

SpO2 Assembly Instructions				
1/29/995/3/01		P889RA	Issue 1	ver 1
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Equipment type: Finger probe Part Number:		
Batch Size		
Nos	Viamed Part number	Description
1	0010100	Viamed SpO2 finger probe service kit (black pads)
1	0010752	Sub miniature D connector plug kit
3m	0030513	SpO2 cable - version D (production)
30mm	0032331	Heatshrink tubing - clear, 6.0mm, 7m reel

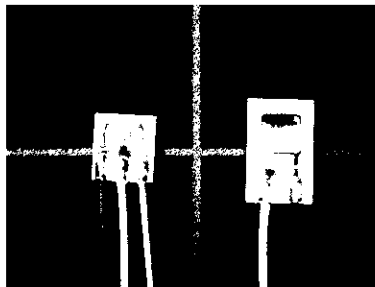
Assembly Clip

1. Prepare Clip end of cable as follows
 - a. Attach strain relief "0010150," to relevant replacement cable, and glue in position.
 - b. Strip back outer cable cover of exposed end 1mm from end of strain relief.
 - c. Remove outer shield and paper, and cut off Kevlar fibres and any unused wires.
 - d. 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.
 - e. 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
 - f. Strip and tin ends of black and white wires.
2. Solder wires to components as per relevant diagram
3. Fit components into pads as follows
 - a. Position components in drying rack.
 - b. Place a small amount of flowable non-corrosive silicone sealant onto the face of the components.
 - c. 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
 - d. Leave pads to set for 24 hours.

Drawn By	MFG&DB
Date	26/04/01
Checked By	
Date	
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4. Assemble the clip as follows
 - a. Glue white inner cable into channel in detector pad
 - b. Fill around component with silicone
 - c. Glue pad support onto back of detector pad.
 - d. Glue pad support onto back of emitter pad.
 - e. Glue white inner cable into channel in emitter pad.
 - f. Fill around component with silicone
 - g. Refit replacement springs "0010140," around pads.
 - h. 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.
 - i. Glue strain relief into position in clip body.



- j. Add labels as required.

Assembly Connector

5. 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/ Twist the shields together, and tin between 12-18mm from the outer cable cover. Cut the twisted shield at 15mm from the outer cable cover.
- j/ Referring to the relevant wiring diagram, solder the wires into the pins.

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k/ Clamp the cable clamp onto the cable, using the cable crimp tool (0010501), 2mm from the end of the outer cable cover.

l/ Push the shroud up over the contact housing, ensuring that the housing fits securely and neatly into the shroud.

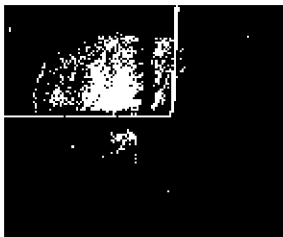
Connector rear view:

1. White
2. Main + inner shield
3. No pin
4. Orange
5. Red
6. Black
7. No pin
8. No pin

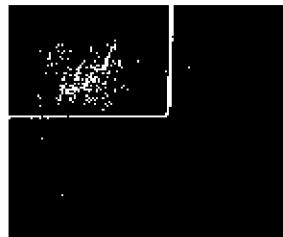
Test using component tester and test box:

Yellow 9.

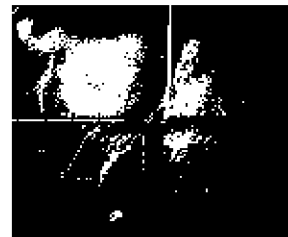
Position 1:Red emitter



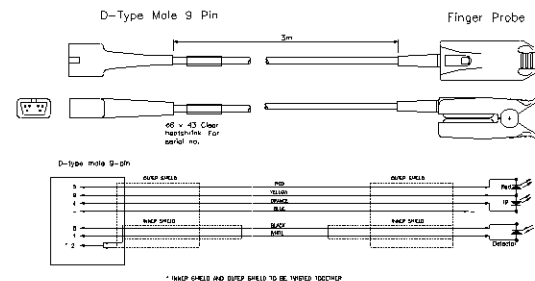
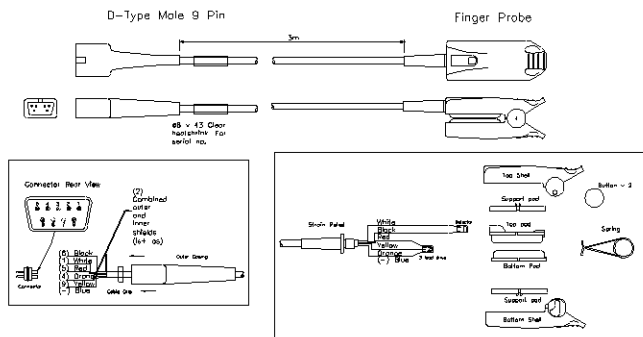
Position 2:IR emitter



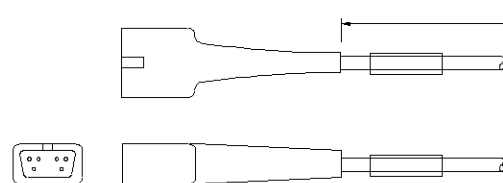
Position 3:Photo-diode



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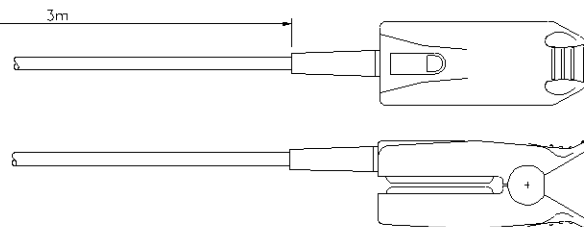


D-Type Male 9 Pin

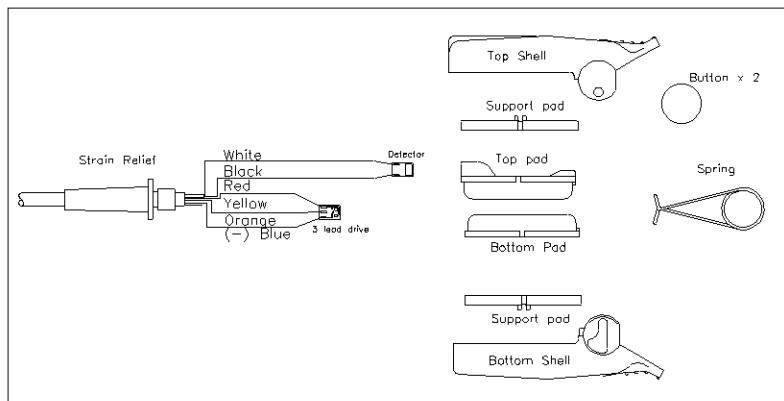
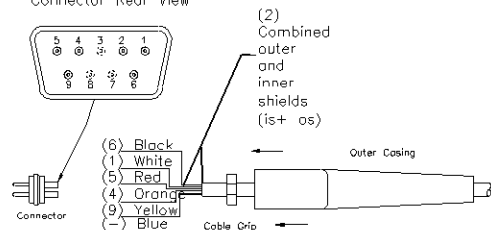


ø6 x 43 Clear
heatshrink. For
serial no.

Finger Probe



Connector Rear View



Title P889RA
Criticare



Dim in mm

Tol ± 0.2

Drawn J.Nirwan

Scale Not To Scale

Date 29/01/02

Dwg No. SPF-889

VIAMED

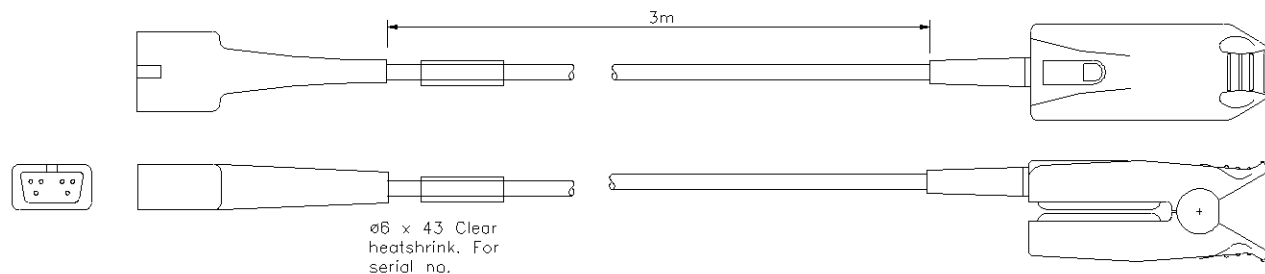
Ltd.

15 Station Rd
Cross Hills, Keighley
West Yorkshire
BD20 7DT

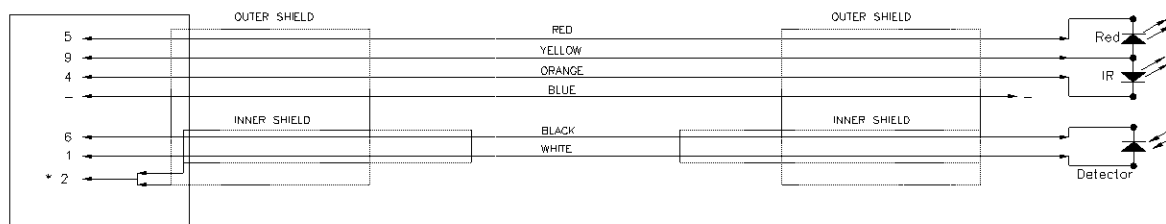
REV	Date	N°	Drawn	Approv	Material :
					Part No. 0018890

D-Type Male 9 Pin

Finger Probe

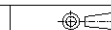


D-type male 9-pin



* INNER SHIELD AND OUTER SHIELD TO BE TWISTED TOGETHER.

Title P889RA
Criticare



Dim in mm

Tol ± 0.2

Drawn J.Nirwan

VIAMED

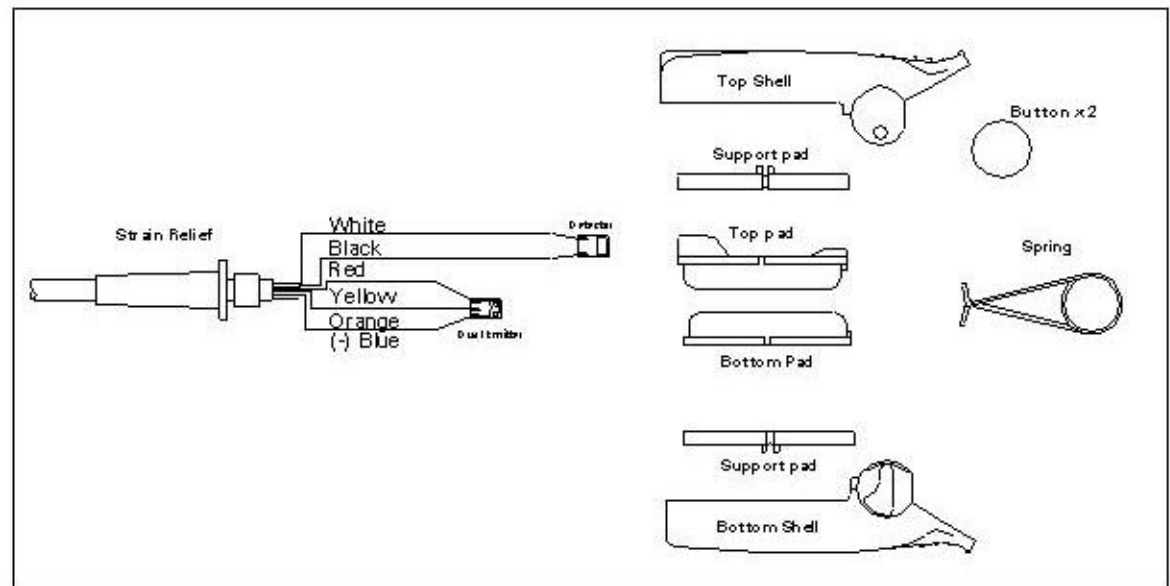
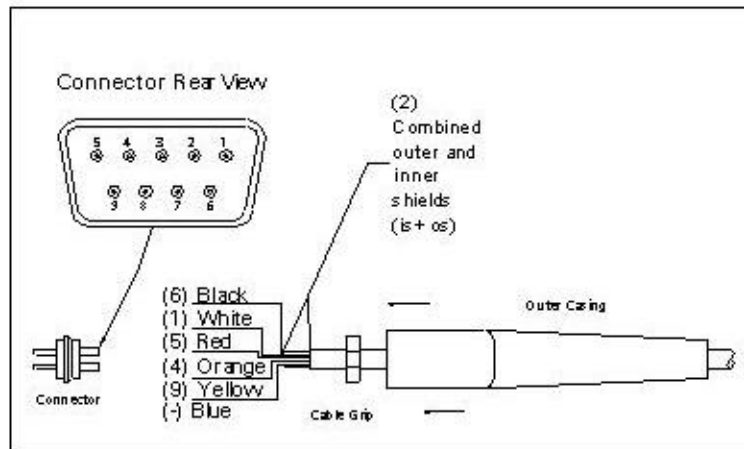
Ltd.

15 Station Rd
Cross Hills, Keighley
West Yorkshire
BD20 7DT

					Material :
REV	Date	N°	Drawn	Approv	Part No. 0018890

Scale	Not To Scale	Date	18/02/03	Dwg No.	SPF-889.1
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Finger Probe



Title: P889RA Criticare			
		Dim in	mm
		Tol	± 0.2
Scale	Not To Scale	Drawn	J.Nirwan
Date	29/01/02	Dwg No.	SPF-889



VIAMED Ltd.
15 Station Rd
Cross Hills, Keighley
West Yorkshire
BD20 7DT

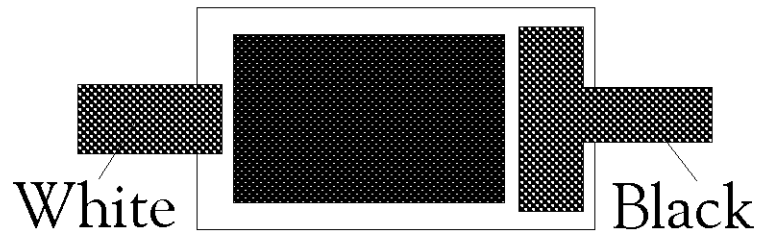




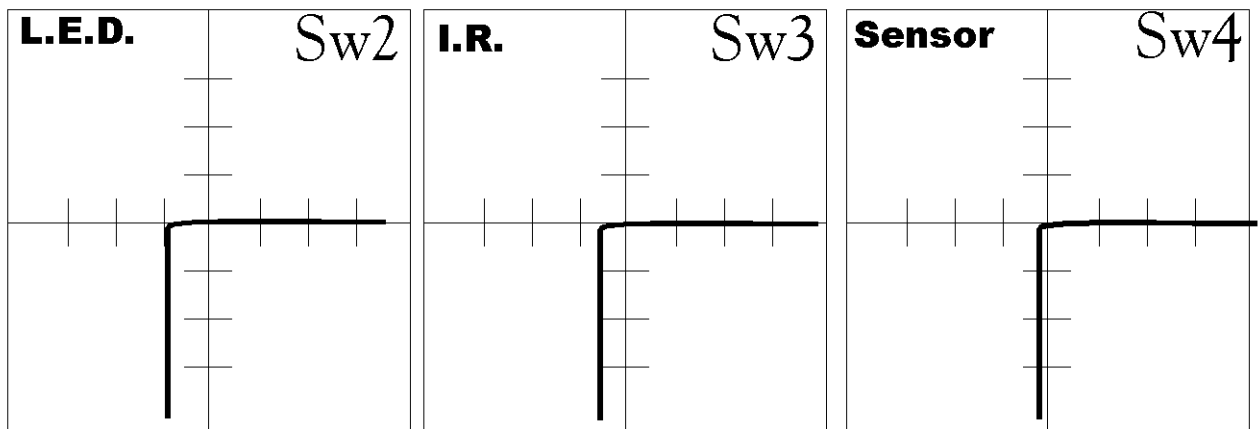
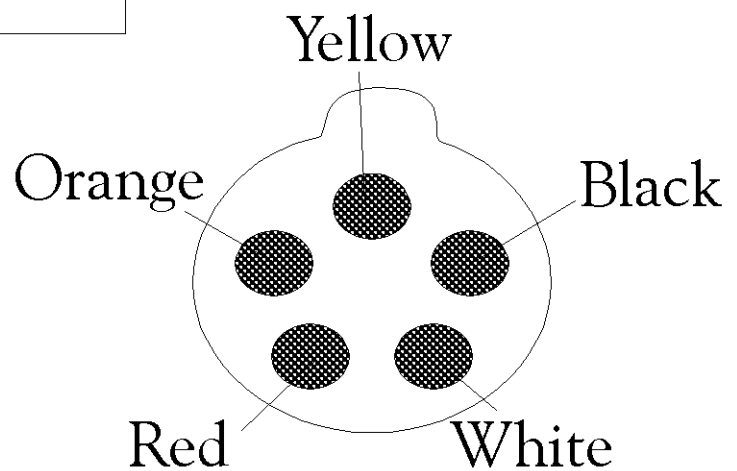
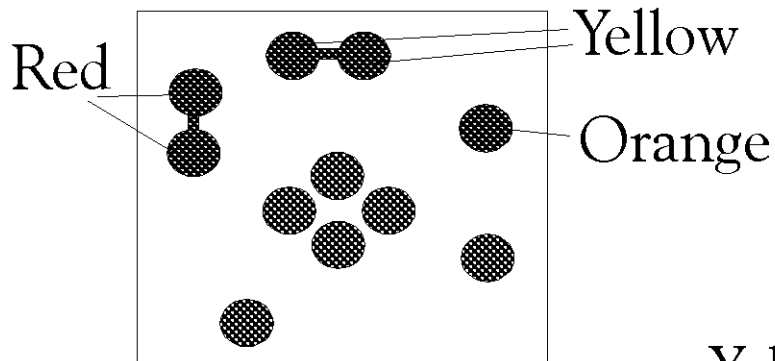
Date	24/03/97	Type	CSI (5 PIN LEMO)
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csi.cmx

Sensor Face Up.



Led Face Down.



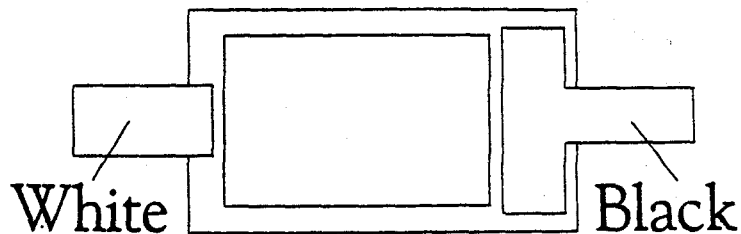
Drawn By	D.Lamb	Signed	
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Date 24/03/97 Type CSI (5 PIN LEMO)

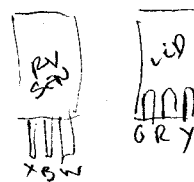
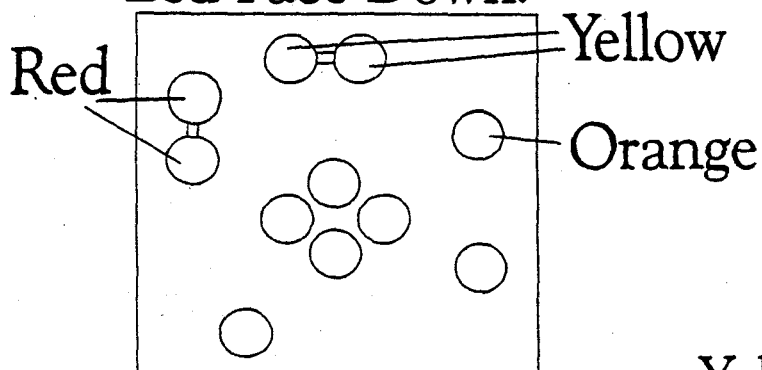
csi.cmx

Cable.

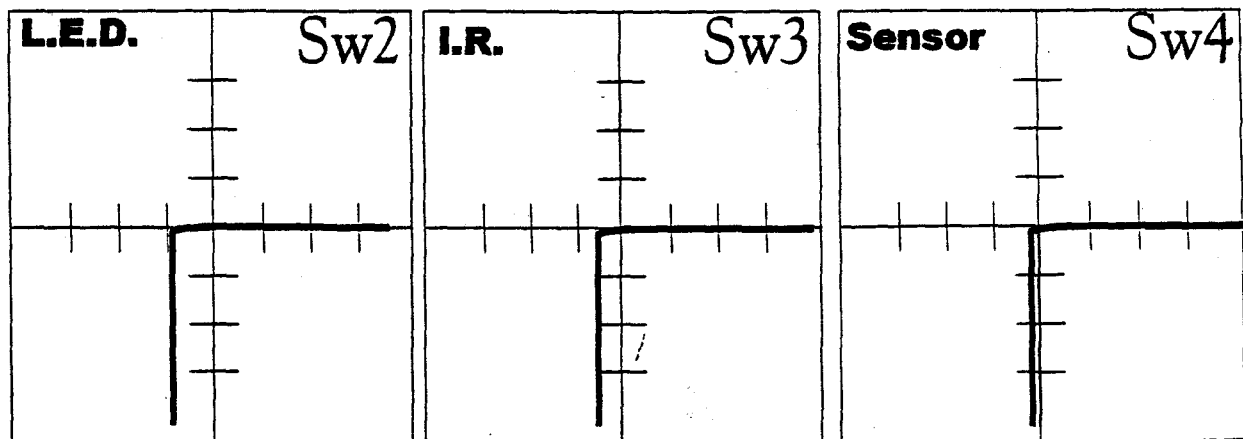
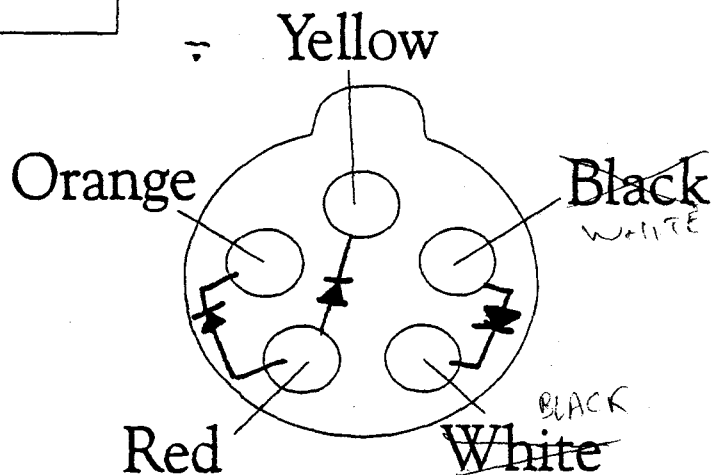
Sensor Face Up.



Led Face Down.



NP, WIRING MAY VARY



Drawn By

D.Lamb

Signed