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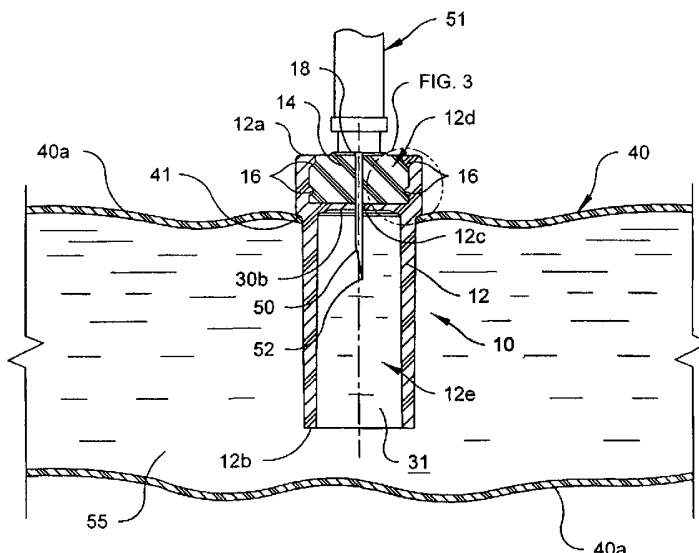
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[Continued on next page]

(54) Title: INJECTION PORT AND METHOD OF MAKING THE SAME



(57) 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 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.

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**INTERNATIONAL SEARCH REPORT**

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**A. CLASSIFICATION OF SUBJECT MATTER**  
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**B. FIELDS SEARCHED**

Minimum documentation searched (classification system followed by classification symbols)  
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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**

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 3,064,652 A (CORCORAN et al.) 20 November 1962 (20.11.1962), entire document.	1, 2, 8, 10-14, 17, 18, 26-29
X	US 4,479,989 A (MAHAL) 30 October 1984 (30.10.1984), entire document.	1-19, 26-29
X, P --- Y, P	US 6,720,044 B2 (ANDERSSON et al.) 13 April 2004 (13.04.2004), entire document.	1-5, 8, 10-13 ----- 6, 9, 14, 17-19, 26-29
A	US 4,794,750 A (SCHMIDT et al.) 03 January 1989 (03.01.1989), entire document.	1, 2, 20-27
A	US 5,695,706 A (WELSH et al.) 09 December 1997 (09.12.1997), entire document.	20-25
A	US 3,184,524 A (WHITEFORD) 18 May 1965 (18.05.1965), entire document.	20-26

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