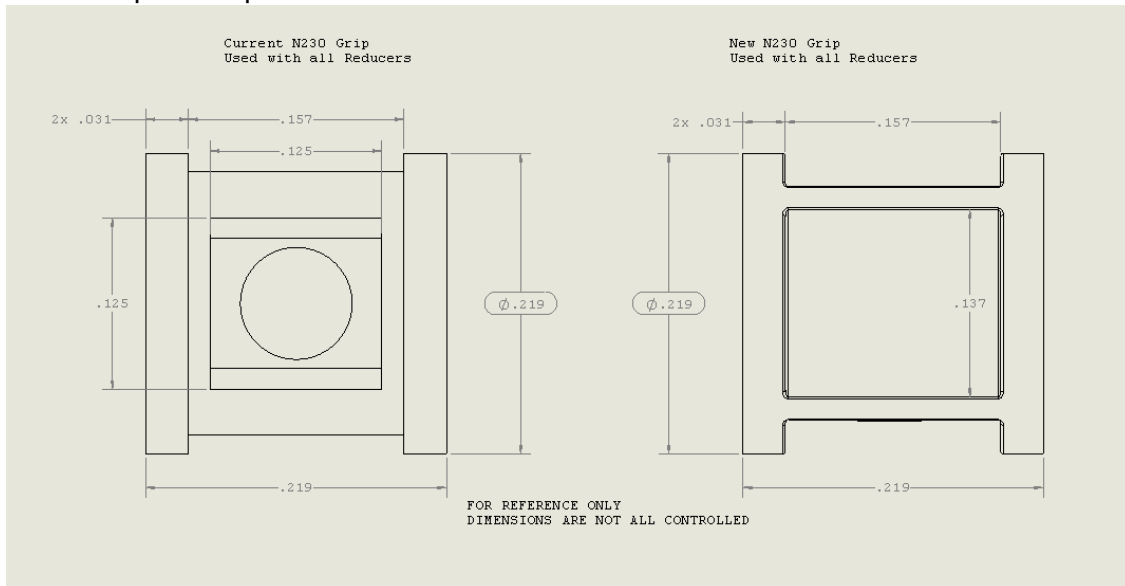
Table 1

N220-1	N230/210-1	N230/220-07	N220/210-1
N220-2	N230/210-2	N230/220-1	N220/210-2
N220-20	N230/210-6	N230/220-2	N220/210-6
N220-6	N230/210-6005	N230/220-20	N220/210-6005
N220-6005	N230/210-9	N230/220-6	N220/210-9
N220-9	N230/210-J1A	N230/220-6005	N220/210-J1A
N220-9002		N230/220-9	
N220-J1A		N230/220-J1A	CF471-65

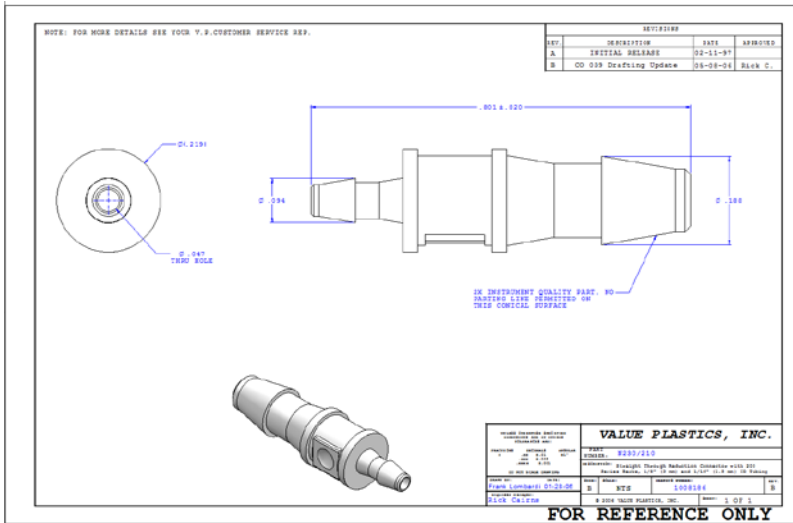
220 Grip Comparison



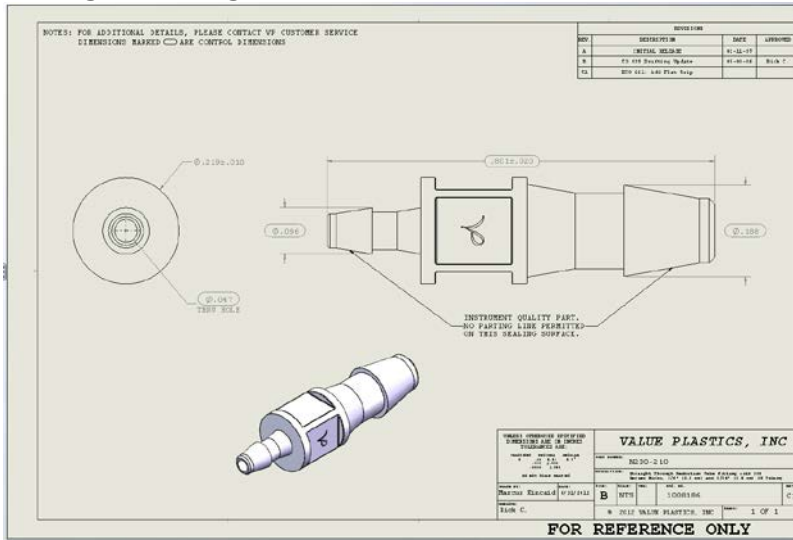
230 Grip Comparison



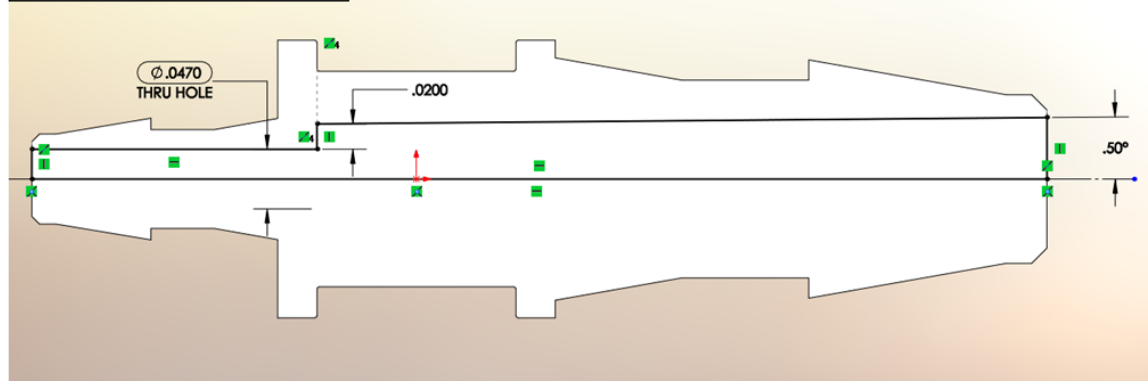
Current N230-210 CSP



Design Change Print for N230-210

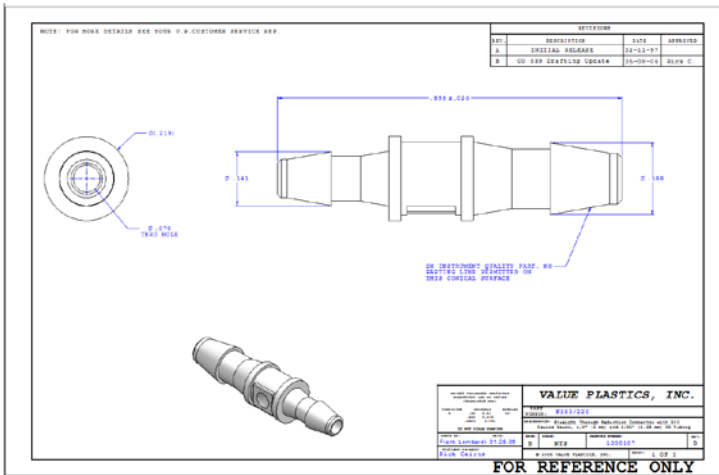


N230-210: New Features

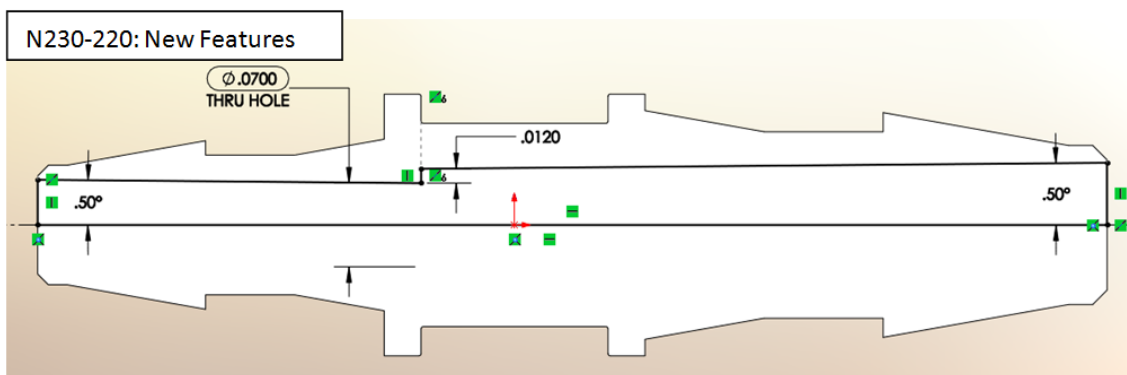
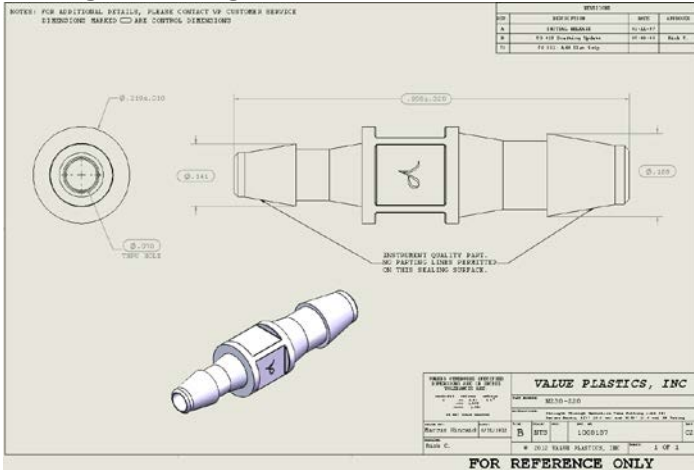


- 0.5 degree draft on 230 barb core pin. No draft on 210
- Offset core pins .005” per side with .015” chamfer (not shown)

Current N230-220 CSP



Design Change Print for N230-220



- 0.5 degrees draft on both core pins
- Offset core pins: 0.005" per side (0.007" chamfer not shown)

Current N220 CSP

NOTE: FOR MORE DETAILS SEE YOUR V.P. CUSTOMER SERVICE REP.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	INITIAL RELEASE	02-11-97	
B	CD 539 Drafting Update	08-28-04	Black C.

2X INSTRUMENT QUALITY PART. NO BANDING LINE PERMITTED ON THIS CONICAL SURFACE

VALUE PLASTICS, INC.	
PART NUMBER: N220 DESCRIPTION: Straight Through Connector with 200 Series Body, 3/32" (2.38 mm) ID Tubing	DATE: 08/28/04 DRAWN BY: NTS CHECKED BY: 1008149 PART: 1 OF 1

FOR REFERENCE ONLY

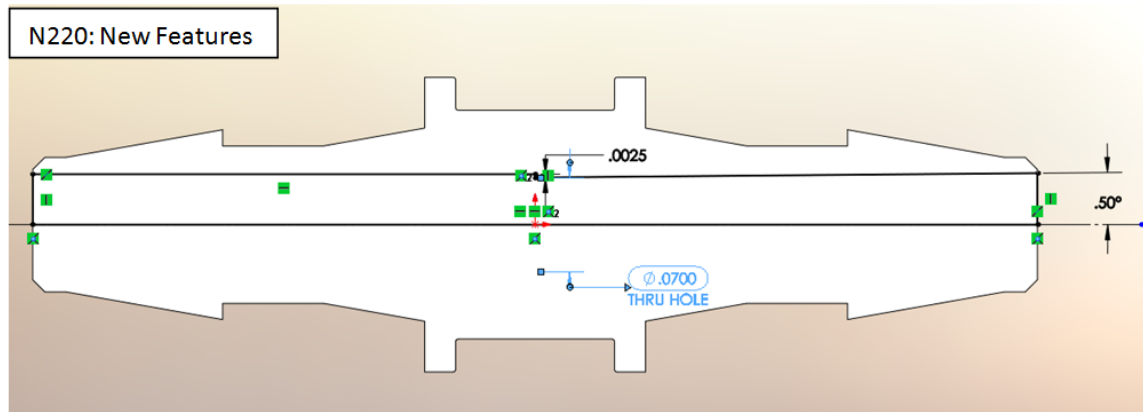
Design Change Print for N220

NOTES: FOR ADDITIONAL DETAILS, PLEASE CONTACT VP NEW PRODUCT DEVELOPMENT
DIMENSIONS HANGED \square ARE CONTROL DIMENSIONS

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	INITIAL RELEASE	01-11-97	
B	CD 519 Drafting Update	01-01-98	Black C.
CL	REV CALL: 846 Flap Strip		

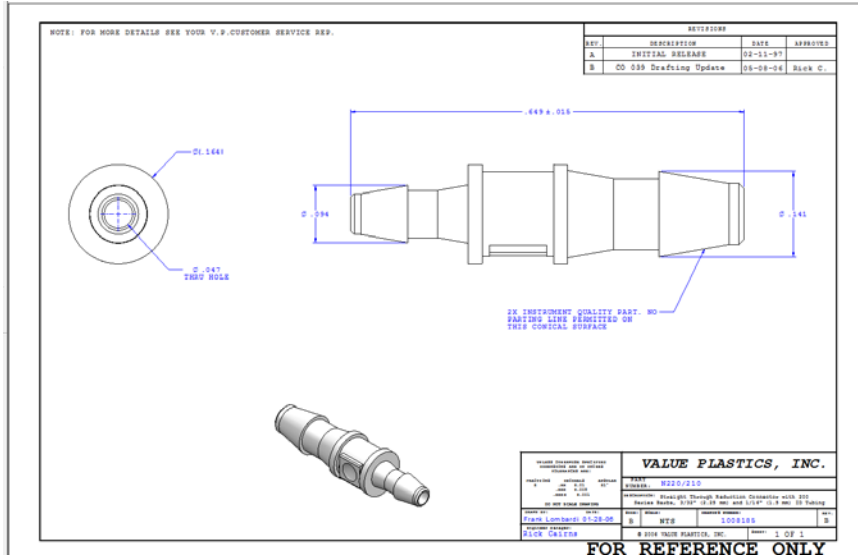
2X INSTRUMENT QUALITY PART. NO BANDING LINE PERMITTED ON THIS CONICAL SURFACE

VALUE PLASTICS, INC.	
PART NUMBER: N220 DESCRIPTION: Straight Through Tub. Flap Strip with 200 Series Body, 3/32" (2.38 mm) ID Tubing	DATE: 01/01/98 DRAWN BY: NTS CHECKED BY: 1008149 PART: 1 OF 1

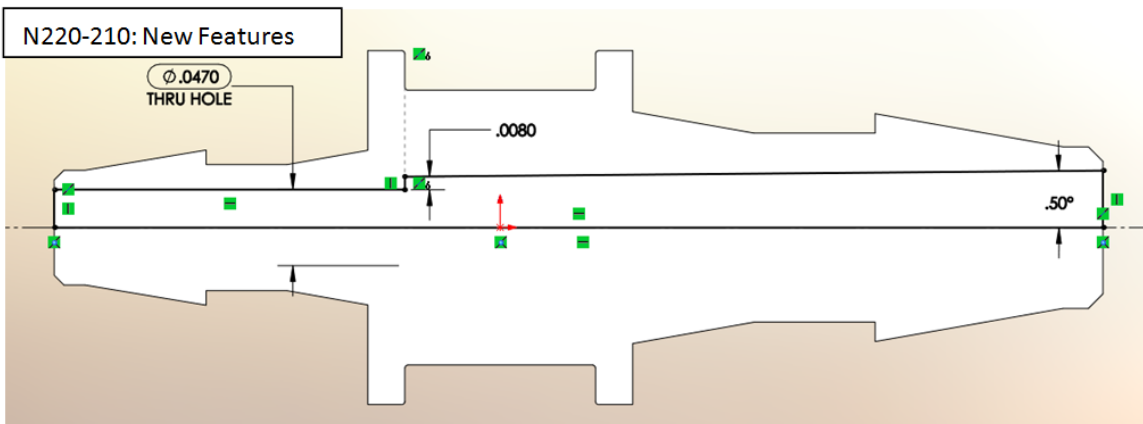
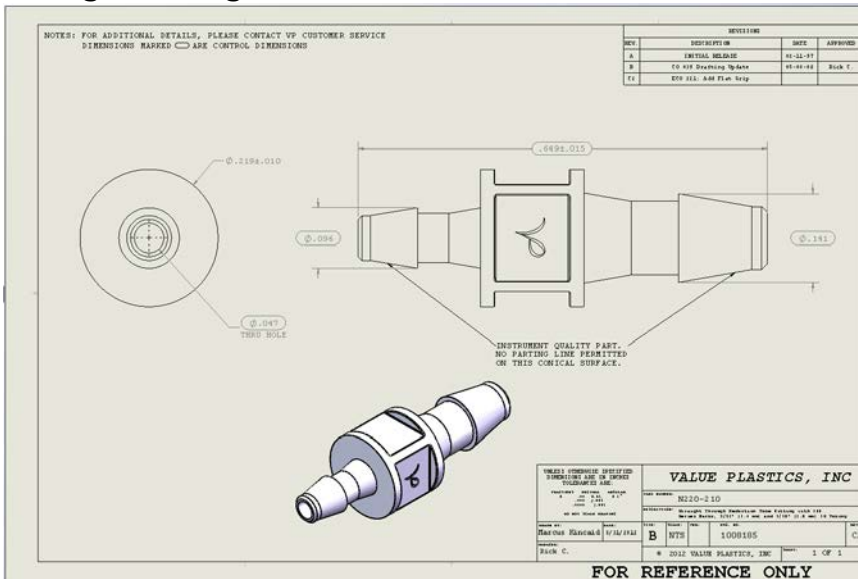


- 0.5 degree draft on half of part.
- Offset core pins: 0.0025" per side

Current N220-210 CSP

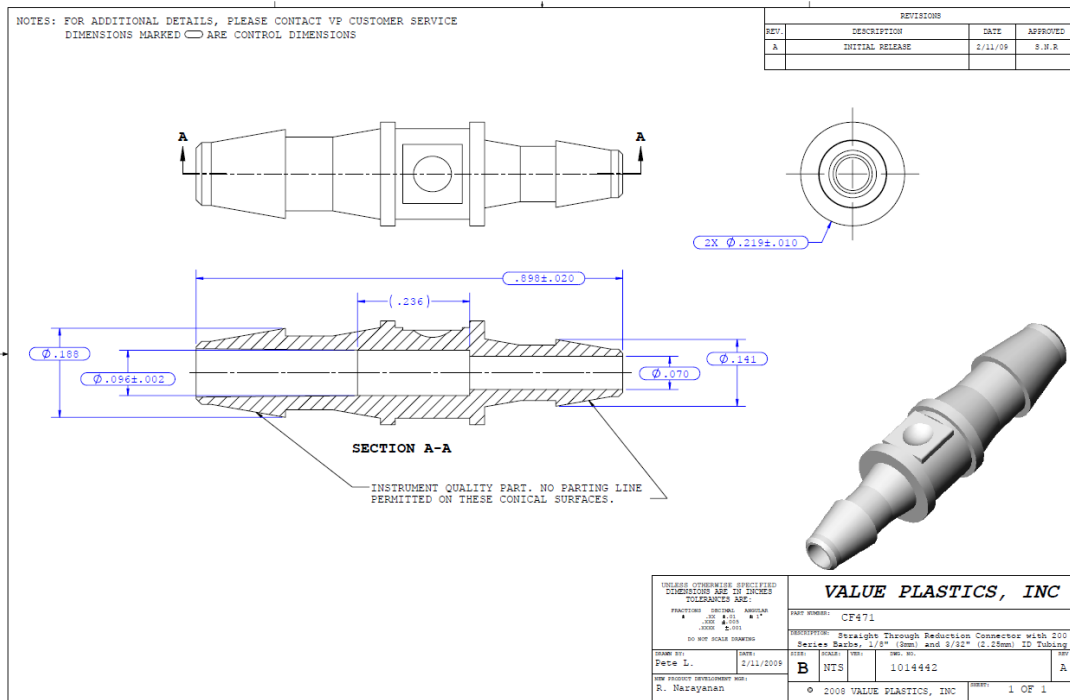


Design Change Print for N220-210



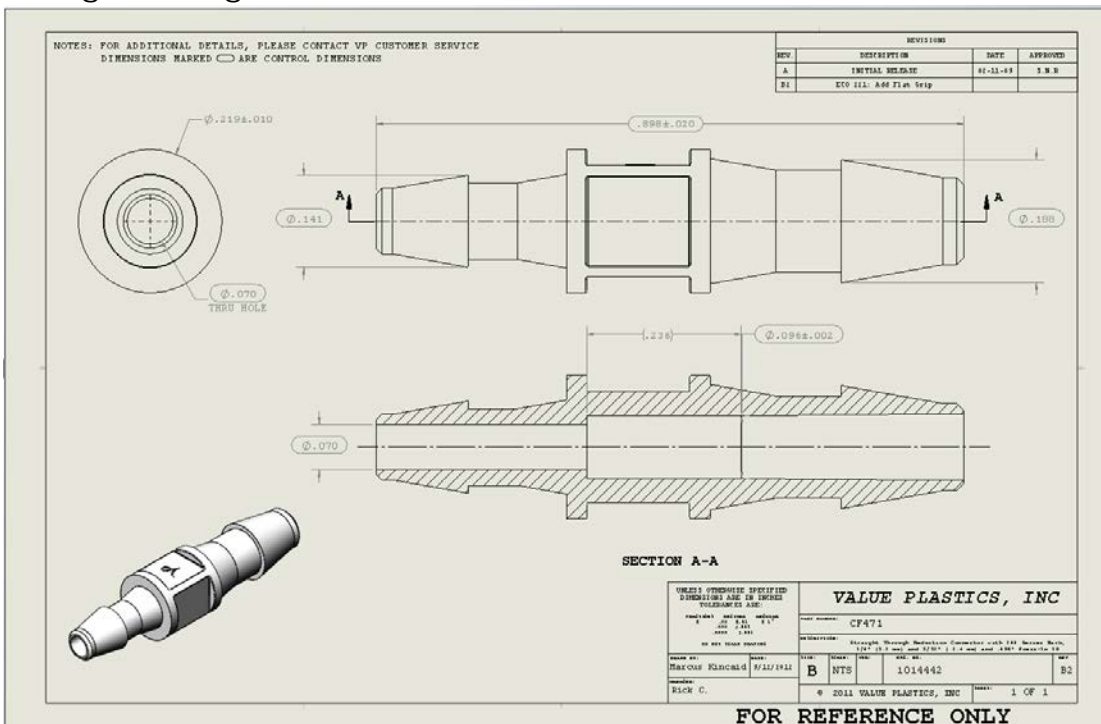
- 0.5 degree draft on 220 barb core pin. None on 210 core pin.
- Offset core pins: .005" per side with .003" chamfer

Current CF471 CSP



FOR REFERENCE ONLY

Design Change Print for CF471



FOR REFERENCE ONLY