

COMPANY OPERATING PROCEDURES

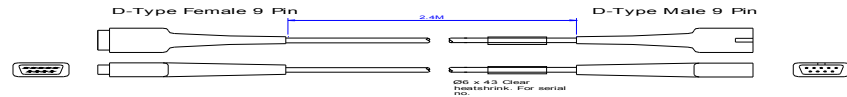
0019568-01 NELLCOR P956E8

VM3/COP/33.08

Date: 17-Dec-01









Revision date: 6-Nov-13

Issue: 3



Equipment required: Soldering iron (0060120), solder (0050012), Wire stripper (0060030), Flush Cutter (0060010), Snipe nose pliers (0060021), 'helping hand' (0060145), Heat gun (0060100).

Parts list: Kit and parts required. (Continued over page)

D-Type female 9-pin Side			D-Type male 9-pin Side		
Qty	Description	Part No.	Qty	Description	Part No.
1	D-type female 9-pin kit	0031220	1	D-Type male 9-pin kit	0031200
(1)	 Outer Casing	kit	(1)	 Outer Casing	kit
(1)	 Cable grip	kit	(1)	 Cable grip	kit
(1)	 Pin Housing	kit	(1)	 Connector	kit
(9)	 Pins	kit	(9)	 Pins	kit
1	2.5m 6-core cable	0030513 (roll)	1	Ø6 x 43mm Clear heat shrink	0032331 (roll)
1	Ø1.6 x 17mm heat shrink	0032310 (roll)	1	Ø1.6 x 17mm heat shrink	0032310 (roll)
1	Ø6 x 10mm heat shrink	0032321 (roll)	1	Ø6 x 10mm heat shrink	0032321 (roll)

ASSEMBLY OPERATIONS

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1. Pre Heat soldering iron temperature to 240°C.
2. Collect all required parts and equipment listed above.
3. Cut a 2.5 metre length of standard 6-core cable. Shown below.

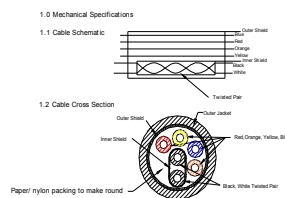


Fig 1.

D-Type female 9-pin side:

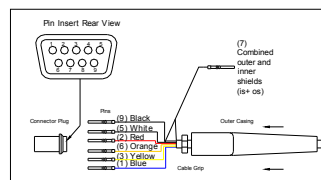


Fig 2.1

1. Feed outer casing, cable grip and Ø6 x 10mm heat shrink (black) over end of cable.
2. Strip 20mm off outer jacket of wire to reveal coloured wires, outer shield, and nylon/paper wire packing.
3. Cut all packing to the base.
4. Strip 20mm off inner jacket to reveal black and white wires and the inner shield.
5. Twist outer and inner shields together.
6. Trim ends of wires and shields to the same length.
7. Strip jacket of every wire 2mm to reveal copper core.
8. Heat Ø1.6 x 17mm heat shrink over twisted inner and outer shields to cover naked wire, and solder end to the rear of one pin.
9. Apply small amount of solder to ends of each wire and solder each of the 5 wires to the rear separate pins.
10. Clamp cable grip approximately 2mm from end of outer jacket.

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11. Place Ø6 x 10mm heat shrink over cable grip and beginning of wires and heat to shrink firmly over.
12. Push outer casing over cable grip and wires to fit around the pin housing.

D-Type male 9-pin side:

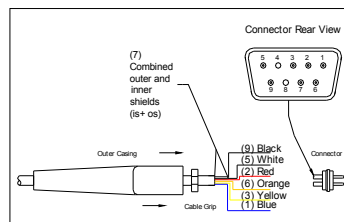


Fig 2.2

1. Feed outer casing, cable grip and Ø6 x 10mm heat shrink (black) over end of cable.
2. Strip 20mm off outer jacket of wire to reveal coloured wires, outer shield, and nylon/paper wire packing.
3. Cut all packing to the base.
4. Strip 20mm off inner jacket to reveal black and white wires and the inner shield.
5. Twist outer and inner shields together.
6. Trim ends of wires and shields to the same length.
7. Strip jacket of every wire 2mm to reveal copper core.
8. Heat Ø1.6 x 17mm heat shrink over twisted inner and outer shields to cover naked wire.
9. Apply small amount of solder to ends of each wire and shields.
10. Solder ends of every wire and shields to the correct positions on the rear of the connector.
11. Clamp cable grip approximately 2mm from end of outer jacket.
12. Place Ø6 x 10mm heat shrink over cable grip and beginning of wires and heat to shrink firmly over.
13. Push outer casing over cable grip and wires to fit around the pin housing.

TESTING

1. Attach male 9-pin side to the test box connector marked 'A'.
2. Attach female 9-pin side to a Nellcor finger probe.
3. Check display is showing correct characteristics as shown below. (At correct switch positions)

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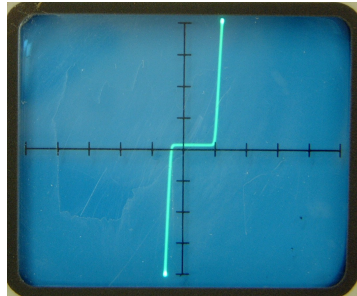
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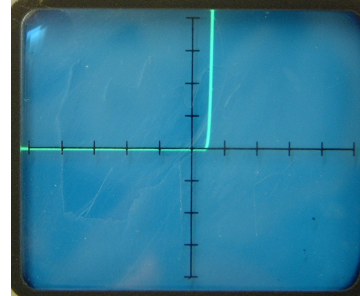
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NB: Gap to be at bottom of display
Position 2. IR, LED.

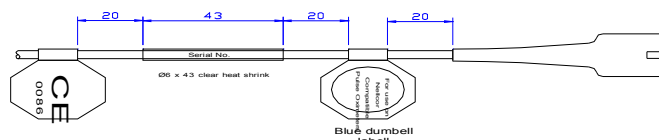


Position 4. Detector

4. If the gap is at the top of the screen then the LED is wired incorrectly.
5. 'Play' with wire at connections to see if any change in the display (i.e. flickering etc).
6. If there is any movement of signal, the extension wire must be taken apart and all connections checked and re-soldered. Then tested again until results are satisfactory.
7. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
8. Connect male 9 pin side to the Nellcor monitor and attach probe on finger to check SpO₂ level. (Ideal reading 95-100.)

Labelling

1. Labels: to be attached facing upwards as looking at the top of the probe.
 - 1 x CE Label
 - 1 x Serial no. Label
 - 1 x Blue Nellcor dumbbell Label



Quality Assurance (QA)

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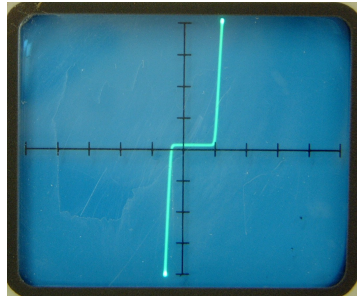
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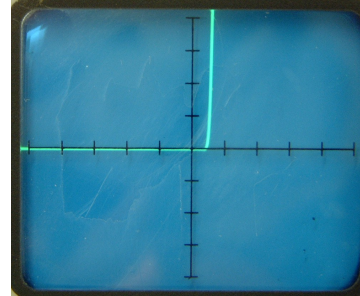
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7. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
8. Connect male 9 pin side to the Nellcor monitor and attach probe on finger to check SpO₂ level. (Ideal reading 95-100.)
9. Fill and sign attached paperwork.
10. Test 10 % of batch on DL3000 simulator.
11. Log all results on compatibility sheet.

Packaging

1. Visually check all labels are attached properly
2. Using a twist tie (bunny clip) wrap the cable and place in a small blue Viamed plastic box, ensuring the cable is inserted in a neat and tidy presentable manor.
3. Place a serial number sticker (supplied with the batch) on the front face of the box.
4. Place a packed and tested sticker (also containing initials of the individual who is packing) on the right hand side top left corner of the box. Do not close box.

Final QA

1. Final inspection. Visually ensure cable sit neatly within the box and is in a presentable state.
2. Boxes are ready to stock in stores.