

24-Aug-15.

Revision date: 10-Oct-16

VM3COP61.11 Production Procedure for Microstim DB3 Tester (2510005)

Parts list		
Qty	Description	Part No.
1	Key fob case	0131352
1	PCB	
1	BNC socket	
1	LED	
1	LED surround	
1	Microstim lead	2520000
1	Strain relief	0010618
1	R1	
1	R2	
1	R3	
1	R4	
1	TH1	
1	D1	
10mm	Heat shrink (6.0mm)	0032321
1	Cable clamp	0030500

Tool list	
Soldering iron	
Wire cutters	
Stanley knife	
Snipe nose pliers	
Phillips screw driver (size 0)	
Low melt glue gun	
Reaming tool	
Cable clamp pliers	

24-Aug-15.

Revision date: 10-Oct-16

- 1) Take the key-fob case and mark a pilot hole as shown.



- 2) Using a small handheld drill, drill through the case.



- 3) Using a reaming tool, enlarge the hole to 10mm to fit the BNC connector.



- 4) Remove the keyring bar.



24-Aug-15.

Revision date: 10-Oct-16

- 5) File smooth any remnants of the keyring bar.



- 6) Mark a pilot hole for the strain relief.



- 7) Using a reaming tool, enlarge the hole to 6mm to fit the strain relief.



- 8) Affix the top label to the case.
- 9) In the centre of the label hole mark a pilot hole for the LED.



24-Aug-15.

Revision date: 10-Oct-16

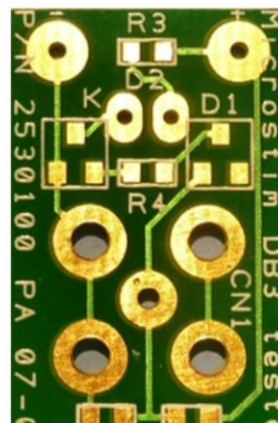
- 10) Using a small handheld drill, drill through the case.
- 11) Using a reaming tool, enlarge the hole to 8mm to fit the LED surround.



- 12) Insert the LED surround and screw on the back nut.



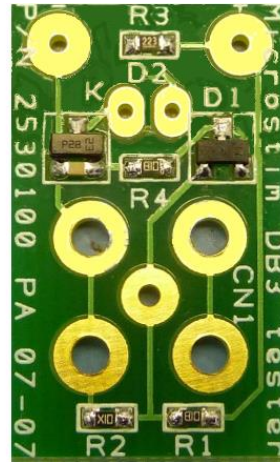
- 13) Using an abrasive PCB cleaner, clean the PCB solder contacts.



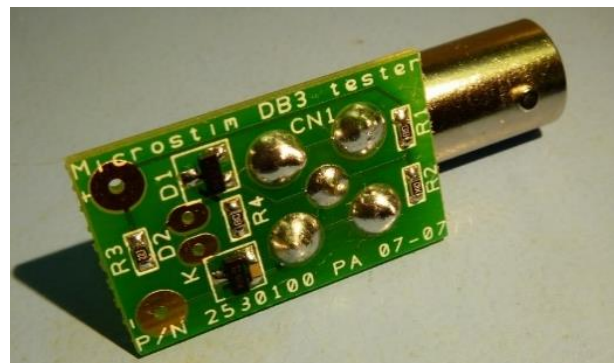
24-Aug-15.

Revision date: 10-Oct-16

- 14) Populate the PCB with components as shown.

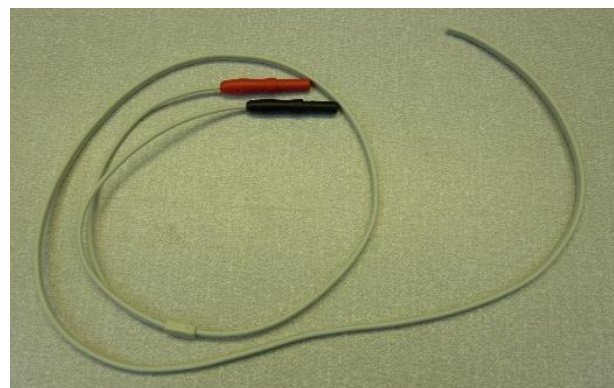


- 15) Solder the BNC connector to the PCB.



- 16) Trim the press-studs from the cable.

- 17) Trim the cable to 75cm.



- 18) Insert the strain relief into the hole at the back of the case.

- 19) Attach the cable clamp 35mm from the end of the cable.

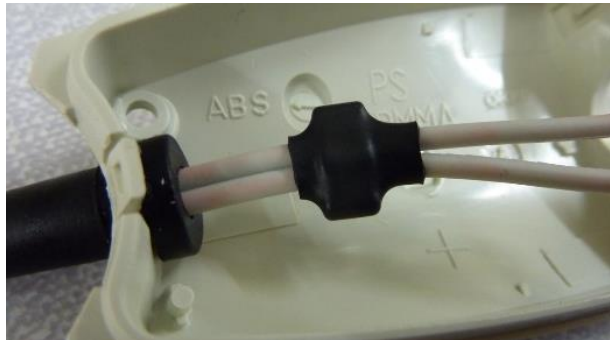
- 20) Strip and tin 5mm on each of the wires.



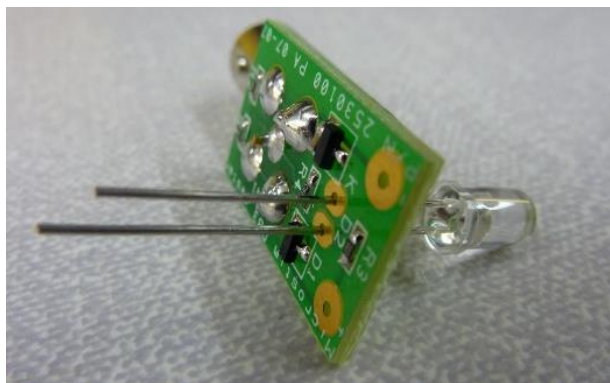
24-Aug-15.

Revision date: 10-Oct-16

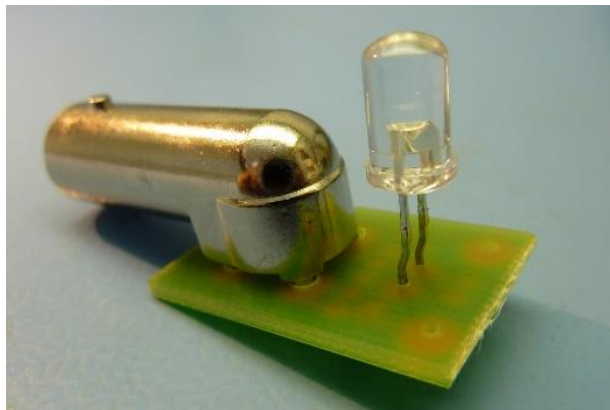
- 21) Apply 10mm of 6mm heat shrink to the cable clamp.



- 22) Insert the LED as shown.



- 23) Solder the LED in place. The LED should be 7mm above the PCB.



- 24) Solder the lead to the PCB. The red lead to the positive contact and the black lead to the negative contact.

- 25) Insert the PCB into the case.



24-Aug-15.

Revision date: 10-Oct-16

- 26) Test the unit is working by attaching a Microstim DB3 and testing its functions.



- 27) Using low-melt glue, affix the PCB into the case.



- 28) Attach the case top and insert the retaining screw.
- 29) Affix the serial number label to the underside of the case.
- 30) The unit is now ready for QA.

