

Quality criteria for Cables and Cable assemblies

1.0 Standard.

- 1.1 Viamed is certified to ISO9001/EN46001 and needs to be supplied with product that will meet the criteria set by the notified bodies and when used in Viamed products and/or services will meet all EU standards.

2.0 Visual Checks

- 2.1 All cables and assemblies must conform to all physical dimensional specifications as per assembly drawing
- 2.2 All cable and assemblies must conform to all mechanical, material and electrical specifications
- 2.3 Visual inspection should be carried out in approved (local legal requirements) lighting conditions at reading distance (25cm to 40 cms) 10 to 18 inches for sufficient time to ensure a complete inspection.
Additional magnification may be necessary for complete inspection of moulding and/or connector abnormalities

3.0 Cable Jacket.

- 3.1 The cable jacket should be uniform in colour
- 3.2 There should be no loose material
- 3.3 Inner conductors should not be visible through the jacket.
- 3.4 The jacket should be round and a snug fit on the inner conductors
- 3.5 The cable jacket should show no evidence of burns or overheating

Signs of burning on cable jacket

- 3.6 The cable jacket should not have signs of flaring due to overheating

Flaring of Insulation

- 3.7 The cable jacket should not have melted insulation, or insulation pulled back from the conductor jacket
- 3.8 The cable jackets should be cut square so that no strips remain.

Incomplete stripping of insulation



- 3.9 The outer jacket should not have any scratches, cuts or damage that expose the inner conductors.

Nicks or cuts that expose the inner conductors

- 3.10 Colour variations or stains must be limited
- a) not less than 20 cms (8 inches) apart
 - b) maximum of three on any one cable
 - c) stain size should be less than 0.35 mm x 0.35 mm
- 3.11 The cable should be free from nodules or limited to
- a) not less than 20 cms (8 inches) apart
 - b) nodule size should be less than 0.1 mm
 - c) Maximum of three per cable
- 3.12 Discoloured nodules or nodules due to foreign material should be rejected.
- 3.13 Inner conductors must not be damaged or kinked after exiting the strain relief.

Kinked conductor emerging from strain relief

1.0 Connector & Strain relief

- 4.1 pits must be less than 0.2 mm in diameter and no nearer than 0.2 mm from any other pit
- 4.2 no more than 4 pits are allowed
- 4.3 connector must not be deformed

Deformation and voids

- 4.4 connector must be able to be installed into a mating connector
- 4.5 Incomplete moulding on the connector must not be greater than 0.5 mm or expose underlying material
- 4.6 Incomplete moulding on the strain relief must not exceed 25% of the moulded area or be in such an area to affect the security of the strain relief when it is added into a housing.
- 4.7 Scratches on the top of the connector must be less than 0.1 mm wide and 0.3 mm long
- 4.8 Each scratch must be separated by at least 0.5 mm
- 4.9 The combined length of all scratches must not exceed 1.5 mm and scratches must be separated by at least 0.5mm
- 4.10 Foreign material must not be more than 0.3 mm in diameter
- 4.11 A maximum of two is acceptable
- 4.12 Foreign material blemishes should be separated by 1.5 mm



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- 4.13 Foreign material below the surface may not become loose
- 4.14 Flash must not protrude more than 0.2 mm from the body of the device
- 4.15 Ejector pin marks should not be indented or protrude more than 0.1 mm