GOSS COMPONENTS

FAA

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To: S NIXON
Co: VIAMED
From: JUDITH RANBY
cc:

Fax: 01535 635582
Date: 6 November, 2001
Page 1 of 1

Subject : POR01968 + POR01969

Further to our telephone conversation of yesterday regarding part number P103-1. We can now offer:-

10,000 @ £1262.34/1000
12,000 @ £1243.05/1000
20,000 @ £1207.40/1000

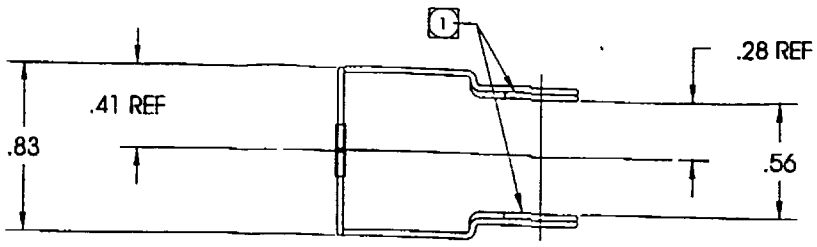
As I mentioned during our conversation we have re-assessed production method of this item as it has previously been uneconomical for us to manufacture.

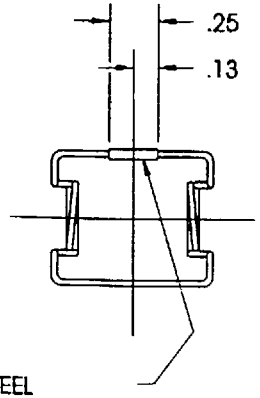
Order held pending your reply.

Regards

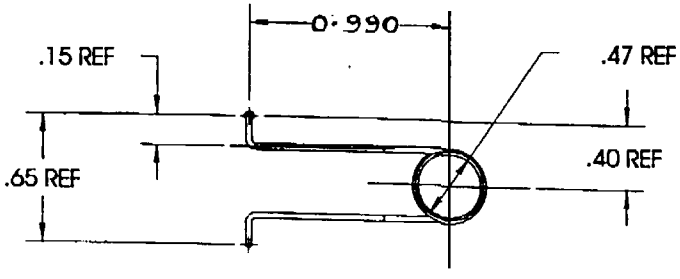
Jude

MODIFICATIONS
0·440 I.D. WAS 0·451
0·990 WAS 1·00
FINISH ADDED.

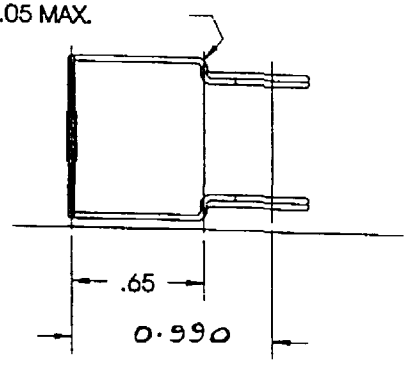


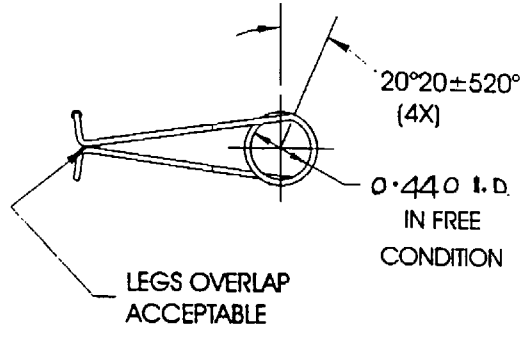


.05 O.D. STAINLESS STEEL TUBE, CRIMPED TO BOTH ENDS OF THE WIRE



ALL BEND RADII TO BE .05 MAX.





FREE CONDITION

1 APPROX. 1.4 COILS.

NOTES: UNLESS OTHERWISE SPECIFIED.

FINISH	POLISHED
MATERIAL	ϕ 0·0315 STAINLESS STEEL 302S26

A. REMOVE ALL BURRS
B. MACHINE SURFACES 63
C. BREAK ALL SHARP EDGES .010 MAX
D. DIMENSIONS PER ANSI Y14.5
E. DIMENSIONS ARE IN INCHES
F. DO NOT SCALE DRAWING

G. TOLERANCES ON
DECIMALS: .XX 2X TOLERANCE; .XXX 3X TOLERANCE
ANGLES: ANGLE TOLERANCE

VIAMED Ltd

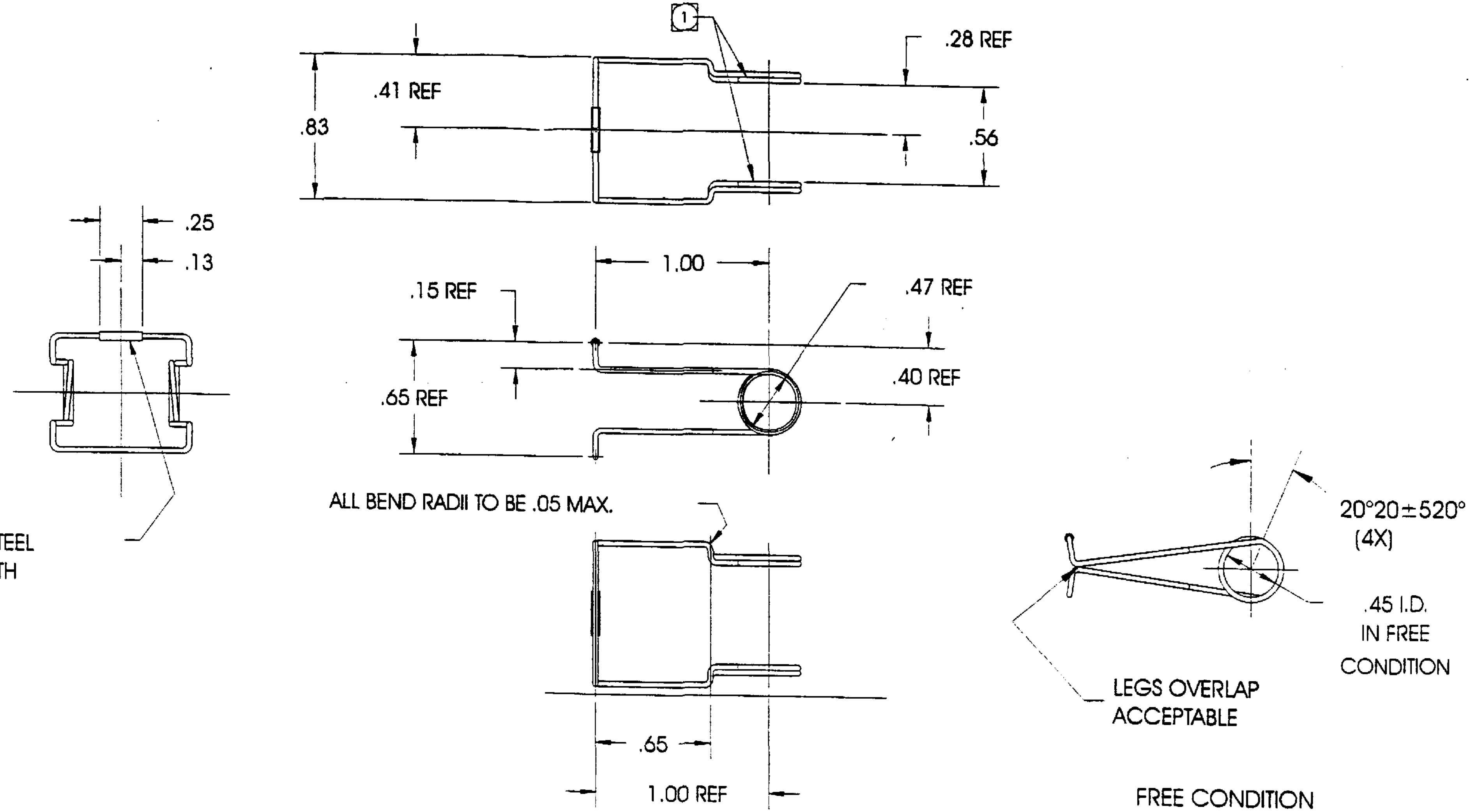
TITLE	WIRE SPRING	
DWG NO.	P103-1	REV 1
SCALE:	SIZE: B	SHEET SHEET OFC

DOS FILE NAME: DOS FILE NAME

Form ENG023 (04/93)

VIAMED
15 Station Road, Cross Hills, Keighley, West Yorkshire
Tel: Cross Hills (0535) 634542 (0535) 636757

96 OCT 1994



1 APPROX. 1.4 COILS.

NOTES: UNLESS OTHERWISE SPECIFIED.

FINISH / MATERIAL: WIRE STAINLESS STEEL BS 2056 316 S42
TUBE STAINLESS STEEL AISI 304 WMD

A. REMOVE ALL BURRS
B. MACHINE SURFACES 63
C. BREAK ALL SHARP EDGES .010 MAX
D. DIMENSIONS PER ANSI Y14.5
E. DIMENSIONS ARE IN INCHES
F. DO NOT SCALE DRAWING

G. TOLERANCES ON

DECIMALS		ANGLES
.XX	2X TOLERANCE	ANGLE TOLERANCE
.XXX	3X TOLERANCE	

VIAMED Ltd

TITLE	WIRE SPRING W3405	
DWG NO.	~~[illegible]~~ 1	REV 1
SCALE:	SIZE: B	SHEET OF

Form ENG023 (04/93)

MODIFICATIONS
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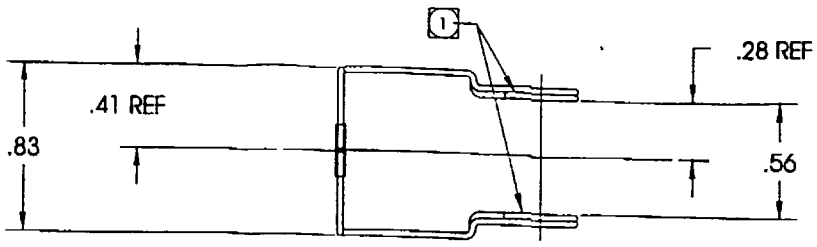
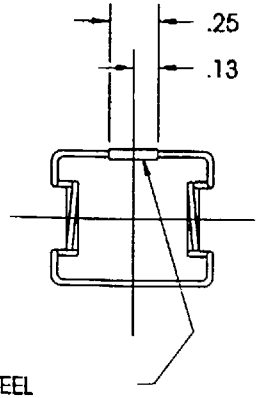
0·990 WAS 1·00
FINISH ADDED.





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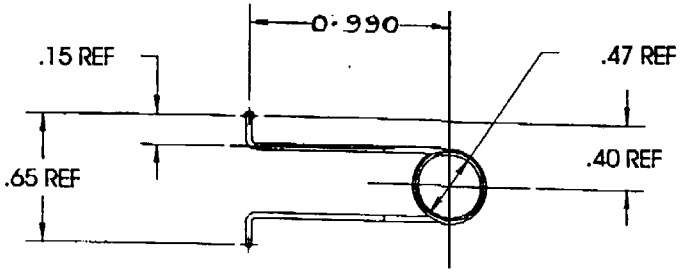
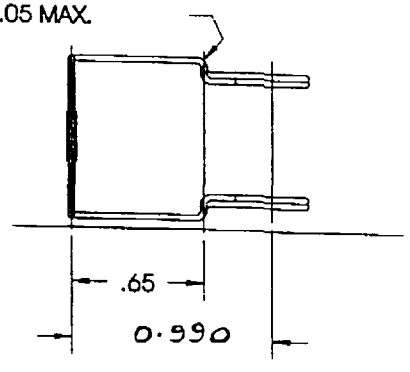
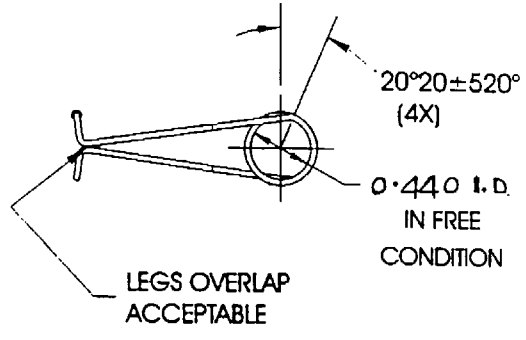


ALL BEND RADII TO BE .05 MAX.





FREE CONDITION

1 APPROX. 1.4 COILS.

NOTES: UNLESS OTHERWISE SPECIFIED.

FINISH	POLISHED
MATERIAL	ϕ 0·0315 STAINLESS STEEL 302S26

A. REMOVE ALL BURRS
B. MACHINE SURFACES 63
C. BREAK ALL SHARP EDGES .010 MAX
D. DIMENSIONS PER ANSI Y14.5
E. DIMENSIONS ARE IN INCHES
F. DO NOT SCALE DRAWING

G. TOLERANCES ON
DECIMALS: .XX 2X TOLERANCE; .XXX 3X TOLERANCE
ANGLES: ANGLE TOLERANCE

VIAMED Ltd

TITLE	WIRE SPRING	
DWG NO.	P103-1	REV 1
SCALE:	SIZE: B	SHEET SHEET OFC

DOS FILE NAME: DOS FILE NAME

Form ENG023 (04/93)

VIAMED
15 Station Road, Cross Hills, Keighley, West Yorkshire
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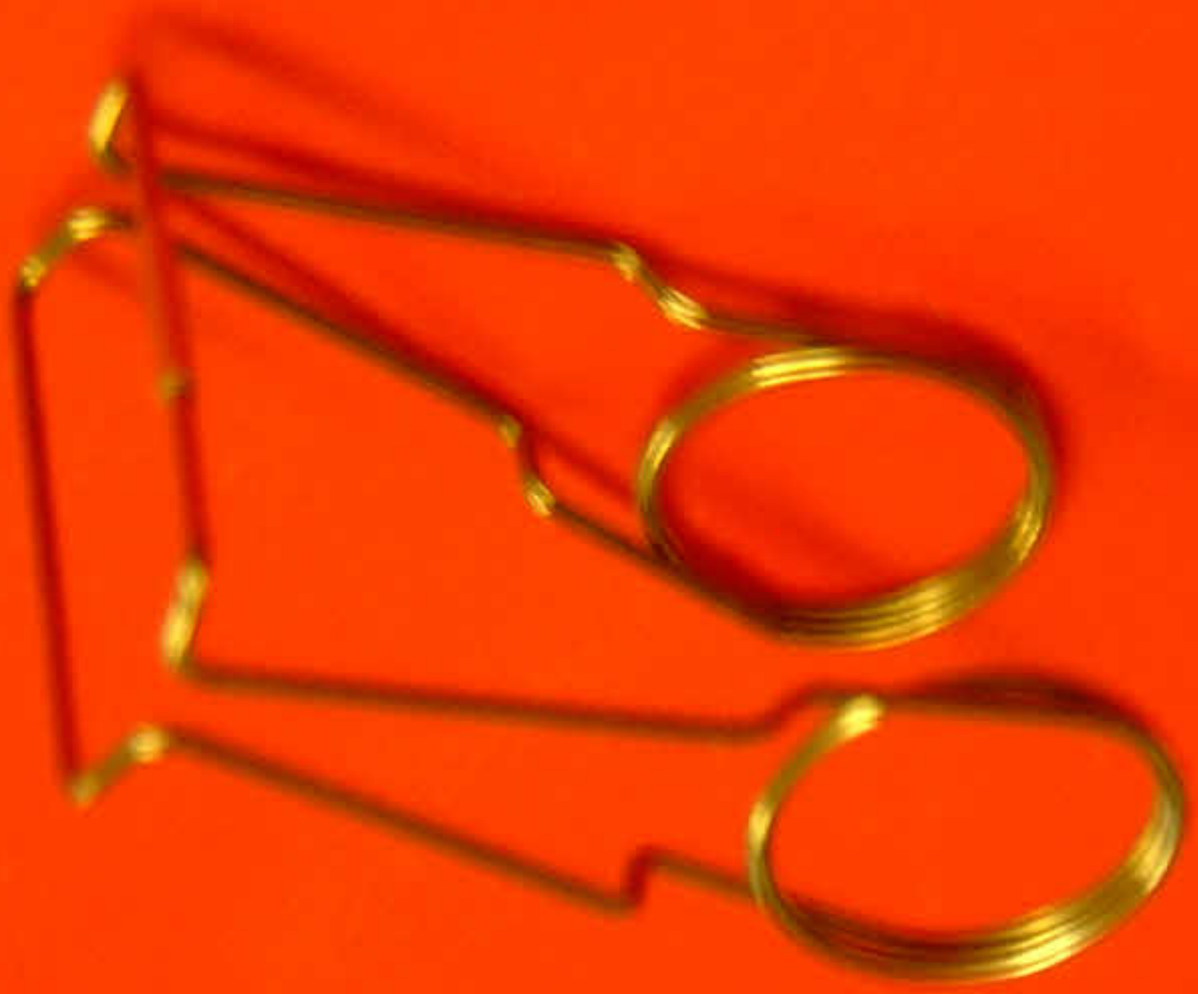

5 October 1999

SpO_2 finger probe spring:

I attended a site meeting at Goss Components with Gerry Barton. The problem with the initial batches of the springs is lack of tension. The week prior to this visit we arranged for sample springs to be made out of a different grade of stainless steel (032). Initially Goss Component over specified the material used by using a medical grade of stainless steel which we found to be too soft and not appropriate for our application.

With the new grade of steel, besides being stronger it is also possible to be temper the springs at higher temperatures, so increasing the tension of the spring.

The lengths of the spring legs were adjusted so that they were exactly the same length, since one was found to be slightly shorter. Even after this adjustment both legs of the springs were increased again by a further 1 mm. This is to make it more compatible with the original spring and also to ensure the aesthetic look of the springs once it has been assembled into the finger clip. The diameter of the spring coil is compatible with the clip buttons, and the end of the spring is flush with the outside of the buttons.

On initial tests the spring was found to be as good, if not better than the original. The tension is good so as to ensure consistent readings, without being too tight so as to adversely effect the perfusion of the patient. Aesthetically once the clip has been opened and extended the clip retains it's original position, so that there is not a gap between the button and the lower part of the clip assembly.

It is anticipated that a sample batch of the new springs will be received on the 6 October. If these are satisfactory they will be officially approved by both Viamed and Goss Components. Goss Components will then supply appropriately amended drawings. Goss component will also manufacture two test jigs, one for Goss to test each spring; and one for Viamed in order to carry out QA batch tests.

A matter that needs to be resolved is what do we do with the 714 springs of lower tension that are presently in stock. I suggest that we keep these (suitably marked) in case we ever have customers who require lower tension springs.

Goss also have a stock of the softer medical grade stainless steel which they would like us to pay for, the price of this will be approximately £300.

If necessary the spring can be further adjusted or redesigned i.e. by altering the diameter of the coil, the angle of the return, or the length of the legs.

S Nixon