TRAINING

SUBJECT: SpO2 Connector Assembly

The following procedure is primarily for use by "Production" personnel – this procedure is to be used in conjunction with other relevant, specific Operating Procedures (where applicable).

The equipment required is as follows:

D.V.M., Soldering Iron, Solder, Wire Stripper, Flush Cutter, Snipe Nosed Pliers, Helping Hands, 1 Set of Jewel Screwdrivers, Dremel tool, Superglue, Primer (loctite 770).

Refer to the relevant Operating Procedure (or technical drawing) for the wiring diagram.

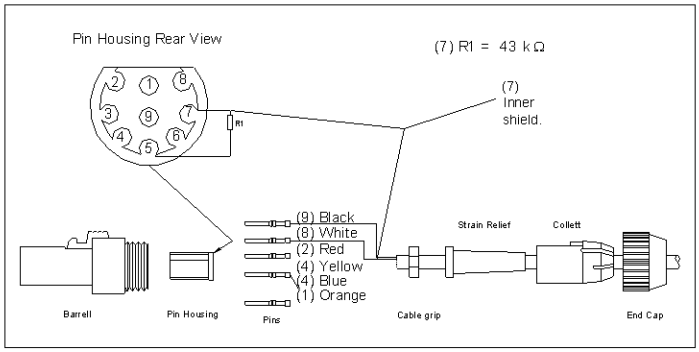
Switch on the soldering iron and ensure that it is set at 240°, and clean the tip.

At all times the Quality of the soldering must be as per:- SpO2 Testing & QC – Stage 4 – Section 1.

Hypertronics Assembly

PICTORIAL and SCHEMATIC REPRESENTATIONS

N.B. Connectors are also other colours than black (usually grey)



1. Feed ∅6 x 43mm (clear) heat shrink, end cap, collett, strain relief, ∅6 x 10mm (black) heat shrink and cable grip onto the cable.
2. Strip 20mm off the outer jacket of wire and cut all the packing to the base.
3. Reveal the black and white wires, which are covered by the inner shield. Trim the inner shield to approximately 20mm long.
4. Strip the jacket of every wire 2mm to reveal the copper core. Apply a small amount of solder to the ends of each wire and shield.
5. Trim one of the legs of the resistor to 4mm long and the other to 15mm long.

6. Cover the resistor in ∅1.6mm heat shrink and solder each leg into the rear of 2 separate pins and push pins firmly into correct locations.
7. Solder the shield to pin 7, covering it with ∅1.6mm heat shrink, and the remaining wires to the rear of 4 separate pins and push/pull firmly into correct locations.
8. Clamp the cable grip approximately 2mm from the outer jacket end.
9. Place ∅6 x 10mm heat shrink over the cable grip and the beginning of the wires and heat to shrink firmly around.
10. Push the strain relief up to the cable grip, collett over the strain relief up to the pin housing, and into the barrel and finally screw the end cap onto the barrel.
11. Test the