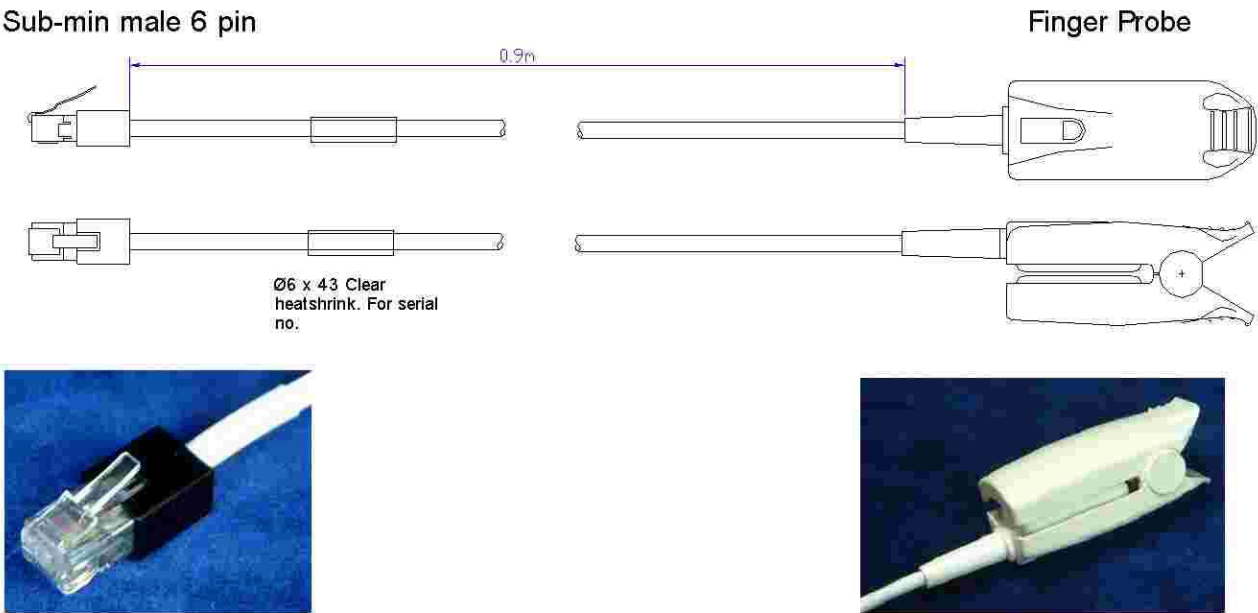


COMPANY OPERATING PROCEDURES

0018740 Palco P874RA

VM3/COP/32.19

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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)


Sub-min Male-6 pin side			Finger Probe Side		
Qty	Description	Part No.	Qty	Description	Part No.
1	Sub-min Male-6 pin kit	0010717	1	Top Shell (x25)	0010110
(1)	Connector	Kit	2	Pad Support (white) (x50)	0010160
(1)	Wire Housing	Kit	1	Top Pad (white)(x25)	0010130
(1)	Cable Grip	Kit	1	Bottom Pad (white)(x25)	0010131
(1)	Outer Housing	Kit	1	Bottom Shell (x25)	0010111
1	Ø6 x 43mm Clear heat shrink	0032331	1	Spring (x25)	0010140
1	Ø6 x 10mm heat shrink	0032321	2	Button (White) (x50)	0010180
1	Ø1.6 x 17mm heat shrink	0032310	1	Detector	0030903
			1	LED/ I.R.	0030956.

COMPANY OPERATING PROCEDURES

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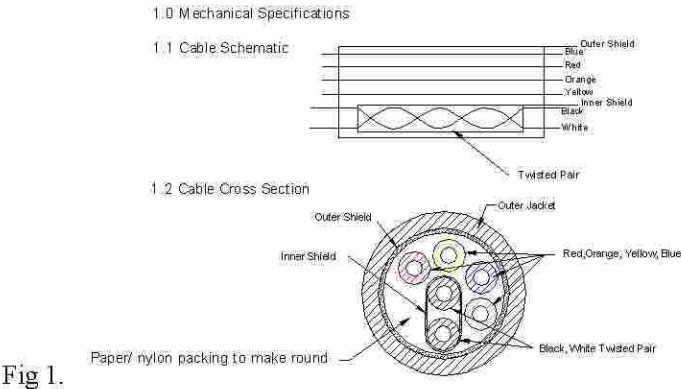
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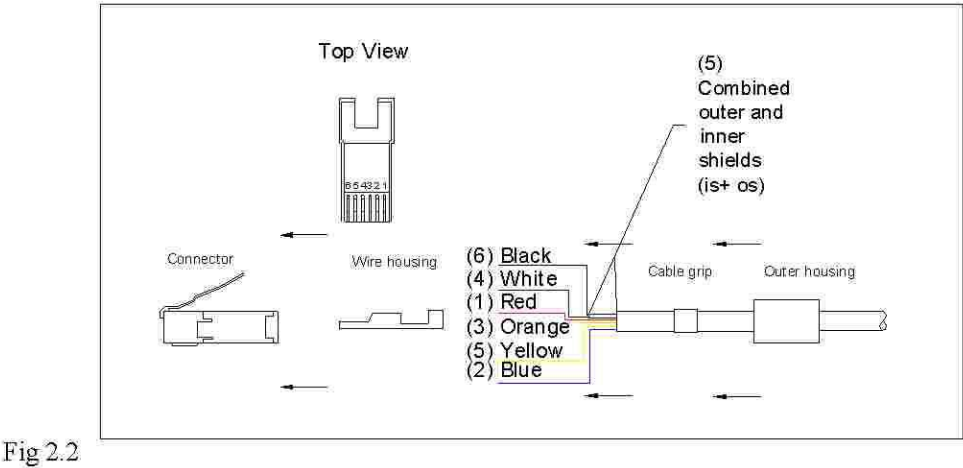
			1		Strain Relief	0010150
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ASSEMBLY OPERATIONS

- 1. Pre Heat soldering iron temperature to 240°c.
- 2. Collect all required parts and equipment listed above.
- 3. Cut a 1 metre length of standard 6-core cable. (Details shown below).



Sub-min Male-6 pin side:



- 1. Feed Ø6 x 43mm (clear) heat shrink, outer housing, cable grip, Ø6 x 10mm (black) heat shrink 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 inner and outer shields together along with the yellow wire.

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6. Clamp cable grip 2mm from the end of the cable outer jacket.
7. Push wires firmly into correct locations. (Apply small amount of glue if necessary).
8. Trim any excess wire 'overhanging' from the front end of the wire housing.
9. Push housing into the connector, and use pliers to push pins down through wires.
10. Push upper and lower cases around the connector firmly into place.

Finger Probe side:

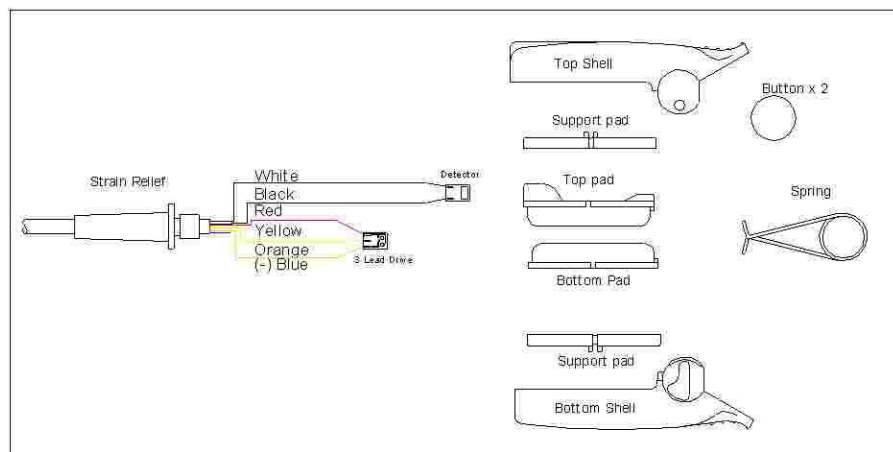


Fig 2.3

1. Apply loctite primer to the cable surface, and slide on the strain relief.
2. Apply a small amount of superglue on to the surface of the cable and push the strain relief over the glue to secure in place leaving approximately 80 mm of cable.
3. Strip outer jacket up to the strain relief and cut packing, outer shield, blue and orange wires.
4. Cut red and yellow wires to 15 mm, strip jackets off 2mm and apply a small amount of solder to the ends.
5. Strip 10 mm off inner jacket and cut off inner shield.
6. Strip jackets 2mm and apply small amount of solder.
7. Solder wires to the detector, LED/I.R as shown in fig 2.3
8. 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.
9. Superglue loose cable to the pads and fill the rears with white silicon.
10. Glue pads onto the pad supports (prime first).
11. Place spring around pads and into place.
12. Clip upper and lower shells (apply a little super glue) into place and glue caps onto the sides.

TESTING

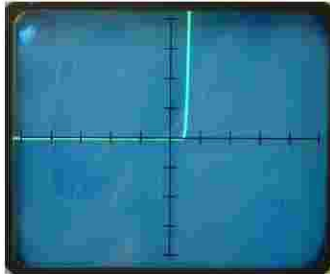
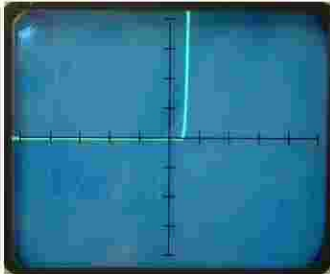
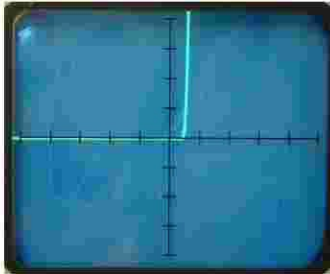
1. Attach Sub-min Male-6 pin side to a Palco test lead and then to the test box connector marked 'C'.

COMPANY OPERATING PROCEDURES

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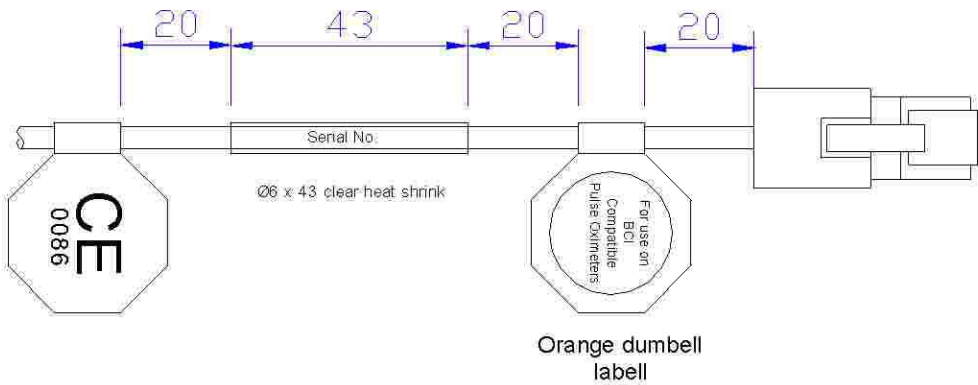
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2. Check display is showing correct characteristics as shown below. (At correct switch positions)
- 
- Position 2. IR Position 3. LED Position 4. Detector
3. ‘Play’ with wire at connections to see if any change in the display (i.e. flickering etc).
4. 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.
5. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
6. Attach Sub-min Male-6 pin side to a Palco 300 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
 - 1x Orange ‘Do Not Throw Away’ Label (correct one of two is dependant of country unit is being sold to).



Quality Assurance (QA)

1. Attach Sub-min Male-6 pin side to a Palco test lead and then to the test box connector marked ‘C’.

COMPANY OPERATING PROCEDURES

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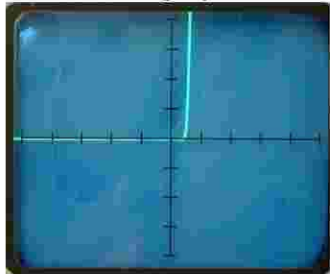
VM3/COP/32.19

Date: 3-May-02

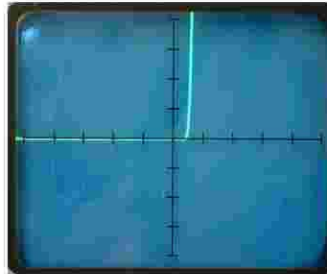
Revision date: 17-May-04

Issue: 3

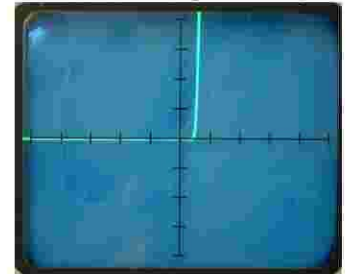
2. Check display is showing correct characteristics as shown below. (At correct switch positions)



Position 2. I.R



Position 3. LED



Position 4. Detector

3. 'Play' with wire at connections to see if any change in the display (i.e. flickering etc).
4. 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.
5. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
6. Attach Sub-min Male-6 pin side to a Palco 300 monitor, and the probe on to the finger to check SpO₂ level. (Ideal reading 95-100.)
7. Fill and sign attached paperwork.
8. Test 10 % of batch on DL3000 simulator at all the correct settings (see compatibility sheet).
9. 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.