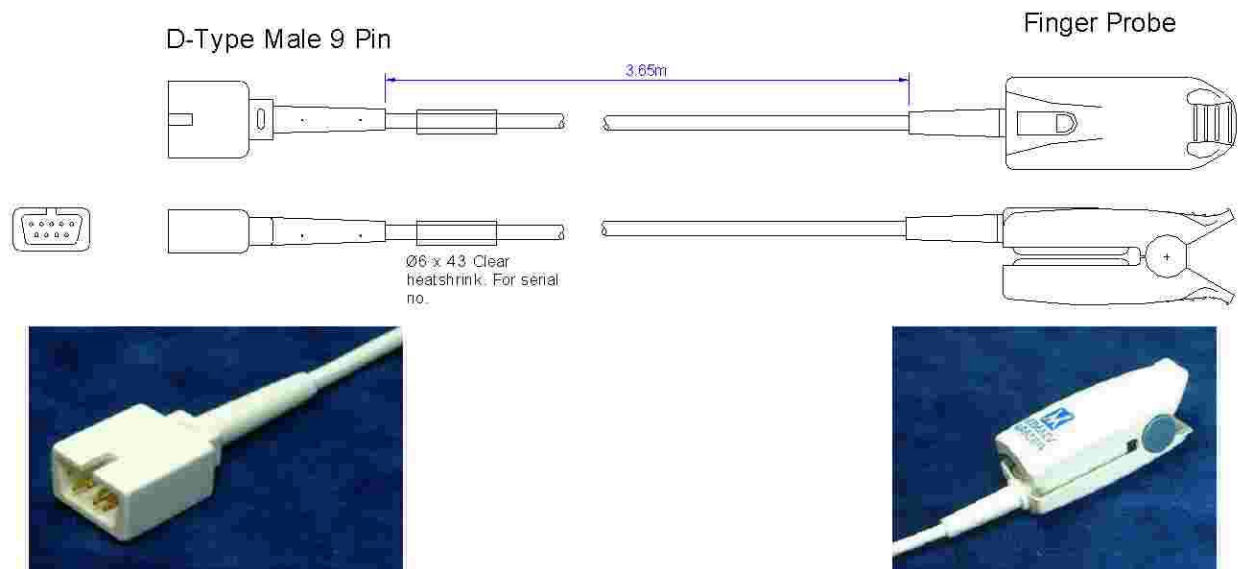


COMPANY OPERATING PROCEDURES

0018580 Nellcor P858RA


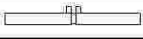


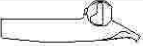





VM3/COP/32.05

Date: 19-Dec-01 Revision date: 17-May-04 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.

D-type male 9-pin side			Finger Probe Side		
Qty		Part No.	Qty	Description	Part No.
1	Pre-manufactured cable	0018587	1	 Top Shell	0010110
			2	 Pad Support (Blue)	0010161
			1	 Top Pad (white)	0010130
			1	 Bottom Pad (white)	0010131
			1	 Bottom Shell	0010111
			1	 Spring	0010140
			2	 Button (Blue)	0010181
			1	 Detector	0030902
			1	 LED/ I.R.	0030955
			1	 Strain Relief	0010150

COMPANY OPERATING PROCEDURES

0018580

Nellcor

P858RA

VM3/COP/32.05

Date: 19-Dec-01

Revision date: 17-May-04

Issue: 3

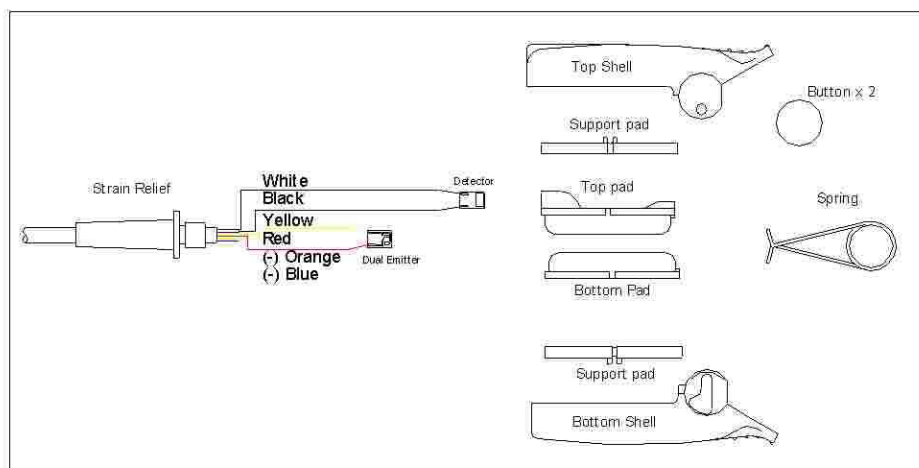
ASSEMBLY OPERATIONS

1. Pre Heat soldering iron temperature to 240°c.
2. Collect all required parts and equipment listed above.

D-type male 9-pin side:

1. Pre manufactured (0018587 sub assembly) wire needs no work on this side.

Finger Probe side:



1. Solder wires to the detector, LED/I.R as shown in fig 2.3
2. Place the assembly on the drying rack, and apply a small amount of clear silicon to the front of the detector and LED/I.R and mount into the pads (Led/IR in the top pad and Detector in the bottom pad) allowing the sensors to be seen and central, and scrape excess silicon. Then place the drying rack in the drying cabinet and leave to dry overnight.
3. Superglue loose cable to the pads and fill the rears with white silicon.
4. Glue pads onto the pad supports (prime first).
5. Place spring around pads and into place.
6. Clip upper and lower shells (use a little super glue) into place and glue buttons onto the sides.

TESTING

1. Attach D-type male 9-pin side to the test box connector marked 'A'.
2. Check display is showing correct characteristics as shown below. (At correct switch positions)

COMPANY OPERATING PROCEDURES

0018580

Nellcor

P858RA

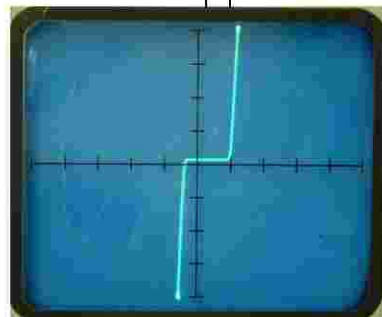
VM3/COP/32.05

Date: 19-Dec-01

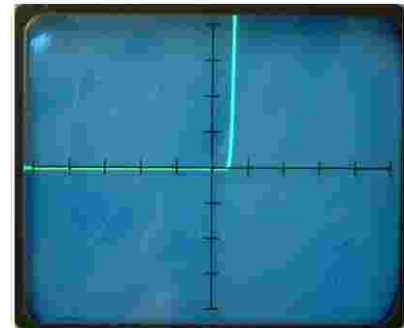
Revision date: 17-May-04

Issue: 3

LED should read approx 1.8v



Position 1. IR, LED.

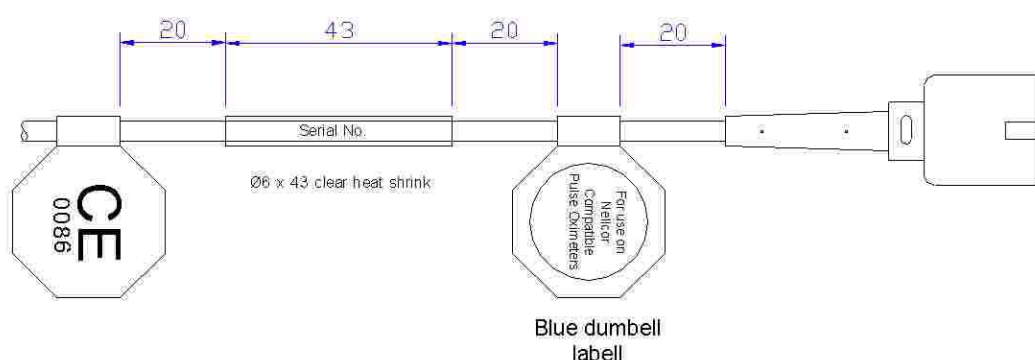


Position 4. Detector

3. If the LED signal is at the bottom then it is wired incorrectly.
4. 'Play' with wire at connections to see if any change in the display (i.e. flickering etc).
5. If there is any movement of signal, the cable must be taken apart and all connections checked and re-soldered. Then tested again until results are satisfactory.
6. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
7. Attach D-type male 9-pin side to a Nellcor monitor and the probe on to the 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 Viamed shell label on probe lower shell.
 - 1 x Serial no. Label
 - 1 x Blue Nellcor dumbbell Label.



COMPANY OPERATING PROCEDURES

0018580

Nellcor

P858RA

VM3/COP/32.05

Date: 19-Dec-01

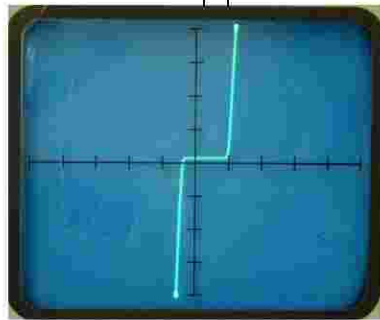
Revision date: 17-May-04

Issue: 3

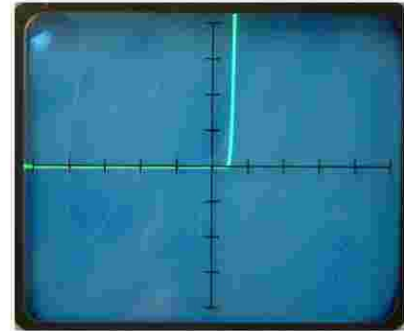
Quality Assurance (QA)

1. Attach D-type male 9-pin side to the test box connector marked 'A'.
2. Check display is showing correct characteristics as shown below. (At correct switch positions)

LED should read approx 1.8v



Position 1. IR, LED.



Position 4. Detector

3. If the LED signal is at the bottom then it is wired incorrectly.
4. 'Play' with wire at connections to see if any change in the display (i.e. flickering etc).
5. If there is any movement of signal, the cable must be taken apart and all connections checked and re-soldered. Then tested again until results are satisfactory.
6. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
7. Attach D-type male 9-pin side to a Nellcor monitor and the probe on to the finger to check SpO₂ level. (Ideal reading 95-100.)
8. Fill and sign attached paperwork.
9. Test 10 % of batch on DL3000 simulator.
10. 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.