



Equipment type: Finger probe Part Number:
Batch Size

Nos

Viamed Part number

Description

1

0010100

Viamed SpO2 finger probe service kit (white pads)

1

0010750

Sub miniature D connector plug kit

1m

0030513

SpO2 cable - version D (production)

30mm

0032331

Heatshrink tubing - clear, 6.0mm, 7m reel

5mm

0032310

Heatshrink tubing - black, 1.6mm, 25m reel

Assembly Clip

Prepare Clip end of cable as follows

Attach strain relief "0010150," to relevant replacement cable, and glue in position.

Strip back outer cable cover of exposed end 1mm from end of strain relief.

Remove outer shield and paper, and cut off Kevlar fibres and any unused wires.

Strip and tin relevant coloured wires (from red, yellow, blue, orange) to 13mm from end of cable cover.

Strip and tin last 1mm of each wire.

Cut inner white cable to 78mm from end of outer cable cover, strip last 8mm of inner cable cover, strip and tin last 1mm of black and white wires, cut off inner shield and discard

Strip and tin ends of black and white wires.

Solder wires to components as per relevant diagram

Fit components into pads as follows

Position components in drying rack.

Place a small amount of flowable non-corrosive silicone sealant onto the face of the components.

Place pads onto components, ensuring that both emitter and detector are central in pad windows. Also note that the silicone on the outside of the pad must run to the contour of the pad to make a smooth window - there should be no doming or sinking of the window. Any excess can be removed with a small screwdriver, also any deficit can be topped up with small amounts of silicone from a screwdriver tip - however these steps should be taken within 2 minutes of the pad being placed on the component, before the silicone has had time to become tacky, so that it is still flowing enough to ensure that the window will return to a smooth flat surface

Leave pads to set for 24 hours.

Assemble the clip as follows

Glue white inner cable into channel in detector pad

Fill around component with silicone

Glue pad support onto back of detector pad.

Glue pad support onto back of emitter pad.
Glue white inner cable into channel in emitter pad.
Fill around component with silicone
Refit replacement springs "0010140," around pads.
Push pads into position within clip, making sure that the pad support rim is securely underneath the pad retaining lugs - there are four retaining lugs for each pad. If any lugs are not holding the pad support securely, then add a drop of superglue to the relevant lug.
Glue strain relief into position in clip body.
Add labels as required.

Assembly Connector

a/ Check that all the relevant parts are in the connector kit - the kit should contain:
1 x shroud, 1 x pin housing, 1 x cable grip.
b/ Add a 30mm length of heatshrink (0032331) to the cable.
c/ Add the shroud to the cable.
d/ Add the cable grip to the cable.
e/ Strip the outer cable cover back by 30mm, using the cable stripper (0060031).
f/ Unwind, but do not remove, the outer shield. Remove the paper layer, and the Kevlar strands, using flush cutter (0060020), cutting them flush to the end of the cable cover. Also remove any unused wires, cutting them flush to the end of the cable cover.
g/ Strip the inner cable cover back, using the cable stripper, flush to the end of the outer cable cover as possible. Unwind, but do not remove, the inner shield.
h/ Cut the wires to 15 mm from the end of the cable cover. Strip and tin the last 2mm of each of the wires.
i/ Fan out the shields together, then separate the fanned out shields into 2 equal and separate parts, each part containing strands from both the inner and outer shields. Twist each part and tin between 12-18mm from the outer cable cover. Cut each twisted shield at 15mm from the outer cable cover.
j/ Referring to the relevant wiring diagram, solder the wires into the pins.
k/ Add a 5mm length of heatshrink (0032310) over pin 6, and shrink into place using a heatgun. This will isolate the pin from the shields.
j/ Clamp the cable clamp onto the cable, using the cable crimp tool (0010501), 2mm from the end of the outer cable cover.
k/ Push the shroud up over the contact housing, ensuring that the housing fits securely and neatly into the shroud.

Connector rear view:

1. Not connected
2. Red
3. Yellow
4. No pin
5. White
6. Main + inner shield
7. Main + inner shield
8. No pin
9. Black

