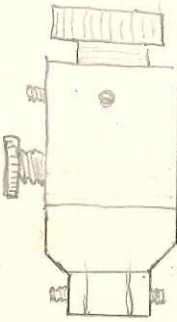
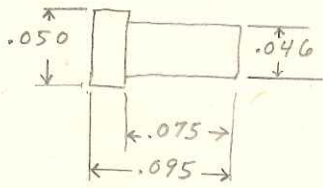


FRONT .190
PIPETTE HOLDER
.190 FRONT .084 REAR
WITH TEFLON SEAL

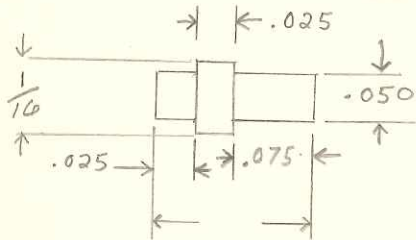


Perfusion End
Piece #1
Sylgard Holding
Pipette



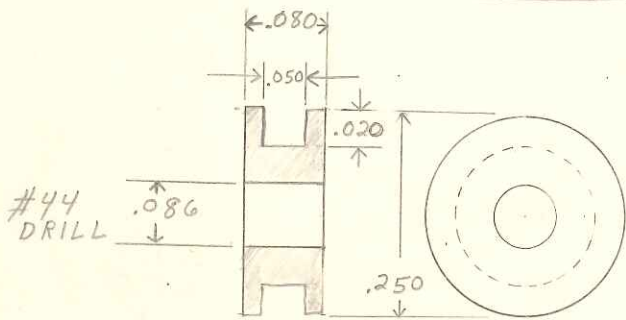
303 STAINLESS

2 PER.



303 STAINLESS

2 PER.

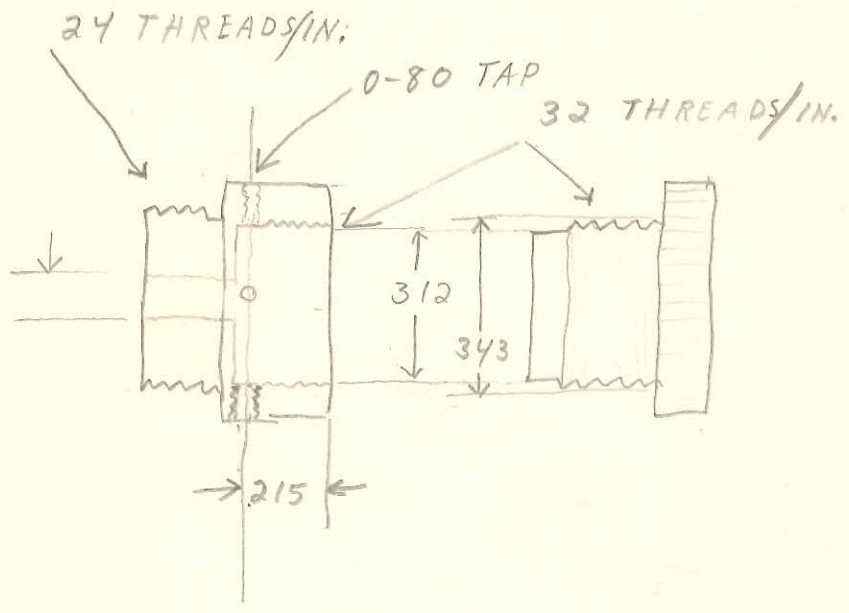


PLEXIGLAS
1 PER.



.010 S.S. SPRING WIRE
WIND ON A #60 DRILL
(.040)

2 PER.



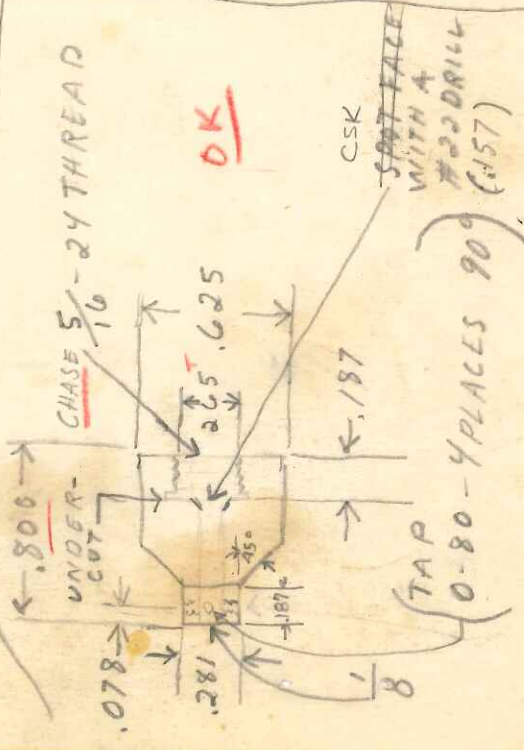
FRONT
GUIDE

#1

SEAL SILICONE
1 REAR

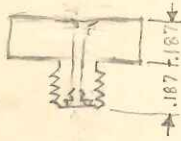
MATERIAL

LUCITE



SEE SMALL SKETCH
BELOW

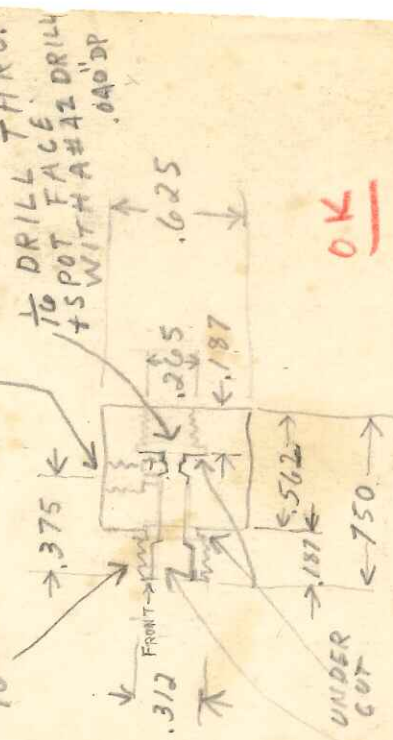
#55 DRILL
THRU



#2

LUCITE

CHASE
5/16 24 THREAD



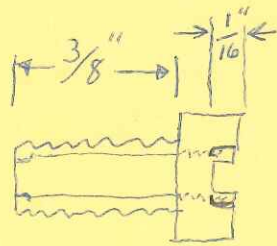
#55 DRILL TO 1/8"
CENTER HOLE THEN
5/32 END MILL
.200 DEEP Y TAP
(10-32)

1/8 DRILL 13/32 DEEP Y COUNTER DRILL
WITH #22 DRILL (.157) .225 DEE
.093

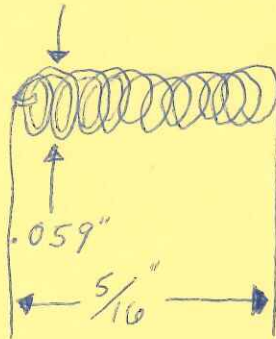
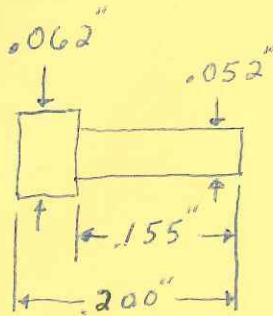
PLUNGER & SPRING
ASSEM. # 1

001 B

3-56 FIL. HD. SCREW S.S.



DRILL #55 (.052) THRU, DRILL # 1/16 (.0625) TO WITHIN 1/32 OF TIP, COUNTER-DRILL #49 DRILL (.073) 1/16 DEEP + TAP 5/64 DEEP, WITH 1-72 TAP.



.010 S.S. SPRING WIRE
16 TURNS ON A #60 DRILL (.040)

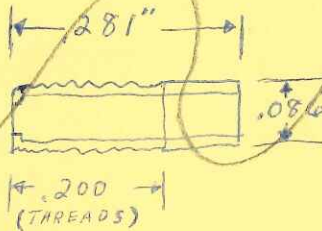
MAKE FROM
PLUNGER & SPRING
ASSEM. # 2

3-56

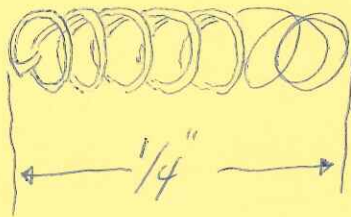
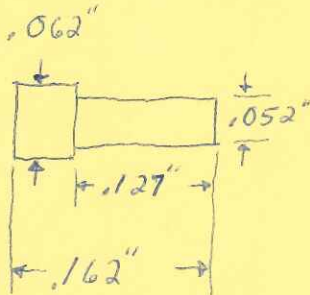
~~2-64~~ FIL. HD. SCREW

DRILL #55 (.052) THRU

DRILL # 1/16 (.0625) TO WITHIN 1/32 OF TIP



.010 S.S. SPRING WIRE
12 TURNS ON A #60 DRILL (.040)



Plunger fits into Lucite pipette holder in place of the above drilled 3-56 screws

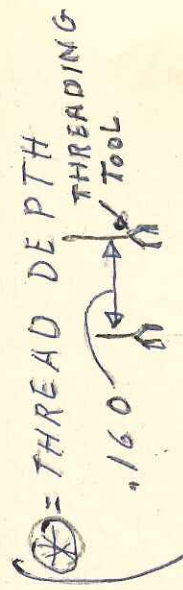
PERFUSION SIDE

NOTE! SIDE ARM OPENING TO BE 45° FROM VERTICAL *

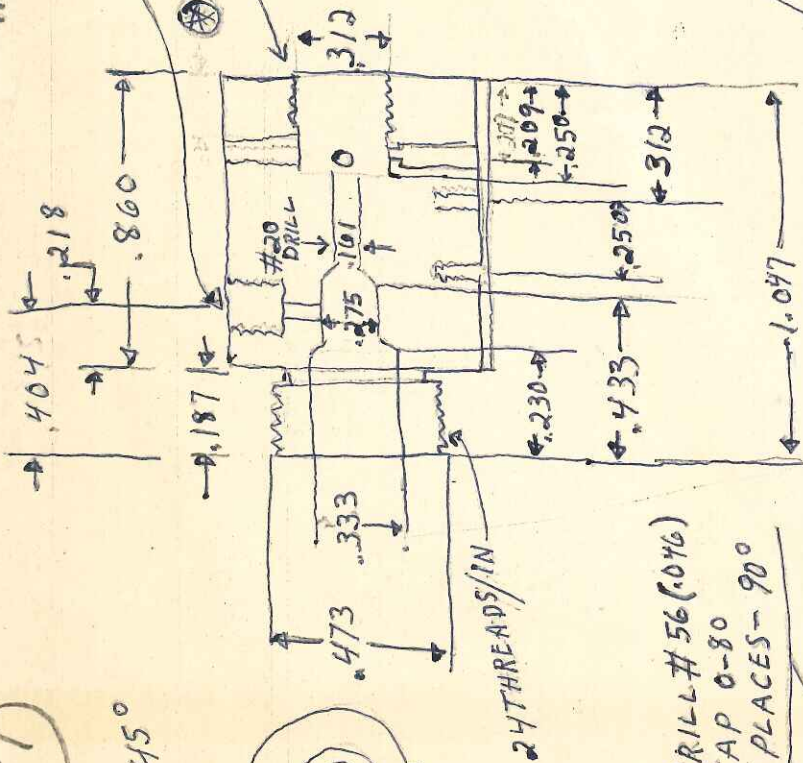
#55 DRILL (.052) TO .275 DIA., 5/32 END MILL
.125 DEEP & TAP 10-32 THREAD

32 THREADS / INCH (CHASE)
DRILL #45 (.082) TO EDGE OF .312 BORE & TAP
3-56 NOT QUITE THROUGH TO CENTER BORE

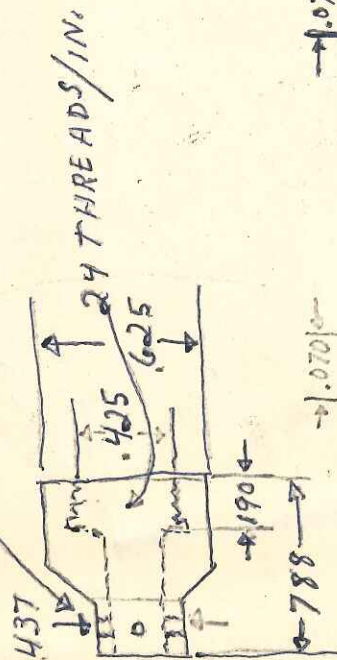
DRILL #55 (.052) THROUGH TO CENTER
OPENING & COUNTER DRILL WITH #1/16 TO
WITHIN 1/32 OF GOING THROUGH. (OR COUNTER BORE .180
DEEP WITH 1/16 DRILL)



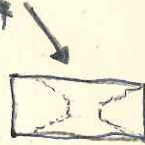
PIECES #1
Sylgard Holding
Sylgard Pipe



DRILL #56 (.046)
TAP 0-80
4 PLACES - 90°



#46 DRILL (.081)



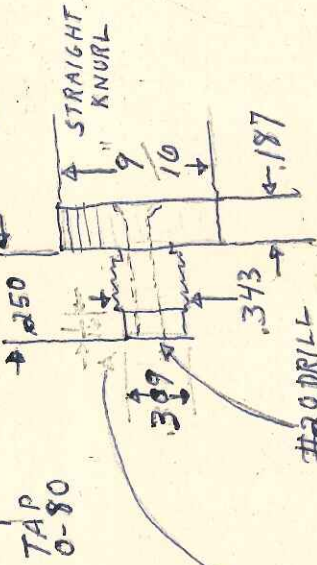
TEFLON
SLIP SEAL
FIT INTO
S.S. RIM

PERFUSION SIDE

#3 DRILL
(.213)

S.S. RIM.

CHASE 32 THREADS / INCH

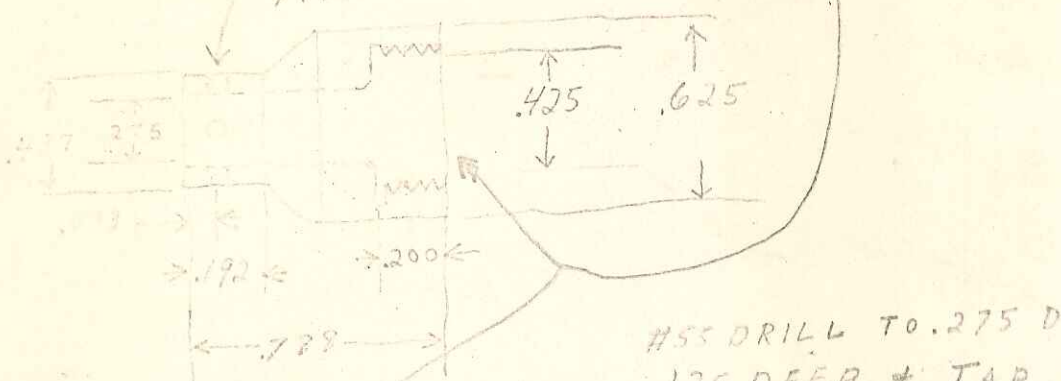


10

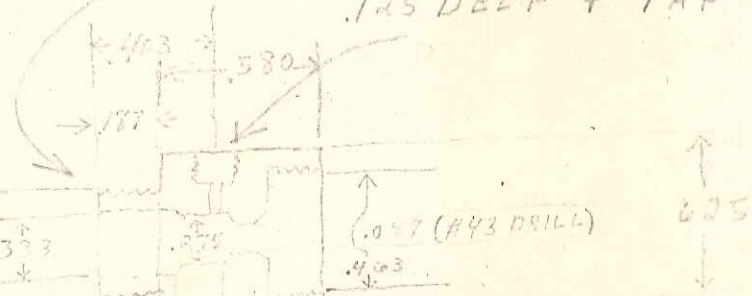
Piece #1

DRILL #56 (.046)
4 TAP 6-80
4 PLACES - 90°

THREADS 24/INCH



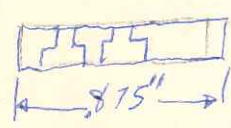
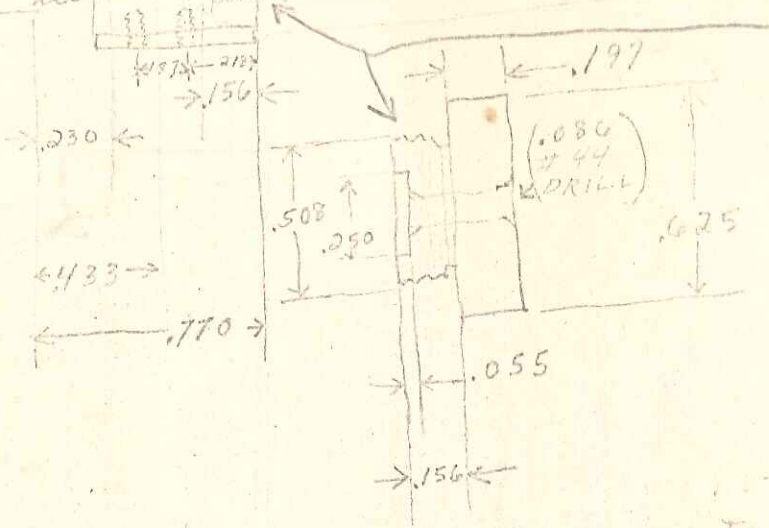
HSS DRILL TO .275 DIA: $\frac{5}{32}$ END MILL
.125 DEEP + TAP 10-32 THREE



THREADS 24/in



DRILL #50 (.070)
TAP 2-56



TEFLON SEAL

a = DRILL #4
(.086) & ROLL
OUTER EDGE WITH
BURNISHING TOOL
TO SEAL .055
PIPETTE TUBE

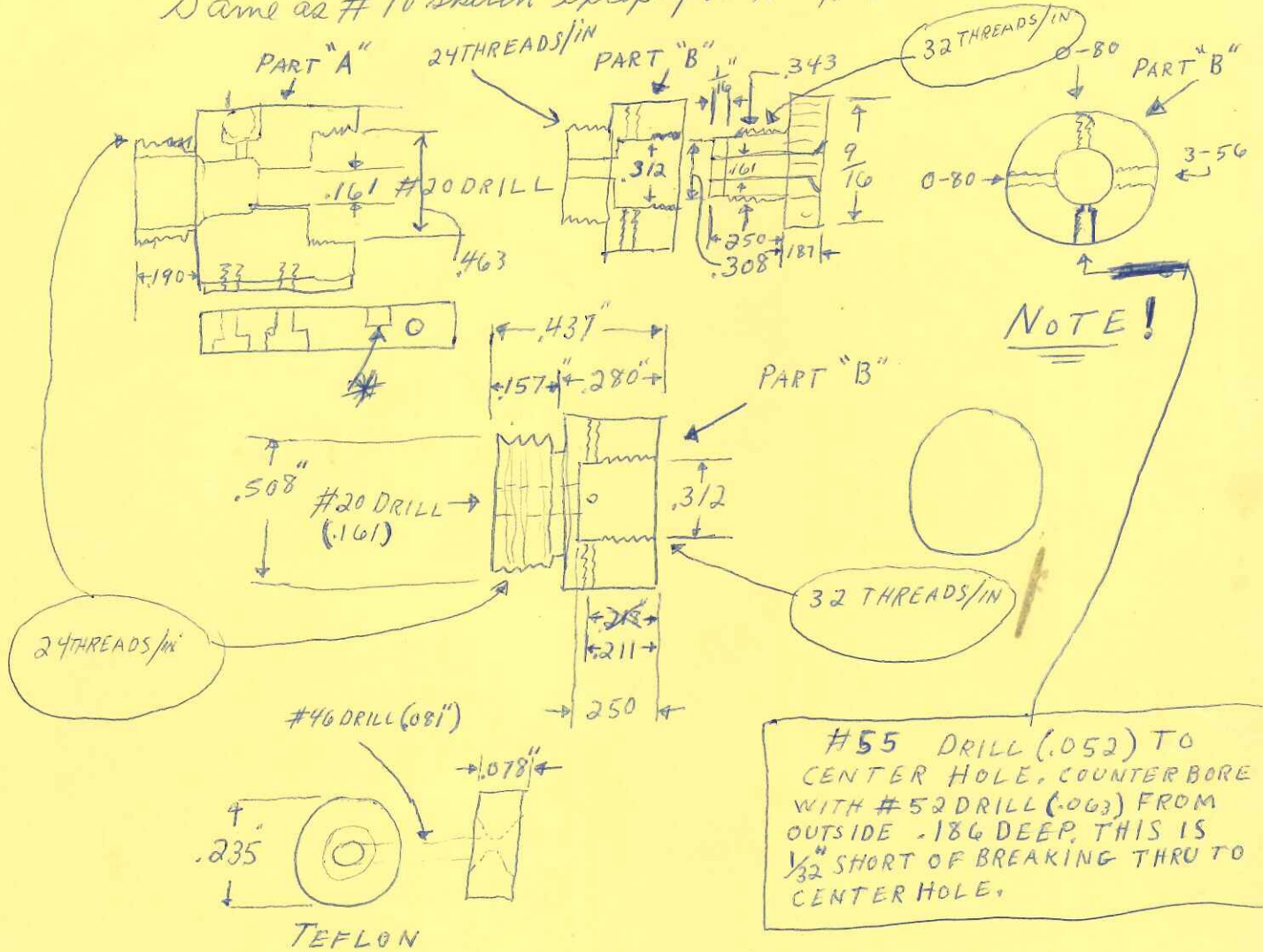


TAP 10-32
ENDING STOCK
1.000

001 A

DR. BURG 3/24/71
J.W.

Same as #10 sketch except for the #20 drilled hole



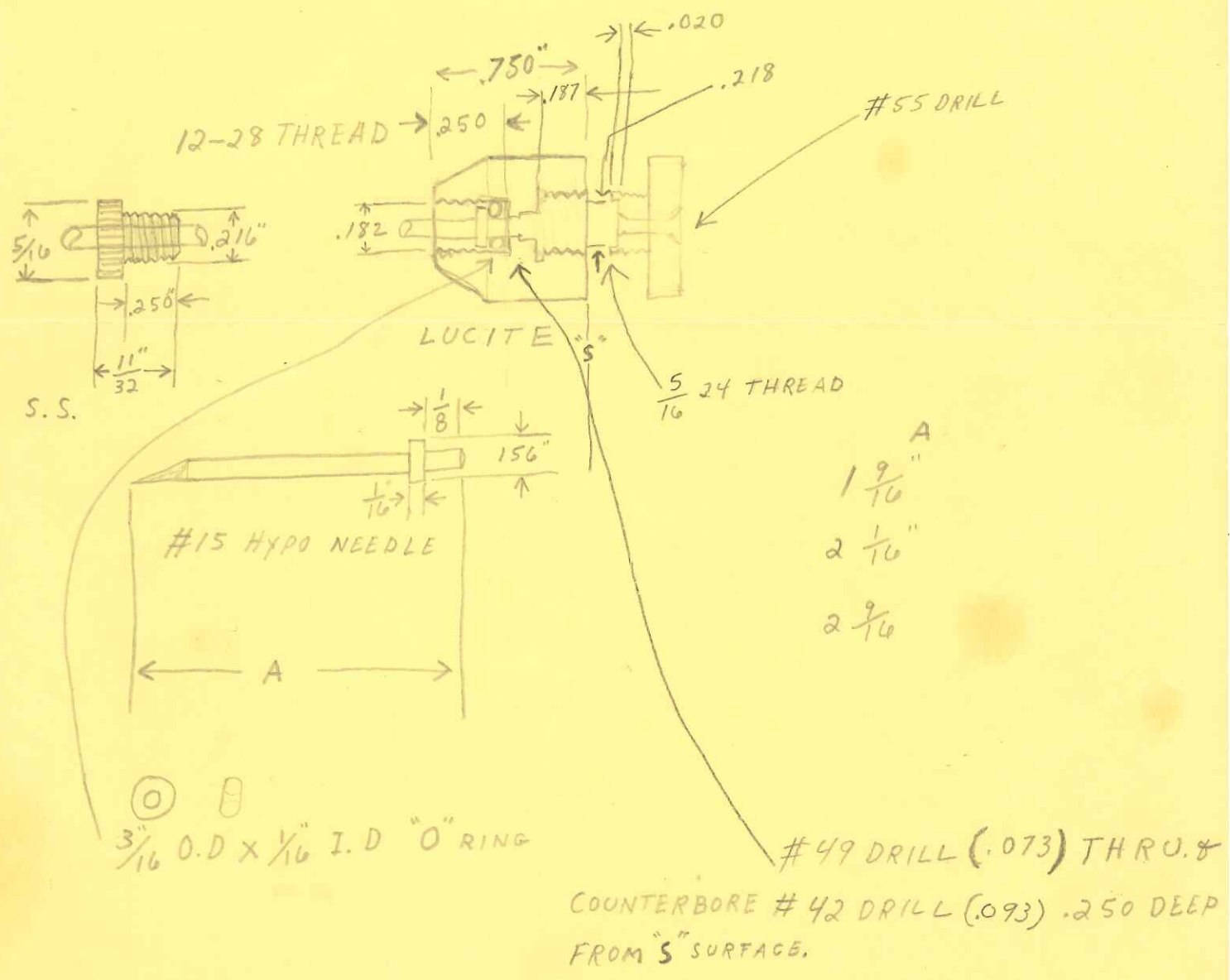
NOTE!

PART "B" MUST BE ASSEMBLED TIGHT TO PART "A" BEFORE DRILLING FOR TAPPED HOLES. THE #2 SPRING ASSEM. IS HELD IN PLACE BY THE HOLE MARKE "*" IN THE DRIVE GUIDE.

piece #1

Dr. Gauras

The front hypo needle holder, with the Teflon seal, as pictured below + a #3 pipette holder, same as used by Dr Burg, together with a five inch drive adapts the original design to Dr Gauras's use.



FRONT PIPET HOLDER

#1

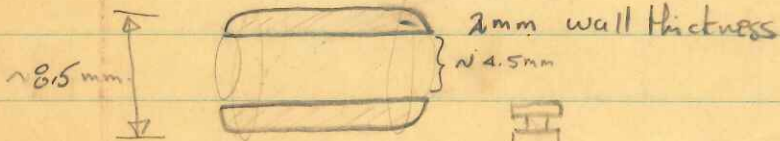
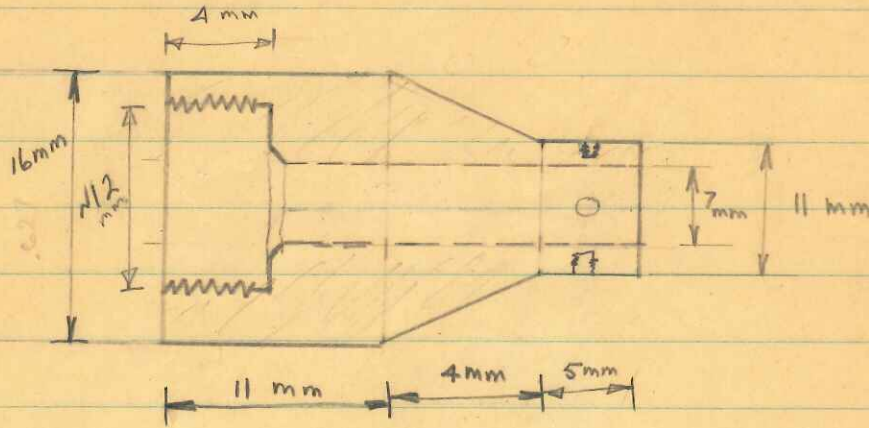
Hellman 11/27/67

make - 1

(1 each - 6 Pcs)

Oil pipet

721219



Rubber gasket

