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(71) Applicant: **W. L. GORE & ASSOCIATES, INC.**
[US/US]; 555 Paper Mill Road, Newark, DE 19711 (US).

(72) Inventors: **BASHAM, Robert**; W. L. Gore & Associates, Inc., 551 Paper Mill Road, Newark, DE 19711 (US).
DUPUY, Nicole; W. L. Gore & Associates, Inc., 551 Paper Mill Road, Newark, DE 19711 (US). **LAROSE, Erik**; W. L. Gore & Associates, Inc., 551 Paper Mill Road, Newark, DE 19711 (US).

(74) Agent: **MILLER, Amy** et al.; W. L. Gore & Associates, Inc., 551 Paper Mill Road, P.O. Box 9206, Newark, DE 19714-9206 (US).

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(54) Title: A METHOD OF INSERTING A LUBRICANT FREE STOPPER INTO A LUBRICANT FREE BARREL OR A LUBRICANT FREE CARTRIDGE TUBE AND A SYSTEM FOR ASSEMBLING SAME

(57) Abstract: A method of inserting a lubricant free stopper into a lubricant free syringe barrel or lubricant free cartridge tube is disclosed. The method includes (1) inserting a stopper with a sealing rib into a placement region, (2) lowering the body of the insertion tube into a syringe barrel or cartridge tube to a position located past the barrel flange or top of the cartridge tube, (3) maneuvering the stopper to a distal opening of the insertion tube using an insertion pin, (4) retracting the insertion tube while the stopper remains in a fixed position within the syringe barrel or cartridge tube, and (5) fully retracting the insertion pin and the insertion tube from the syringe barrel or cartridge tube. The method is lubricant free or substantially lubricant free. The insertion tube may be electropolished and/or extrude honed.



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