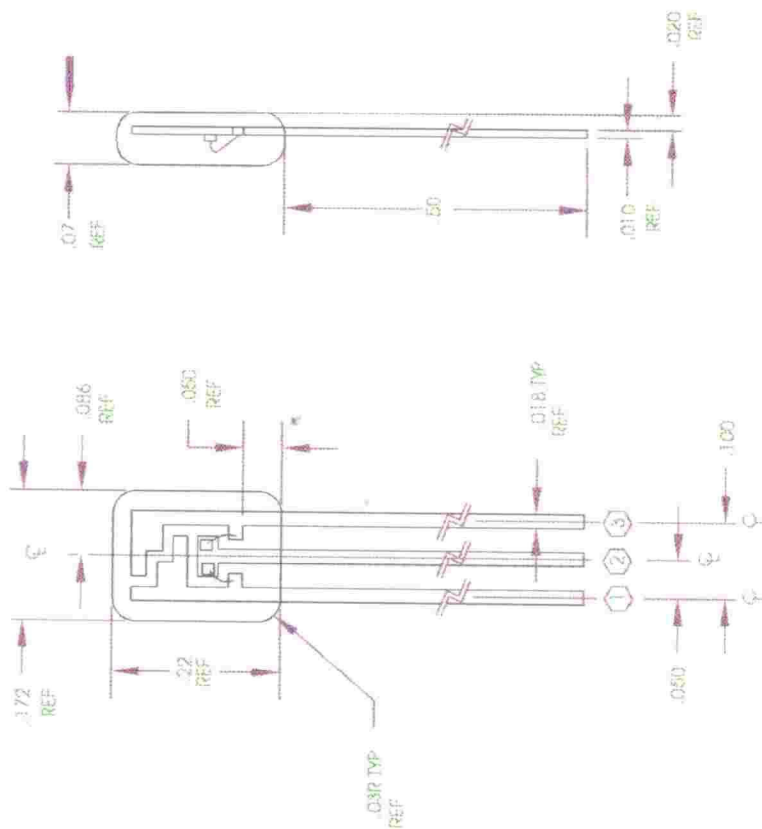
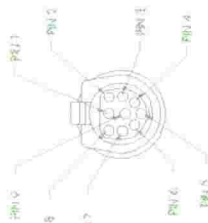


FINISHED PART

NOTES: UNLESS OTHERWISE SPECIFIED.

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FINISH	MATERIAL	✓	G TOLERANCE ON DECIMALS XX" ZN TOLERANCE XXX SW TOLERANCE	ANGLES ↙	ANGLE TOLERANCE	DWG NO.	DRAWING NUMBER	REV REVISION	MEDICAL CABLES™ 9408 CDD-89 ARIZONA, 85034-1554, CA 94889



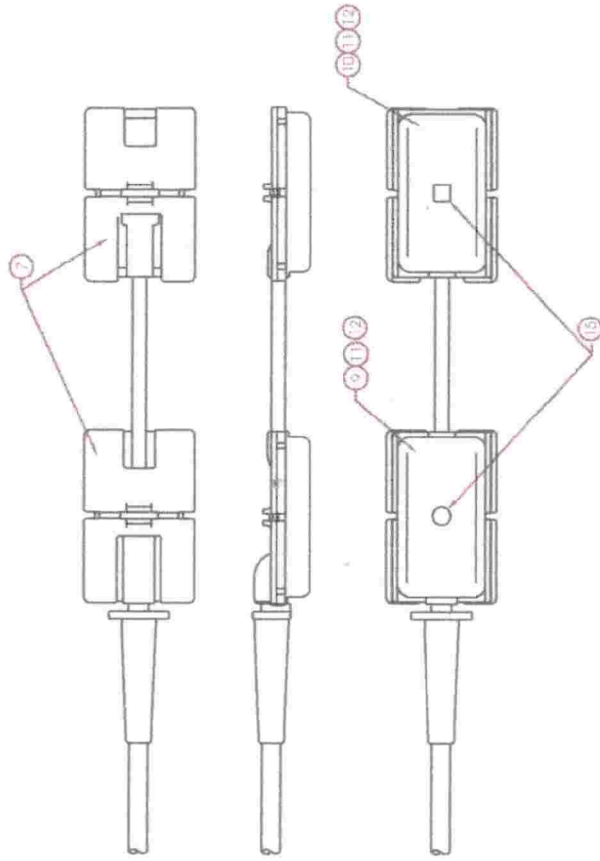
PIN #	PIN #
1	ORANGE
2	RED
3	N/C
4	YELLOW
5	RESISTOR *
6	N/C
7	SHIELD/RESISTOR *
8	WHITE
9	BLACK

* SEE DRAWING FOR DETAILS.

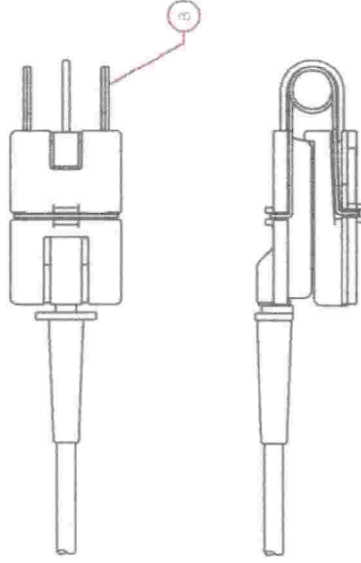


NOTES: UNLESS OTHERWISE SPECIFIED,

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FRAME TO POUCH/CABLE ASSEMBLY



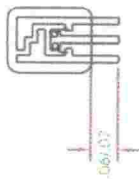
SPRING TO POUCH ASSEMBLY

NOTES: UNLESS OTHERWISE SPECIFIED.

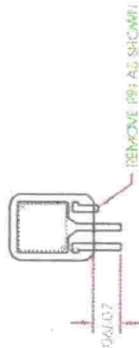
FINISH A. REMOVE ALL BURRS B. MACHINE SURFACES AS SHOWN C. DEBurr ALL SHARP EDGES, ROUNDS MAX. D. DIMENSIONS PER AND YIELDS E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING.		MATERIAL 1. TOLERANCES UNLESS SPECIFIED: FRACTIONS DECIMALS .XX .XX .XXX .XXX .XXX .XXX .XXX .XXX		ANGLE TOLERANCE ANGLES 45° 45° 90° 90° 180° 180°		SCALE B		SIZE B		SHEET 1 OF 1		REV 1		REVISION LETTER 1	
FINISH A. REMOVE ALL BURRS B. MACHINE SURFACES AS SHOWN C. DEBurr ALL SHARP EDGES, ROUNDS MAX. D. DIMENSIONS PER AND YIELDS E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING.				FINISH A. REMOVE ALL BURRS B. MACHINE SURFACES AS SHOWN C. DEBurr ALL SHARP EDGES, ROUNDS MAX. D. DIMENSIONS PER AND YIELDS E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING.				FINISH A. REMOVE ALL BURRS B. MACHINE SURFACES AS SHOWN C. DEBurr ALL SHARP EDGES, ROUNDS MAX. D. DIMENSIONS PER AND YIELDS E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING.				FINISH A. REMOVE ALL BURRS B. MACHINE SURFACES AS SHOWN C. DEBurr ALL SHARP EDGES, ROUNDS MAX. D. DIMENSIONS PER AND YIELDS E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING.			

Form ENG-023 (04/93)

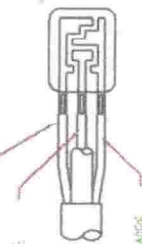
EMITTER



DETECTOR



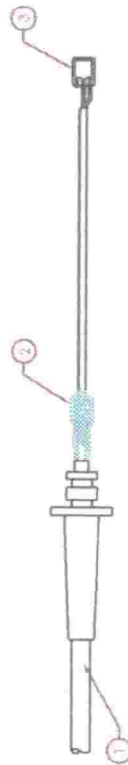
ORANGE WIRE
YELLOW WIRE



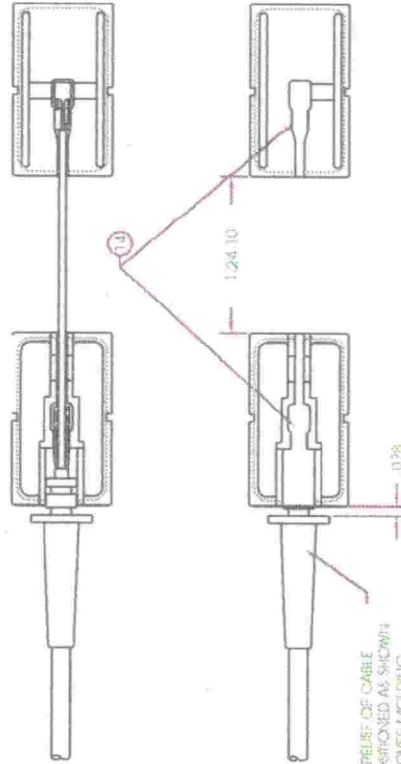
BLACK WIRE

WHITE WIRE

SOLDER WIRE TO BACK SIDE OF P8 (TOP)



CERAMIC ASSEMBLY (LED/DET) TO CABLE



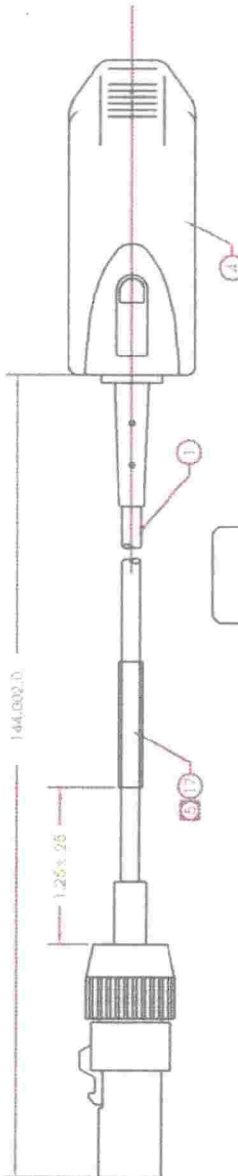
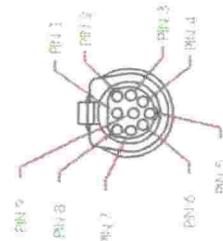
CABLE ASSEMBLY TO POUCH

STRAIN-RELIEF OF CABLE
MUST BE POSITIONED AS SHOWN
PRIOR OVER-MOLDING

FINISH		MATERIAL		TITLE		REV		REVISION LETTER	
A. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES AND DECIMALS THEREOF.		B. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES AND DECIMALS THEREOF.		FINAL ASSEMBLY		DRAWING NUMBER		SHEET 0 OF 1	
C. DIMENSIONS IN PARENTHESES ARE FOR INFORMATION ONLY.		D. DIMENSIONS IN PARENTHESES ARE FOR INFORMATION ONLY.		SCALE: 1:1		SIZE: B		SHEET 0 OF 1	
E. DIMENSIONS IN PARENTHESES ARE FOR INFORMATION ONLY.		F. DIMENSIONS IN PARENTHESES ARE FOR INFORMATION ONLY.		SCALE: 1:1		SIZE: B		SHEET 0 OF 1	

NOTES: UNLESS OTHERWISE SPECIFIED:

Form ENG023 (04/93)

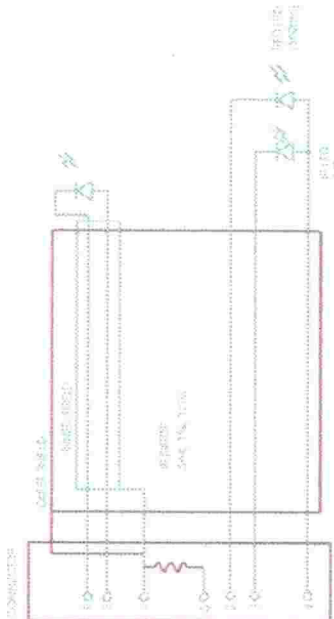


Y: LAST DIGIT OF THE STEP
M: MAXIMUM TEMPERATURE THE ASSEMBLY
EXAMPLE: A - P8/1 B - P8/2 C - MAP
DO NOT USE THESE TEMPERATURES FOR
ASSEMBLY.

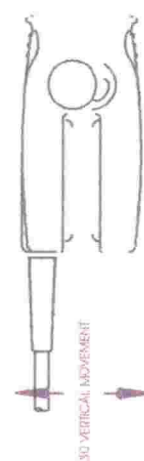
XXXXXXXX

DETAIL A

30° (GREEN BUTTON)



SCHEMATIC



- 1. PRINT SERIAL NUMBER AND DATE CODE ON LABEL. SEE DETAIL A.
- 2. PRIOR APPLYING LIQUID DEFLASH AND CLEAN BOTH WINDOWS FOR BETTER BONDING.
- 3. PRIOR TO APPLYING SILICONE EPOXY (ITEM 11) TO THERMISTAL FRAMES, HEAT BONDING AREA OF COPPER/UM FRAME WITH PRIMER (ITEM 12).
- 4. NO EPOXY (ITEM 11) ALLOWED ON SURFACE OF PROBE. DO NOT APPLY EXCESSIVE EPOXY.



FINISH		TITLE		FINAL ASSEMBLY	
MATERIAL		DWG NO.		DRAWING NUMBER	
A. FINISH OF ALL SURF. B. MACHINING SURFACES AS SHOWN C. SIGMA ALL SURF. EDGES 0.01 MAX D. DIMENSIONS ARE IN INCHES E. DIMENSIONS ARE IN INCHES F. DO NOT SCALE DRAWING		SCALE		SHEET B	
G. TOLERANCES ON DECIMALS XX 2X TOLERANCE XXV 3X TOLERANCE		ANGLES		REV	
				REVISION LETTER	
				SHEET OF OF	

NOTES: UNLESS OTHERWISE SPECIFIED.

Form ENG023 (04/93)

Probe P867 RA 03/25/98