

CLAIMS

1. A method for producing a port comprising:

sealingly inserting a sealing plug, through which a hollow needle can be
5 pierced, into a part to be sealed of a port body, wherein the port body includes:
the part to be sealed that has a tubular shape with a first end and a second end
opposite to the first end in a center axis direction thereof; a connection part that
has a tubular shape, and is continuous with the first end of the part to be
sealed; and a part to be fitted that is formed in any one of an inner peripheral
10 surface of the part to be sealed, an outer peripheral surface of the part to be
sealed, and the second end of the part to be sealed, wherein the sealing plug has
a first surface located on a pulling-out preventing member side and a second
surface located opposite to the first surface, and has an extension that extends
toward a side opposite to the pulling-out preventing member side from the
15 center portion of the second surface of the sealing plug, and wherein an outer
peripheral surface of the extension bulges outward over the entire periphery in
a circumferential direction;

fitting a fitting part of a pulling-out preventing member into the part to
be fitted, wherein the pulling-out preventing member includes: a body part that
20 has a first surface and a second surface opposite to the first surface, and the
fitting part that is continuous with the body part, to thereby engage the part to
be fitted with the fitting part so as to be able to transmit a force which is
directed in the center axis of the part to be sealed; and

laying the body part on the sealing plug.

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2. A method for producing a port comprising: sealingly inserting a sealing
plug, through which a hollow needle can be pierced, into a part to be sealed of a
port body, wherein the port body includes: the part to be sealed that has a
tubular shape with a first end and a second end opposite to the first end in a
center axis direction thereof; a connection part that has a tubular shape, and is
30 continuous with the first end of the part to be sealed; and a part to be fitted that

is formed in any one of an inner peripheral surface of the part to be sealed, an outer peripheral surface of the part to be sealed, and the second end of the part to be sealed, wherein the sealing plug has a first surface located on a pulling-out preventing member side and a second surface located opposite to the first surface, and has an extension that extends toward a side opposite to the pulling-out preventing member side from the center portion of the second surface of the sealing plug, and wherein an outer peripheral surface of the extension bulges outward over the entire periphery in a circumferential direction;

fitting a fitting part of a pulling-out preventing member into the part to be fitted, wherein the pulling-out preventing member includes: a body part that has a first surface and a second surface opposite to the first surface, and the fitting part that is continuous with the body part, to thereby make an engaging surface of the part to be fitted that is directed toward a first end side of the part to be sealed face an engaging surface of the fitting part that is directed toward a second end side of the part to be sealed; and

laying the body part on the sealing plug.

3. The method for producing the port according to claim 1 or 2, wherein the part to be fitted is any one of a recess part and a projection part, and the fitting part is a remaining one of the recess part and the projection part.

4. The method for producing the port according to any one of claims 1 to 3, wherein the body part has a needle insertion portion that opens to the first surface and the second surface and exposes the sealing plug, wherein the sealing plug includes a projection part that projects toward the needle insertion portion of the body part, and wherein laying the body part on the sealing plug encompasses disposing the projection part of the sealing plug within the needle insertion portion while any one of the first surface and the second surface of the body part is directed toward the sealing plug, and disposing an end of the projection part at the same level as or substantially the same level as a

remaining one of the first surface and the second surface of the body part, or at a position where the end of the projection part projects outward from a remaining one of the first surface and the second surface of the body part.

5 5. The method for producing the port according to any one of claims 1 to 4, wherein the pulling-out preventing member includes a first restriction part that is formed on the first surface of the body part, and wherein laying the body part on the sealing plug encompasses bringing the first restriction part into abutting engagement with the sealing plug.

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6. The method for producing the port according to any one of claims 1 to 4, wherein the pulling-out preventing member includes a second restriction part that is formed on the second surface of the body part, and wherein laying the body part on the sealing plug encompasses bringing the second restriction part
15 into abutting engagement with the sealing plug.

7. A method for producing a medical liquid bag comprising:
sealingly inserting a sealing plug, through which a hollow needle can be pierced, into a part to be sealed of a port body, wherein the port body includes:
20 the part to be sealed that has a tubular shape with a first end and a second end opposite to the first end in a center axis direction thereof; a connection part that has a tubular shape, and is continuous with the first end of the part to be sealed; and a part to be fitted that is formed in any one of an inner peripheral surface of the part to be sealed, an outer peripheral surface of the part to be
25 sealed, and the second end of the part to be sealed, wherein the sealing plug has a first surface located on a pulling-out preventing member side and a second surface located opposite to the first surface, and has an extension that extends toward a side opposite to the pulling-out preventing member side from the center portion of the second surface of the sealing plug, and wherein an outer
30 peripheral surface of the extension bulges outward over the entire periphery in a circumferential direction;

fitting a fitting part of a pulling-out preventing member into the part to be fitted, wherein the pulling-out preventing member includes: a body part that has a first surface and a second surface opposite to the first surface, and the fitting part that is continuous with the body part, to thereby engage the part to be fitted with the fitting part so as to be able to transmit a force which is directed in the center axis of the part to be sealed;

laying the body part on the sealing plug; and

connecting a bag body to be filled with a medical liquid to an outer periphery of the connection part.

8. A method for producing a medical liquid bag comprising:

sealingly inserting a sealing plug, through which a hollow needle can be pierced, into a part to be sealed of a port body, wherein the port body includes: the part to be sealed that has a tubular shape with a first end and a second end opposite to the first end in a center axis direction thereof; a connection part that has a tubular shape, and is continuous with the first end of the part to be sealed; and a part to be fitted that is formed in any one of an inner peripheral surface of the part to be sealed, an outer peripheral surface of the part to be sealed, and the second end of the part to be sealed, wherein the sealing plug has a first surface located on a pulling-out preventing member side and a second surface located opposite to the first surface, and has an extension that extends toward a side opposite to the pulling-out preventing member side from the center portion of the second surface of the sealing plug, and wherein an outer peripheral surface of the extension bulges outward over the entire periphery in a circumferential direction;

fitting a fitting part of a pulling-out preventing member into the part to be fitted, wherein the pulling-out preventing member includes: a body part that has a first surface and a second surface opposite to the first surface, and the fitting part that is continuous with the body part, to thereby make an engaging surface of the part to be fitted that is directed toward a first end side of the part to be sealed face an engaging surface of the fitting part that is directed toward a

second end side of the part to be sealed;

laying the body part on the sealing plug; and

connecting a bag body to be filled with a medical liquid to an outer periphery of the connection part.

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9. The method for producing the medical liquid bag according to claim 7 or 8, wherein the part to be fitted is any one of a recess part and a projection part, and the fitting part is a remaining one of the recess part and the projection part.

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10. The method for producing the medical liquid bag according to any one of claims 7 to 9, further comprising: filling the medical liquid into the bag body via the port body to which the connection part of the bag body is connected,

wherein sealingly inserting the sealing plug into the part to be sealed and

15 laying the body part on the sealing plug are carried out after the medical liquid is filled in the bag body.

11. The method for producing the medical liquid bag according to any one of claims 7 to 9, wherein a non-sealed portion provided in the bag body is sealed

20 after the medical liquid is filled in the bag body through the non-sealed portion.

12. The method for producing the medical liquid bag according to claim 11, wherein connecting the bag body to the outer periphery of the connection part encompasses sealing the non-sealed portion by welding the non-sealed portion

25 to the connection part disposed at the non-sealed portion.