



## SpO2 Assembly Instructions

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S & W

Page 3

Of 3

k/ Cut the wires to 15mm from the outer cable cover. Strip and tin the last 2mm of each wire.

l/ Cut one of the legs of the 68K1 resistor (0032134) to 4mm from the resistor body. Cut the other leg to 15mm from the resistor body. Bend the longer leg of the resistor to form a hairpin, ensuring that the ends of both legs are now level.

m/ Cut one of the legs of the 100K resistor (0032140) to 4mm from the resistor body. Cut the other leg to 15mm from the resistor body. Bend the longer leg of the resistor to form a hairpin, ensuring that the ends of both legs are now level.

n/ Solder the short leg of the 68K1 resistor into one of the ARBO pins. Solder the short leg of the 100K resistor into another of the ARBO pins.

o/ Solder the long leg of the 68K1 resistor into an ARBO pin. Also solder the long leg of the 100K into the same pin. Solder the twisted shield to the long legs of these resistors, between the body of the resistor and the pin.

p/ Solder the remaining wires into the remaining pins.

q/ Referring to the wiring diagram, and ensuring that the pin retaining rings do not become detached, insert the pins into the socket housing as follows:

i/ Push the pin with both resistors and the shield attached into pin hole 8.

ii/ Push the pin with the 68K1 resistor only attached into pin hole 5.

iii/ Push the pin with the 100K resistor only attached into pin hole 7.

iv/ Push the remaining pins into the relevant pin holes.

r/ Push the 15mm piece of heatshrink (0032321) up over the cable cover, so that 10mm of the heatshrink covers the white cable cover, and the remaining 5mm projects beyond the cable cover and over onto the wires. Shrink this into position using a heatgun.

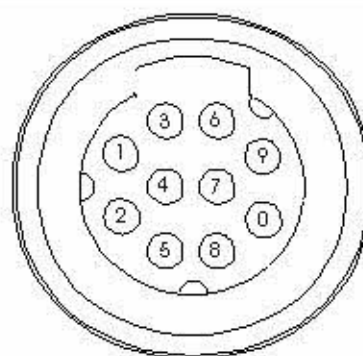
s/ Screw the strain relief over the cable and into the shell (without tongue), at a point just above where the cable cover ends, so that the cord grip does not bite down upon the cable at a point where there is no cable cover beneath the heatshrink to protect the wires. There should also be a small degree of 'play' with the cable, so that when the connector is fitted together, there is no strain directly on the wires.

t/ Attach the cable tie to the cable, just below the strain relief, and tighten. Cut off the excess part of the cable tie using the flush cutter.

u/ Orientate the socket housing in the shell (without tongue), and add the shell (with tongue). Push up the internal ring into position around the shells. Push up the shroud around the connector. Finally add the front ring to the connector.

Connector rear view:

- |           |                      |
|-----------|----------------------|
| 1. Orange | 6. No pin            |
| 2. Red    | 7. R2                |
| 3. No pin | 8. R1 + R2 + Shields |
| 4. Yellow | 9. Black             |
| 5. R1     | 0. White             |



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