INJECTION PORT AND METHOD OF MAKING THE SAME

Abstract: An injection port for an intravenous bag including a generally hollow tube that is mountable to the intravenous bag. The hollow tube has a first end. A polymeric plug is mounted in the first end. The polymeric plug is integrally molded into the tube proximate to the first end. A method for construction the injection port including injecting a first molding material into a mold cavity, allowing the first molding material to at least partially cure and harden, moving a movable mold part to expose a first cavity defined by inner surfaces of the at least partially cured and hardened molding material, injecting a second mold material into the first cavity, allowing the second molding material to at least partially cure and harden such that the second molding material bonds with the inner surfaces and removing the injection port from the mold.
Published: with international search report

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For two-letter codes and other abbreviations, refer to the "Guidance Notes on Codes and Abbreviations" appearing at the beginning of each regular issue of the PCT Gazette.
INTERNATIONAL SEARCH REPORT

A. CLASSIFICATION OF SUBJECT MATTER
   IPC: A61M 31/00(2006.01); B29B 7/00(2006.01); B65D 33/00(2006.01); A61B 19/00(2006.01); B29C 33/40(2006.01)
   USPC: 604/408,6,16,403; 264/225,328,8,383/96; 128/DIG24
   According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED
   Minimum documentation searched (classification system followed by classification symbols)
   U.S.: 604/408,6,16,403; 264/225,328,8,383/96; 128/DIG24

   Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

   Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)
   EAST: port, plug or septum, elastomer, diaphragm, bag or container, injection molding.

C. DOCUMENTS CONSIDERED TO BE RELEVANT

<table>
<thead>
<tr>
<th>Category</th>
<th>Citation of document, with indication, where appropriate, of the relevant passages</th>
<th>Relevant to claim No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>X</td>
<td>US 3,064,652 A (CORCORAN et al.) 20 November 1962 (20.11.1962), entire document.</td>
<td>'1, 2, 8, 10-14, 17, 18, 26-29</td>
</tr>
<tr>
<td>Y, P</td>
<td></td>
<td>6, 9, 14, 17-19, 26-29</td>
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<tr>
<td>A</td>
<td>US 4,794,750 A (SCHMIDT et al.) 03 January 1989 (03.01.1989), entire document.</td>
<td>1, 2, 20-27</td>
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<tr>
<td>A</td>
<td>US 3,184,524 A (WHITEFORD) 18 May 1965 (18.05.1965), entire document.</td>
<td>20-26</td>
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☑ Further documents are listed in the continuation of Box C. ☐ See patent family annex.

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