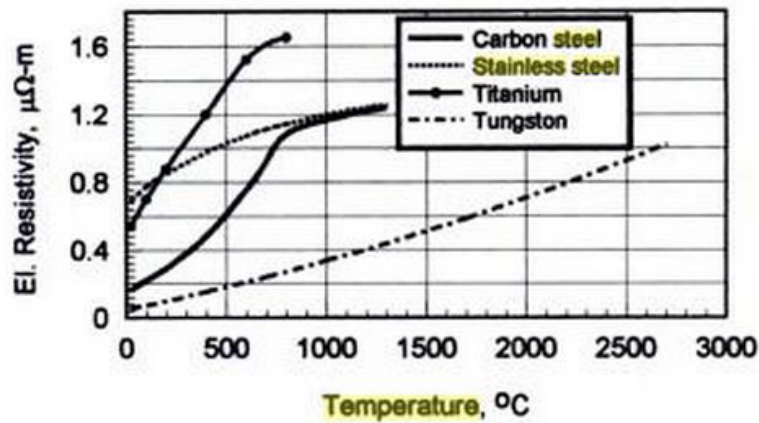


ANEXOS

Anexo 1: Comportamiento de la resistividad del acero con la temperatura



Sacado de Handbook of Induction Heating, Valery Rudnev

Anexo 2 : Tabla con especificaciones del endoscopio 1TQ160 de Olympus

Tabla de anexos 1 - especificaciones del endoscopio 1TQ160

GIF-1TQ160		
Sistema Óptico	Campo de Visión	140°
	Profundidad Visual	3 ~ 100mm
	Dirección Visual	0° (hacia adelante)
Extremo Distal	Diámetro Exterior	10.9mm
Tubo de Inserción	Diámetro Exterior	11.3mm
Sección de Doblado	Rangos de Doblado	210° arriba / 90° abajo 100° izquierda / derecha
Longitud de Trabajo		1,030mm
Longitud Total		1,340mm
Canal de Instrumentos	Diámetro Interior	Ø3.7mm
	Mínima Distancia Visible	4mm desde el extremo distal
	Posición de Entrada / Salida del accesorio de endoterapia en el campo de visión	

Referencia: <https://medical.olympusamerica.com/products/gastroscope/evis-exera-gif-1tq160>

Anexo 3 : Tabla con especificaciones parileno N y C

Tabla de anexos 2 - Tabla con especificaciones parileno N y C

Data recorded following appropriate ASTM methods

	Parylene N	Parylene C
Typical Physical and Mechanical Properties		
Tensile Strength, psi	6,500	10,000
Tensile Strength, MPa	45	69
Yield Strength, psi	6,300	8,000
Yield Strength, MPa	2,400	3,200
Elongation at Break, %	40	200
Density, g/cm ³	1.110	1.289
Coefficient of Friction:		
static	0.25	0.29
dynamic	0.25	0.29
Water Absorption, % (24 hr)	0.01 (0.019*)	0.06 (0.029*)
Index of Refraction, n _D ²³	1.661	1.639
Typical Electrical Properties		
Dielectric Strength, short time (Volts/mil at 1 mil)	7,000	6,800
Volume Resistivity, 23°C, 50% RH (Ohm-cm)	1x10 ¹⁷	6x10 ¹⁶
Surface Resistivity, 23°C, 50% RH (Ohm-cm)	1x10 ¹⁵	1x10 ¹⁵
Dielectric Constant:		
60 Hz	2.65	3.15
1,000 Hz	2.65	3.10
1,000,000 Hz	2.65	2.95
Dissipation Factor:		
60 Hz	0.0002	0.020
1,000 Hz	0.0002	0.019
1,000,000 Hz	0.0006	0.013
Typical Barrier Properties		
Gas Permeability*		
Nitrogen	7.7	0.95
Oxygen	30	7.1
Carbon Dioxide	214	7.7
Hydrogen Sulfide	795	13
Sulphur Dioxide	1,890	11
Chlorine	74	0.35
Moisture Vapor Transmission**	1.50	0.14
Typical Thermal Properties		
Melting Temperature (°C)	410	290
Linear Coefficient of Expansion (10 ⁻⁵ /°C)	6.9	3.8
Thermal Conductivity, 10 ⁻⁴ (cal/sec)/(cm ² , °C/cm)	3	2

NOTES:

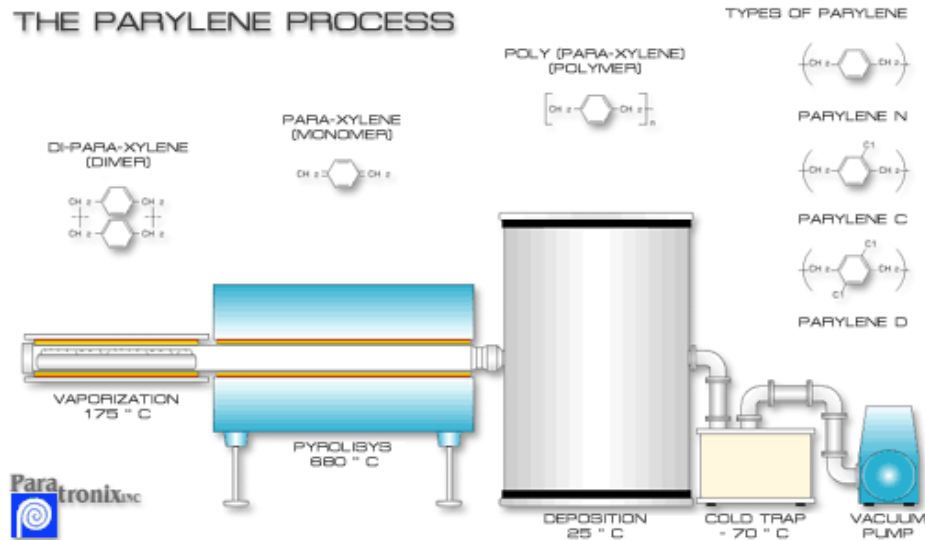
* cm³-mil/100 in²-24hr-atm (23°C)

** g-mil/100 in²-24hr, 37°C, 90% RH

1 mil = 1/1000 in. = 25.4 microns

Referencia: http://www.vp-scientific.com/parylene_properties.htm

Anexo 4 : Esquema del proceso de deposición del parileno



Referencia: www.paratronix.com

Anexo 5 : Determinación de coeficientes de fatiga

Gráfico de anexos 1: Coeficiente o factor de superficie.

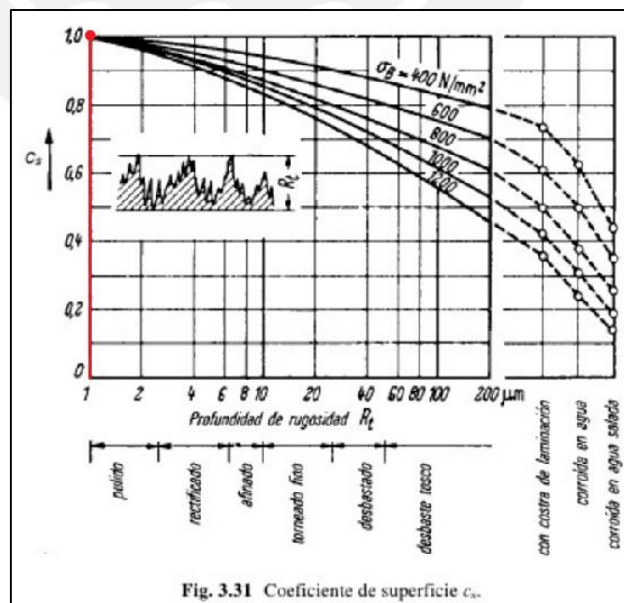


Gráfico de anexos 2: Coeficiente o factor de tamaño.

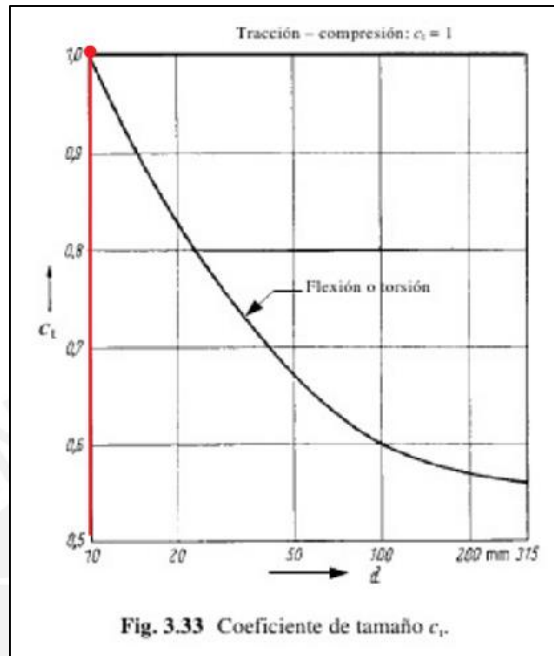


Fig. 3.33 Coeficiente de tamaño c_t .

Gráfico de anexos 3: Coeficiente o factor de temperatura.

Tabla 3.4 Factor de temperatura c_{temp}

T (°C)	c_{temp}
20	1,000
50	1,010
100	1,020
150	1,025
200	1,020
250	1,000
300	0,975
350	0,927
400	0,922
450	0,840
500	0,766
550	0,670
600	0,546

Tabulando para 270°C
el coeficiente será de 0.987

[Ref.: Joseph Stigley & Larry Mitchell. Diseño en Ingeniería Mecánica]

Gráfico de anexos 4: Coeficiente o factor de carga.

Tabla 3.5 Factor de carga c_{carg}

Tipo de carga	c_{carg}
Flexión	1,0
Axial	0,85
Torsión	1,00

[Ref.: Ch. Lipson & R. Javinal: Handbook of Stress and Strength]

Gráfico de anexos 5: Determinación de $B_k(0,2)$ para hallar BK

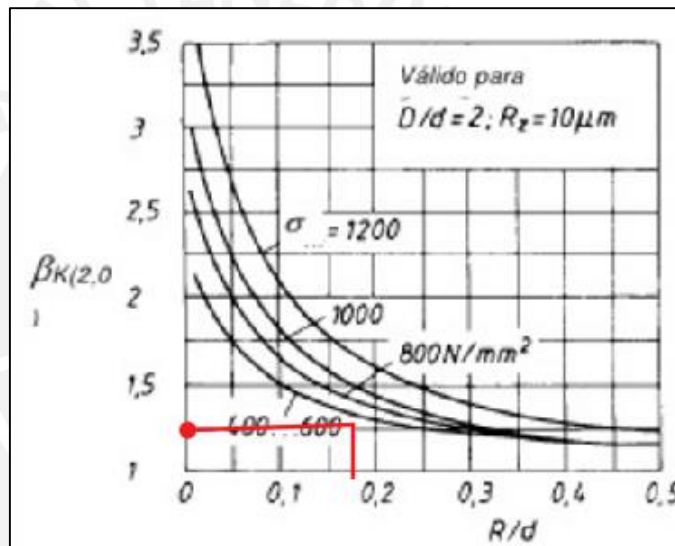
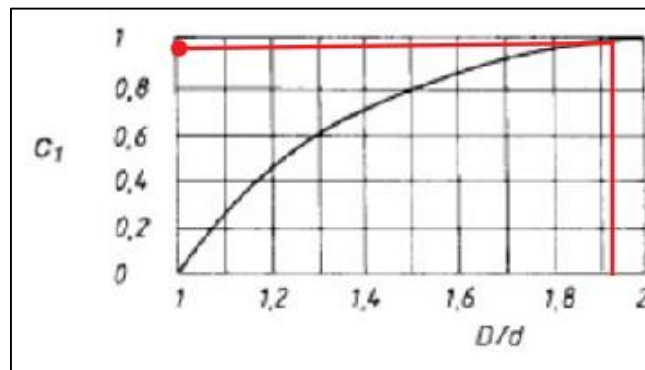


Gráfico de anexos 6: Determinación de C_1 para hallar BK.



Anexo 6 : Tabla con los módulos elásticos de materiales biocompatibles naturales y sintéticos

Tabla de anexos 3 - Módulos elásticos de materiales biocompatibles naturales y sintéticos

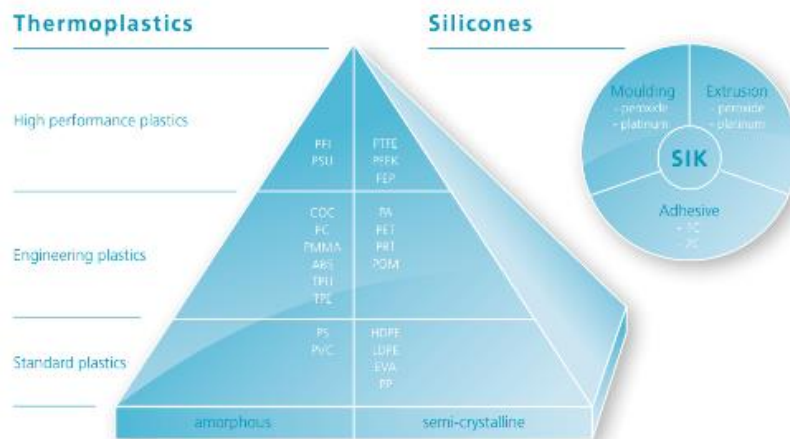
Joint material	Elastic modulus	
	GPa	10 ⁶ psi
Articular cartilage	0.001–0.17	0.000145–0.0247
PTFE	0.5	0.07
UHMWPE	0.5	0.07
Bone cement (PMMA)	3.0	0.44
Bone	10–30	1.45–4.35
TNZT alloys	55–66	7.9–9.6
“New generation” β-Ti alloys	74–85	10.7–12.3
Ti-6Al-4V alloy	110	16
Zirconia	200	29
Stainless steel	205	30
Co-Cr-Mo alloy	230	33
Alumina	350	51

PTFE, polytetrafluoroethylene; UHMWPE, ultrahigh molecular weight polyethylene; PMMA, polymethyl methacrylate; TNZT, titanium-niobium-zirconium-tantalum. Source: Ref 14

Referencia: Joining and Assembly of Medical Materials and Devices, N Zhou.

Anexo 7 : Clasificación de los polímeros biocompatibles

RAUMEDIC Polymer portfolio



Referencia: https://www.raumedic.com/fileadmin/user_upload/PDF/tubing-en.pdf

Anexo 8 : Tabla con las especificaciones del teflón

Tabla de anexos 4 - Módulos elásticos de materiales biocompatibles naturales y sintéticos

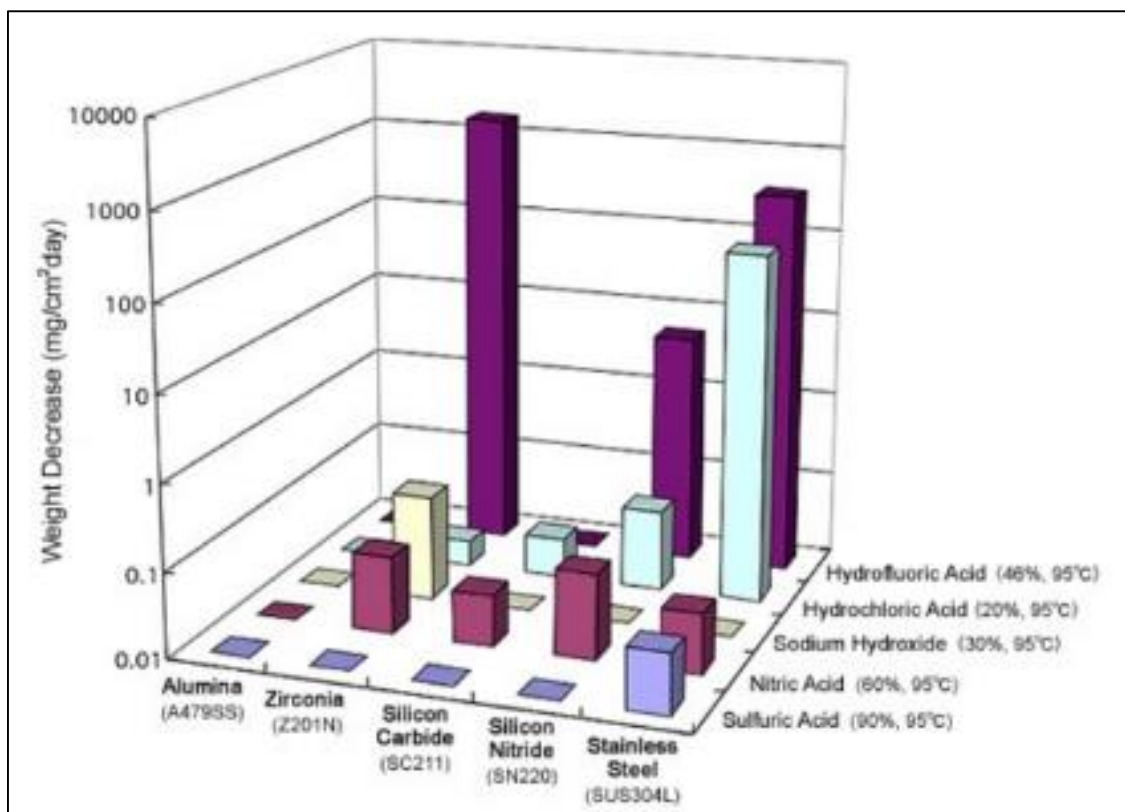
DuPont™ Teflon® PTFE Specifications				
TYPICAL PROPERTIES of TEFLON® PTFE				
ASTM or UL test	Property	PTFE (unfilled)	PTFE (25% glass filled)	PTFE (25% carbon filled)
PHYSICAL				
D792	Density (lb/in ³) (g/cm ³)	0.078 2.16	0.081 2.25	0.075 2.08
D570	Water Absorption, 24 hrs (%)	< 0.01	0.02	0.05
MECHANICAL				
D638	Tensile Strength (psi)	3,900	2,100	1,900
D638	Tensile Modulus (psi)	80,000	-	-
D638	Tensile Elongation at Break (%)	300	270	75
D790	Flexural Strength (psi)	No break	1,950	2,300
D790	Flexural Modulus (psi)	72,000	190,000	160,000
D695	Compressive Strength (psi)	3,500	1,000	1,700
D695	Compressive Modulus (psi)	70,000	110,000	87,000
D785	Hardness, Shore D	D50	D60	D62
D256	IZOD Notched Impact (ft-lb/in)	3.5	-	-
THERMAL				
D696	Coefficient of Linear Thermal Expansion (x 10 ⁻⁵ in./in./°F)	7.5	6.4	6.0
D648	Heat Deflection Temp (°F / °C) at 264 psi	132 / 55	150 / 65	150 / 65
D3418	Melting Temp (°F / °C)	635 / 335	635 / 335	635 / 335
-	Max Operating Temp (°F / °C)	500 / 260	500 / 260	500 / 260
C177	Thermal Conductivity (BTU-in/ft ² -hr-°F) (x 10 ⁻⁴ cal/cm-sec-°C)	1.70 5.86	3.1 10.6	4.5 15.5
UL94	Flammability Rating	V-0	V-0	V-0
ELECTRICAL				
D149	Dielectric Strength (V/mil) short time, 1/8" thick	285	-	-
D150	Dielectric Constant at 1 MHz	2.1	2.4	-
D150	Dissipation Factor at 1 MHz	< 0.0002	0.05	-
D257	Volume Resistivity (ohm-cm) at 50% RH	> 10 ¹⁸	> 10 ¹⁵	10 ⁴
<p>NOTE: The information contained herein are typical values intended for reference and comparison purposes only. They should NOT be used as a basis for design specifications or quality control. Contact us for manufacturers' complete material property datasheets. All values at 73°F (23°C) unless otherwise noted.</p> <p style="text-align: center;">TEFLON ® is a registered trademark of DuPont</p>				

Referencia:

http://www.aetnoplastics.com/site_media/media/attachments/aetna_product_aetnaproduct/25/PTFE%20Specifications.pdf

Anexo 9 : Gráfico con la pérdida de peso de los cerámicos siendo sometidos a distintos ácidos.

Gráfico de anexos 7: Pérdida de peso de los cerámicos siendo sometidos a distintos ácidos.



Referencia: <http://www.extreme-bolt.com/ceramic-screws-alumina-screws-zirconia-screws.html>

Anexo 10 : Tabla con las velocidades recomendadas para microfresas hechas de diamante.

Tabla de anexos 5 - Velocidades recomendadas para microfresas de diamante

DIAMETER	RECOMMENDED RPM'S
.001" to .004"	300,000 to 450,000
.005" to .015"	65,000 to 150,00
.016" to .030"	30,00 to 65,000
.031" to .090"	9,000 to 30,000
1/8" (3.18mm)	2,500
3/16" (4.76mm)	2,250
1/4" (6.35mm)	2,000
5/16" (7.94mm)	1,500
3/8" (5.52mm)	1,250
7/16" (11.1mm)	1,000
1/2" (12.7mm)	950
9/16" (14.28mm)	925
5/8" (15.87mm)	875
2/3" (16.93mm)	850
11/16" (17.46mm)	850
3/4" (19.05mm)	825
7/8" (22.22mm)	775
1.0" (25.4mm)	700
1-1/8" (28.57mm)	675
1-1/4" (1-1/4mm)	650
1-3/8" (34.92mm)	600
1-1/2" (38.10mm)	550
1-5/8" (41.27mm)	550
1-3/4" (44.45mm)	550
2.00" (50.80mm)	525
2-1/4" (57.15mm)	500
2-1/2" (63.50mm)	475
3.00" (76.20mm)	450
3-1/2" (88.90mm)	425
4.00" (101.60mm)	400
6.00" (152.40mm)	300

Referencia: http://www.ukam.com/drilling_recommendations.html

Anexo 11 : Características del PC-ISO tomadas de Fortus



PC-ISO (polycarbonate-ISO), an industrial thermoplastic, which in its raw state, is biocompatible (ISO 10993 USP Class VI) and can be gamma or EtO sterilized. PC-ISO is commonly used in food and drug packaging and medical device manufacturing because of the material's strength and medical compatibility. When combined with a Fortus® 3D Production system, PC-ISO gives you Real Parts™ that can be used for conceptual modeling, functional prototyping, and end-use parts.



Mechanical Properties ¹	Test Method	English	Metric
Tensile Strength (Type 1, 0.125", 0.2"/min)	ASTM D638	8,300 psi	57 MPa
Tensile Modulus (Type 1, 0.125", 0.2"/min)	ASTM D638	289,800 psi	2,000 MPa
Tensile Elongation (Type 1, 0.125", 0.2"/min)	ASTM D638	4%	4%
Flexural Strength (Method 1, 0.05"/min)	ASTM D790	13,100 psi	90 MPa
Flexural Modulus (Method 1, 0.05"/min)	ASTM D790	310,400 psi	2,100 MPa
IZOD Impact, notched (Method A, 23°C)	ASTM D256	1.6 ft-lb/in	86 J/m
IZOD Impact, un-notched (Method A, 23°C)	ASTM D256	1 ft-lb/in	53 J/m

Thermal Properties ²	Test Method	English	Metric
Heat Deflection (HDT) @ 66 psi	ASTM D648	271°F	133°C
Heat Deflection (HDT) @ 264 psi	ASTM D648	260°F	127°C
Glass Transition (Tg)	DMA (SSYS)	322°F	161°C
Vicat Softening	ISO 306	282°F	139°C
Melt Point	-----	Not Applicable ³	Not Applicable ³

Electrical Properties ⁴	Test Method	Value Range
Volume Resistivity	ASTM D257	1.5x10e14 - 8.0x10e13 ohms
Dielectric Constant	ASTM D150-98	3.0 - 2.8
Dissipation Factor	ASTM D150-98	.0009 - .0005
Dielectric Strength	ASTM D149-09, Method A	370 - 70 V/mil

Other ²	Test Method	Value
Specific Gravity	ASTM D792	1.2
Flame Classification	UL 94	HB



PRODUCTION-GRADE THERMOPLASTIC

Referencia: <http://www.fortus.com>

PC-ISO



System Availability	Layer Thickness Capability	Support Structure	Available Colors
Fortus 400mc	0.013 inch (0.330 mm)	BASS	<input type="checkbox"/> White
Fortus 900mc	0.010 inch (0.254 mm) 0.007 inch (0.178 mm)		<input type="checkbox"/> Translucent Natural

The information presented are typical values intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. End-use material performance can be impacted (+/-) by, but not limited to, part design, end-use conditions, test conditions, etc. Actual values will vary with build conditions. Tested parts were built on Fortus 400mc @ 0.010" (0.254 mm) slice. Product specifications are subject to change without notice.

The performance characteristics of these materials may vary according to application, operating conditions, or end use. Each user is responsible for determining that the Stratasys material is safe, lawful, and technically suitable for the intended application, as well as for identifying the proper disposal (or recycling) method consistent with applicable environmental laws and regulations. Stratasys makes no warranties of any kind, express or implied, including, but not limited to, the warranties of merchantability, fitness for a particular use, or warranty against patent infringement.

*It is the responsibility of the finished device manufacturer to determine the suitability of all the component parts and materials used in their finished products.

¹Build orientation is on side long edge.

²Literature value unless otherwise noted.

³Due to amorphous nature, material does not display a melting point.

⁴All Electrical Property values were generated from the average of test plaques built with default part density (solid). Test plaques were 4.0 x 4.0 x 0.1 inches (102 x 102 x 2.5 mm) and were built both in the flat and vertical orientation. The range of values is mostly the result of the difference in properties of test plaques built in the flat vs. vertical orientation.

At the core: Advanced FDM Technology™

Fortus systems are based on patented Stratasys FDM (Fused Deposition Modeling) technology. FDM is the industry's leading additive manufacturing technology, and the only one that uses production grade thermoplastics, enabling the most durable parts.

Fortus systems use a wide range of thermoplastics with advanced mechanical properties so your parts can endure high heat, caustic chemicals, sterilization, and high impact applications.

No special facilities needed

You can install a Fortus 3D Production System just about anywhere. No special venting is required because Fortus systems don't produce noxious fumes, chemicals, or waste.

No special skills needed

Fortus 3D Production Systems are easy to operate and maintain compared to other additive fabrication systems because there are no messy powders or resins to handle and contain. They're so simple, an operator can be trained to operate a Fortus system in less than 30 minutes.

Get your benchmark on the future of manufacturing

Fine details. Smooth surface finishes. Accuracy. Strength. The best way to see the advantages of a Fortus 3D Production System is to have your own part built on a Fortus system. Get your free part at: www.fortus.com/benchmark.

For more information about Fortus systems, materials and applications, call 888.480.3548 or visit www.fortus.com

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ISO 9001:2008 Certified

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FORTUS
3D PRODUCTION SYSTEMS

Referencia: <http://www.fortus.com>

Anexo 12 : Características del adhesivo EPO-TEK315



EPO-TEK® 375
Technical Data Sheet
For Reference Only
High Temperature Epoxy

Number of Components:	Two	Minimum Bond Line Cure Schedule*:	
Mix Ratio By Weight:	10:1	150°C	5 Minutes
Specific Gravity:		120°C	20 Minutes
Part A	1.2	100°C	60 Minutes
Part B	1.0	80°C	90 Minutes
Pot Life:	4 Hours		
Shelf Life:	One year at room temperature		

Note: Container(s) should be kept closed when not in use. *Please see Applications Note available on our website.

Product Description:

EPO-TEK® 375 is a two component, high temperature epoxy designed for semiconductor, hybrid, fiber optic, and medical applications. Also available in a single component frozen syringe.

EPO-TEK® 375 Advantages & Application Notes:

- Reasonable pot-life that allows for low temperature curing to be realized. It has an amber color change upon cure.
- Semiconductor suggested applications: wafer-wafer bonding of CSP; fabrication of MEMs devices; flip chip underfill.
- Hybrid suggested applications: providing near hermetic seals and UHV seals in sensor devices and resisting high temperature packaging.
 - o Down-hole petrochemical fiber optic sensors resisting >200°C field conditions.
- Fiber optic adhesive suggested applications:
 - o Sealing fiber into ferrules, transmitting light in the optical pathway from 800- 1550 nm range.
 - o Fiber component packaging, adhesive for active alignment of optics, environmental seal of opto-package, V-groove arrays.
- Medical suggested applications:
 - o Potting fiber optic bundles into ferrules for light guides and endoscopes; capable of resisting several sterilization techniques including ETO, gamma, ION beam, H2O2 plasma, and >200 autoclave steam cycles; excellent adhesion to surfaces including stainless steel, diamond, titanium, brass, ceramics, glass and most plastics.
 - o Certified to USP Class VI Biocompatibility Standards for medical implants; adhesive for catheter devices including stents and guide wires.
- Electronics Assembly suggested applications:
 - o Used as dielectric layer in the fabrication of capacitors; laminating PZT ferroelectrics found in ultrasound or ink-jetting devices.
 - o Impregnating and insulating copper coil windings in motors and inductor coils. Bonding ferrite cores and magnets.
 - o Structural grade epoxy found in hard-disk drive devices; bonding of stainless steel metals, kapton, and magnets.

Typical Properties: (To be used as a guide only, not as a specification. Data below is not guaranteed. Different batches, conditions and applications yield differing results; Cure condition: 150°C/1 Hour ; * denotes test on lot acceptance basis)

Physical Properties:	
*Color: Part A: Clear/Colorless Part B: Amber	Die Shear Strength @ 23°C: ≥ 10 Kg / 3,400 psi
*Consistency: Pourable liquid	Degradation Temp. (TGA): 421°C
*Viscosity (@ 50 RPM/23°C): 3,000 – 5,000 cPs	Weight Loss:
Thixotropic Index: N/A	@ 200°C: 0.06%
*Glass Transition Temp.(Tg): ≥ 100°C (Dynamic Cure	@ 250°C: 0.16%
20—200°C /ISO 25 Min; Ramp -10—200°C @ 20°C/Min)	@ 300°C: 0.49%
Coefficient of Thermal Expansion (CTE):	Operating Temp:
Below Tg: 48 x 10 ⁻⁶ in/in/°C	Continuous: - 55°C to 200°C
Above Tg: 192 x 10 ⁻⁶ in/in/°C	Intermittent: - 55°C to 300°C
Shore D Hardness: 88	Storage Modulus @ 23°C: 339,358 psi
Lap Shear Strength @ 23°C: > 2,000 psi	*Particle Size: N/A
Optical Properties @ 23°C:	
Index of Refraction @ 23°C: 1.5692 @ 589 nm	Spectral Transmission @ 23°C: >94% @ 600 - 790nm
	>98% @ 800 – 1500nm
Electrical & Thermal Properties:	
Thermal Conductivity: N/A	Volume Resistivity @ 23°C: ≥1 x 10 ¹³ Ohm-cm
Dielectric Constant (1KHz): 3.34	Dissipation Factor (1KHz): 0.004

EPOXY TECHNOLOGY, INC.
14 Fortune Drive, Billerica, MA 01821-3972 Phone: 978.667.3805 Fax: 978.663.9782
www.EPOTEK.com

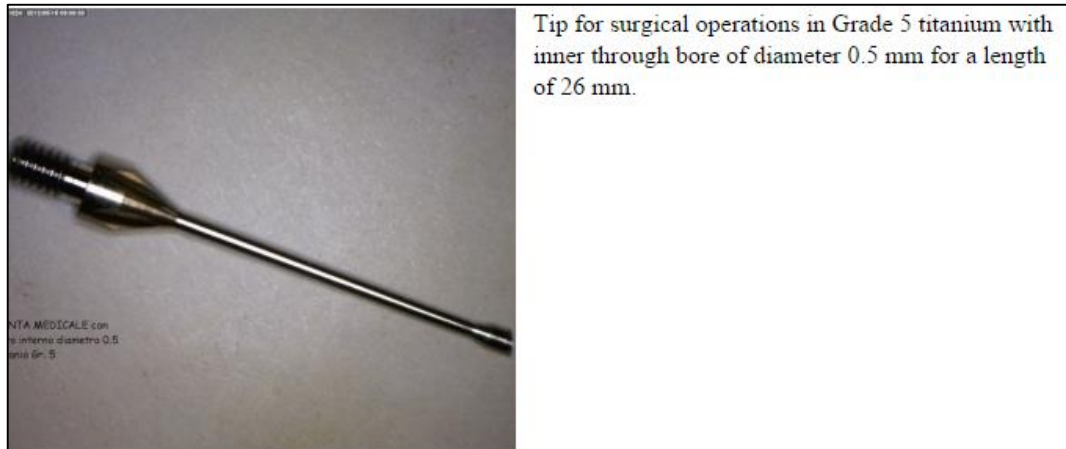
Epoxy and Adhesives for Demanding Applications™

This information is based on data and tests believed to be accurate. Epoxy Technology, Inc. makes no warranties (expressed or implied) as to its accuracy and assumes no liability in connection with any use of this product.

Rev. IV
Jan 2011

Referencia: Epoxy Technology

Anexo 13 : Ejemplo de dispositivo médico fabricado por torno de precisión.



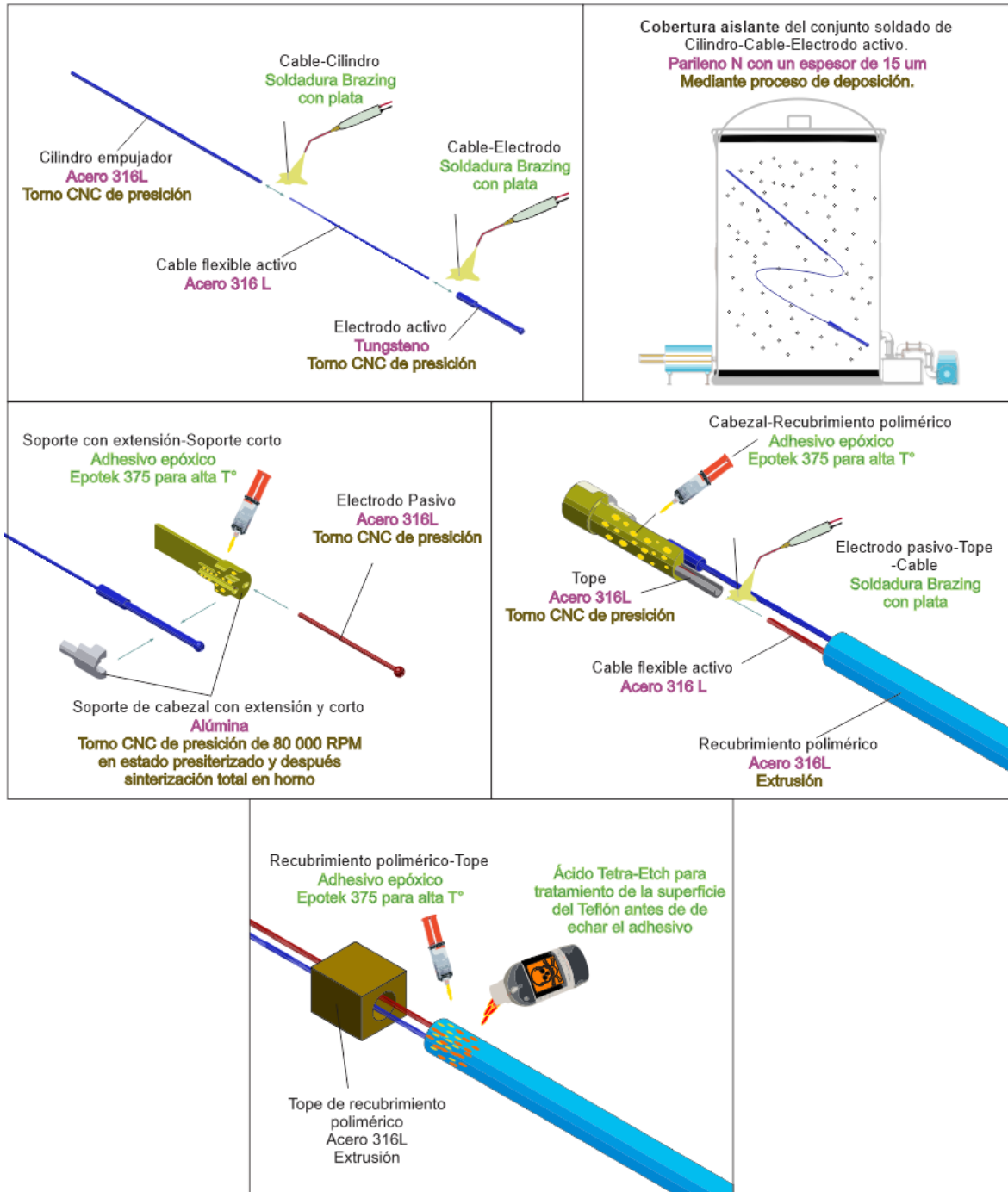
Referencia: <http://www.poppifrancoprecisionmetals.com/lavorazione-acciaio/prodotti>

Anexo 14 : Ejemplo de tolerancias de un torno de precisión

- Precision metal parts uses CNC lathe machines
- Contract manufacturing parts are welcome
- Strict QC is enforced at all stages
- Outer diameter between $\varnothing 0.5\text{mm}$ and 25mm
- Processing precision:
 - Straightness: 0.002mm
 - Perpendicularity: 0.005mm
 - Circular run out: 0.002mm
 - Roughness: 0.005mm
 - Position: 0.01mm
 - Diameter: 0.001mm
 - Cylindricity: 0.005mm
 - Concentricity: 0.005mm
 - Length: 0.002mm
 - Parallelism: 0.005mm
 - Symmetry: 0.005mm

Referencia: <http://www.globalsources.com/si/AS/Mawfong-Precision/6008800260963/pdt/Lathe-Precision-Turned-Part-Product/1061917660.htm>

Anexo 15 : Resumen de ensamble por *brazing* y adhesivo epóxico



Anexo 16 : Correo con cotización del recubrimiento de parileno



John Sterrett <JSterrett@scscoatings.com>

30/11/15 ☆



para mí ▾

Perfecto, gracias por aclarar todo. Bajo estas condiciones, mi recomendación sería que lo aplicáramos 15 um de Parylene C. Buscare la opinión de nuestro gerente de ingeniería para verificar.

Lo malo es que el Parylene se hace por lote, así que hay un cargo mínimo. Para Parylene C o Parylene N esto viene siendo \$400 USD. Si recubriéramos varias piezas a la vez, les saldría mucho menos costoso para cada pieza.

Voy a preparar una cotización formal en nuestro sistema. La recibirán mañana

John Sterrett
Specialty Coating Systems
Territory Manager
South Central US / Mexico
Mobile 214.218.9648
Office 214.383.3600
jsterrett@scscoatings.com
www.scscoatings.com



SPECIALTY COATING SYSTEMS™



Anexo 17 : Cotización del catéter multilumen

	<p>OEM Products 50 Plantation Drive, Jaffrey, NH 03452 Phone: 603-532-7706</p>	<p>QUOTATION</p>	<p>Quote No. JAF-Q00171 Rev. No. 0 Page: 1 of 2</p>
--	---	-------------------------	--

<p>Cust ID: Name: Address: City: Libra Country: Peru Attn: Anibal Silva Sueldo Phone:</p>	<p>Issue Date: 12/1/2015 Sales Rep: Cesar Quintana Delivery Terms: Ex works aasilva@pucp.pe Cell:</p>
--	---

Item	Qty	UOM	Description	Cust P/N	Unit Price	Total
<u>Development samples of two lumen natural PTFE tubing</u>						
1	30	EA	Shaft OD; 3.60mm +/- .051mm Round lumen; 1.50mm +/- .51mm Half moon lumen; radius 1.60mm Half moon lumen will have a .01" radius on both sides Wall thickness around half moon lumen; .205mm Length; 1 meter Quoted as <u>development samples</u> see additional information below.	Customer sketch without a part number	N/A	See Item #2
2	32	Hours	NRE (non recurring engineering) charge Development engineering time for the following - Creation & implementation of manufacturing and quality documentation - Tool design and qualification - Process development and qualification - Manufacturing the thirty development samples - Providing executive summary of project Terms: 50% with the PO and the balance prior to shipment	N/A	\$200.00	\$6,400.00
3	1	Set	Extrusion tooling Terms: 50 % with the PO and the balance when Teleflex takes delivery of the tooling. Lead time is approximately 6-8 weeks ARO <u>Development samples</u> - Suitable for development builds where specifications are under development and not necessarily finalized - Product may be manufactured to generic procedures. - Process parameters are not validated or documented in dedicated specifications but actual parameters used are recorded in the lot record. - Lot records have full traceability of components and materials. - The specification is limited to the quotation and supporting documents. - Parts manufactured as development samples, not for human use, best effort, and shipped without a CofC. - Production volume orders will only be accepted after Teleflex receives customer approval of development samples.	N/A	\$3,750.00	\$3,750.00

Trey Frederick

Trey Frederick
Technical Sales Manager

Unless otherwise noted, Terms are Net 30 days from date of invoice. A complete description of our standard Terms Conditions of Sale will be forwarded for your permanent records.