24-Aug-15.

Revision date: 26-Jul-18

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/connector	2530102
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

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.

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.

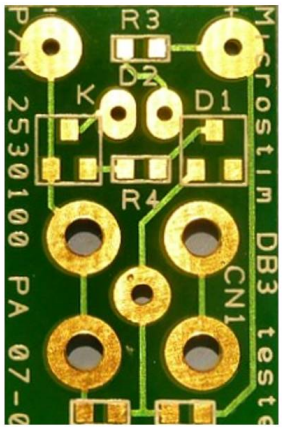
9) In the centre of the label hole mark a pilot hole for the LED.

10) Using a small handheld drill, drill through the case.

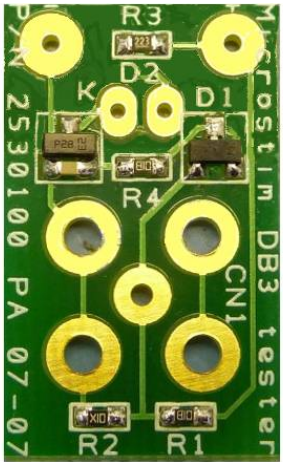
11) Using a reaming tool, enlarge the hole to 8mm to fit the LED surround.

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

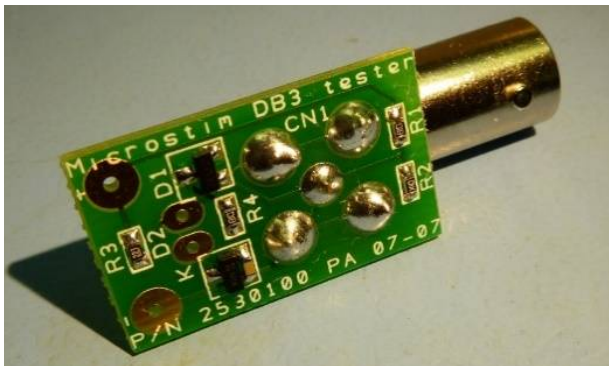
13) Using an abrasive PCB cleaner, clean the PCB solder contacts.



14) Populate the PCB with components as shown.

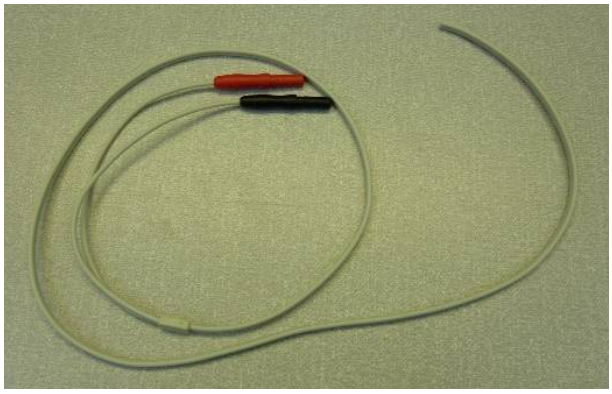


15) Solder the BNC connector to the PCB.



16) Trim the press-studs from the cable.

17) Trim the cable to 75cm.

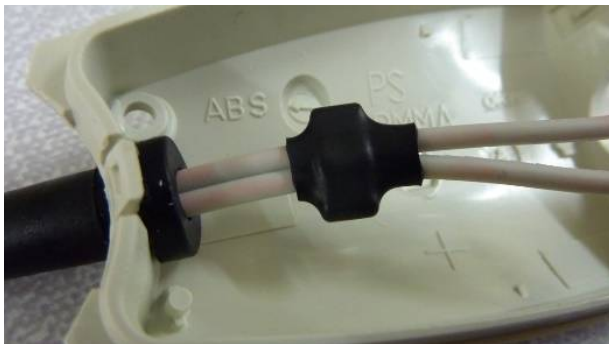


18) Insert the strain relief into the hole at the back of the case.

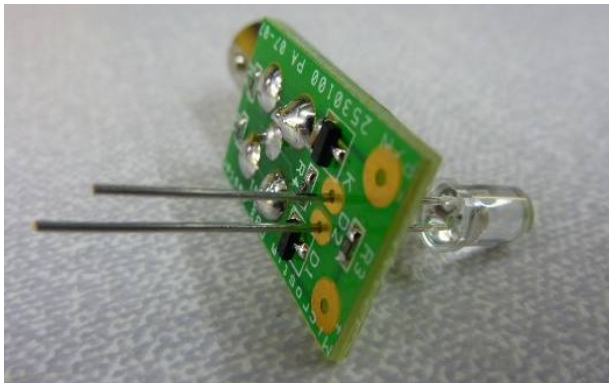
19) Attach the cable clamp 35mm from the end of the cable.

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

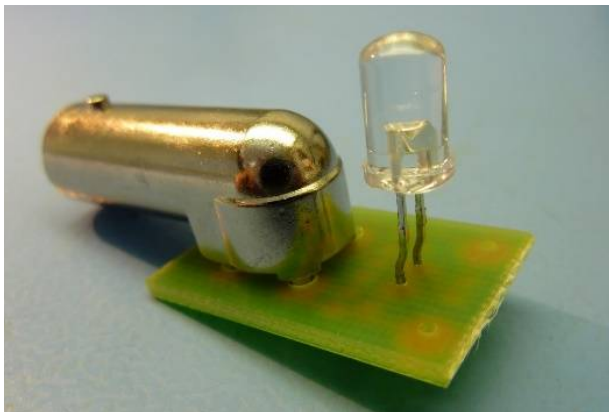
21) Apply 10mm of 6mm heat shrink to the cable clamp.



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.

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.