

# INTERNATIONAL STANDARD

**ISO**  
**594-2**

Second edition  
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## **Conical fittings with 6 % (Luer) taper for syringes, needles and certain other medical equipment —**

### **Part 2: Lock fittings**

*Assemblages coniques à 6 % (Luer) des seringues et aiguilles  
et de certains autres appareils à usage médical —*

*Partie 2: Assemblages à verrouillage*



Reference number  
ISO 594-2:1998(E)

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 594-2 was prepared by Technical Committee ISO/TC 84, *Medical devices for injections*.

This second edition cancels and replaces the first edition (ISO 594-2:1991), of which it constitutes a minor revision.

It corresponds to European Standard EN 1707:1996, prepared by Technical Committee CEN/TC 205, *Non-active medical devices*.

ISO 594 consists of the following parts, under the general title *Conical fittings with a 6 % (Luer) taper for syringes, needles and certain other medical equipment*:

- *Part 1: General specifications*
- *Part 2: Lock fittings*

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# Conical fittings with 6 % (Luer) taper for syringes, needles and certain other medical equipment — Part 2: Lock fittings

## 1 Scope

This part of ISO 594 specifies requirements for conical lock fittings with a 6 % (Luer) taper for use with hypodermic syringes and needles and with certain other apparatus for medical use, e.g. transfusion equipment.

The requirements apply to fittings made of rigid and of semi-rigid materials and include test methods, but exclude provision for more flexible or elastomeric materials.

NOTE 1 It is not practicable to define the characteristics of rigid or semi-rigid materials with precision, but glass and metal may be considered as typical rigid materials. In contrast many plastics materials may be regarded as semi-rigid.

NOTE 2 The Luer lock fitting was designed for use at pressures of the order of 300 kPa or lower. Its use in other applications may require consideration to establish its suitability.

## 2 Normative references

The following normative documents contain provisions which, through reference in this text, constitute provisions of this part of ISO 594. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 594 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 468, *Surface roughness — Parameters, their values and general rules for specifying requirements.*

ISO 594-1:1986, *Conical fittings with a 6 % (Luer) taper for syringes, needles and certain other medical equipment — Part 1: General requirements.*

ISO 7886-1, *Sterile hypodermic syringes for single use — Part 1: Syringes for manual use.*

## 3 Dimensions and tolerances

### 3.1 Male and female 6 % (Luer) conical fittings

The dimensions and tolerances for the male and female fittings specified in ISO 594-1 apply to the relevant conical part of the fitting described in clause 4 of this part of ISO 594.

### 3.2 Male and female 6 % (Luer) conical lock fittings

#### 3.2.1 Rigid materials

The dimensions of male and female lock fittings made of rigid materials shall be as shown in Figures 1 to 4 and as given in Table 1.



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