

COMPANY OPERATING PROCEDURES

0019928 MARQUETTE P992E8

VM3/COP/33.20

Date: 21-Dec-01

Revision date: 23-Jul-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 female 9-pin side:

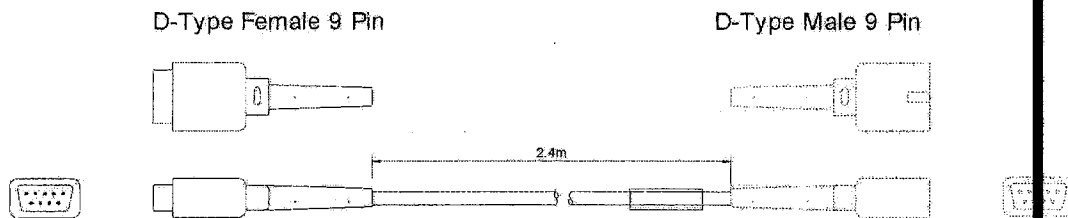


Fig 2.1. 00956E8 Extension Cable.

1. The 00956E8 cable is already assembled. The female side does not need to be modified, but the male side needs to be cut off ready for the Marquette male 11-pin connector to be fitted keeping cable as long as possible.

Marquette male 11-pin side:

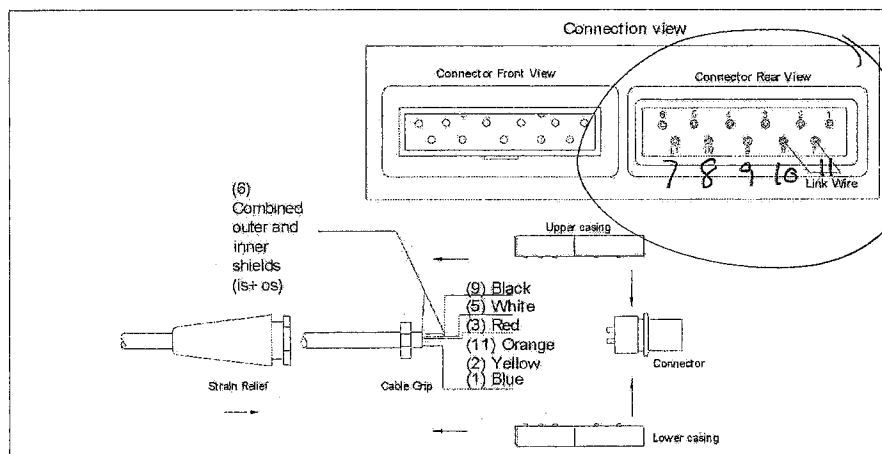


Fig 2.1

1. Feed Ø6 x 43mm (clear) heat shrink, rubber housing, Ø6 x 10mm (black) heat shrink and cable grip over the end of the cable.

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2. Strip 25mm off outer jacket of cable to reveal coloured wires, outer shield, and nylon/paper wire packing.
3. Cut all packing to the base.
4. Strip 25mm off inner jacket to reveal black and white wires and the inner shield.
5. Twist outer and inner shields together.
6. Strip jacket of every wire 2mm to reveal copper core.
7. Heat Ø1.6x 22mm heat shrink over twisted inner and outer shields to cover excess naked wire.
8. Take a 10mm piece of wire, strip 2mm off each end and solder one end to Pin 7 and the other to Pin 8.
9. Solder ends of every wire and shields to the correct positions on the rear of the connector top and bottom (shown in fig 2.2.)
10. Clamp cable grip approximately 2mm from end of outer jacket.
11. Place Ø6 x 10mm heat shrink over cable grip and beginning of wires and heat to shrink firmly over.
12. Push upper and lower casing around the connector and cable grip.
13. Push rubber housing over cable grip and wires to fit firmly around the combined upper and lower casing.

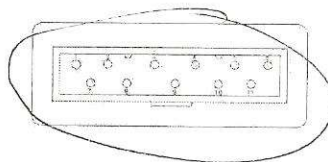
TESTING

1. Use the multi meter to check continuity between every wire from pin to pin.
2. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).

Front View
Female 9 Pin



Front View
Male 11 Pin



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
 - 1x Orange 'Do Not Throw Away' Label (correct one of two is dependant of country unit is being sold to).

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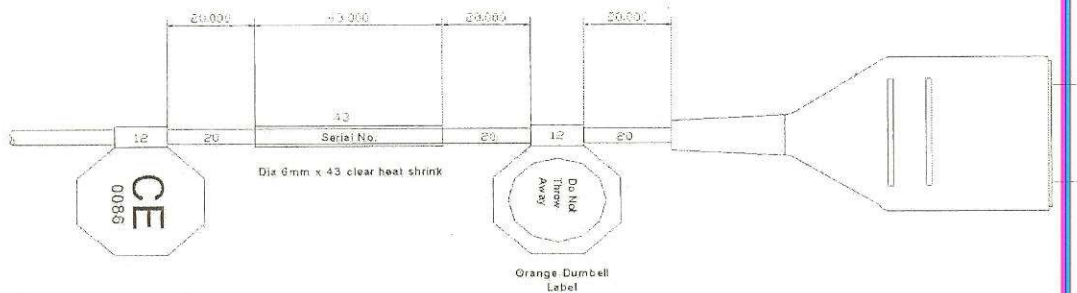
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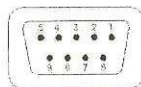
Issue: 3



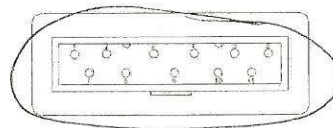
Quality Assurance (QA)

1. Use the multi meter to check continuity between every wire from pin to pin.
2. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
3. Fill and sign attached paperwork.
4. Test 10 % of batch on DL3000 simulator.
5. Log all results on compatibility sheet.

Front View
Female 9 Pin



Front View
Male 11 Pin



Packaging

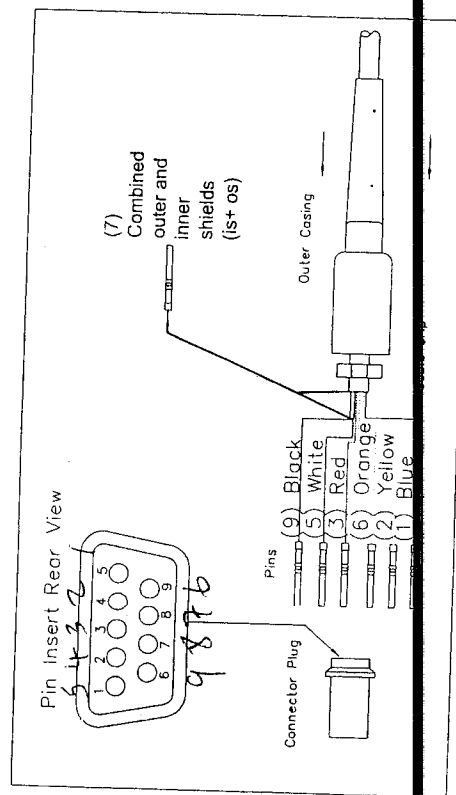
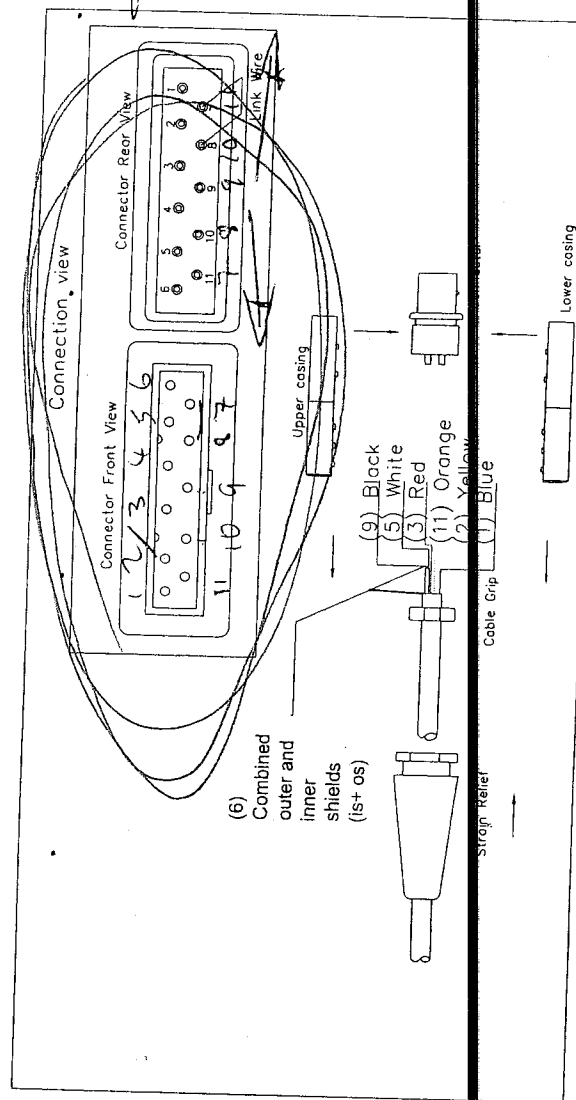
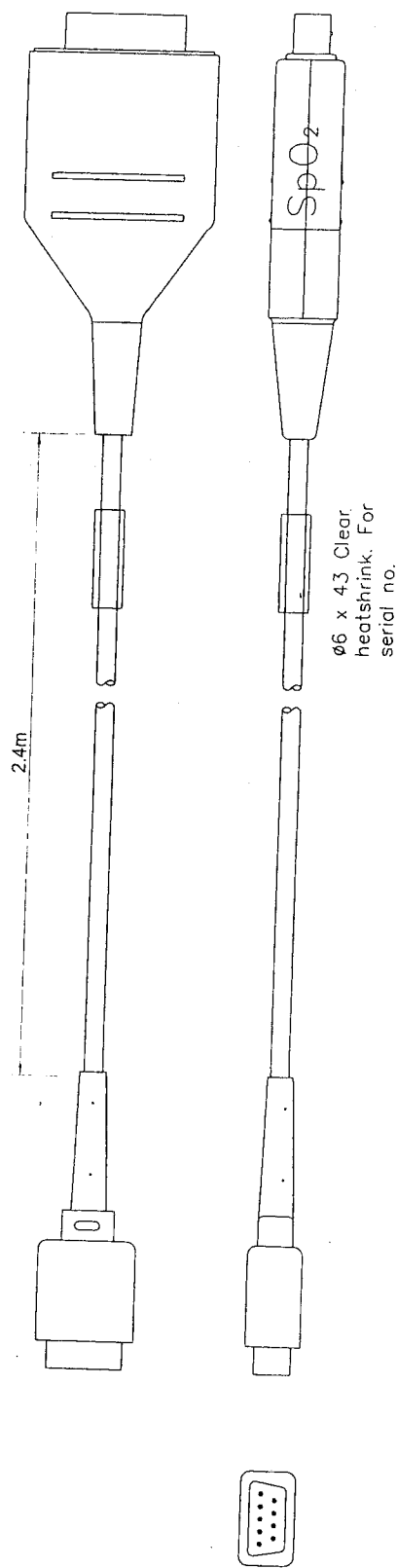
1. Visually check all labels are attached properly
2. Using a twist tie (bunny clip) wrap the cable and place in a small blue Viamed plastic box, ensuring the cable is inserted in a neat and tidy presentable manor.
3. Place a serial number sticker (supplied with the batch) on the front face of the box.
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.

P956E8 Extension cable

Marquette Male 11 Pin



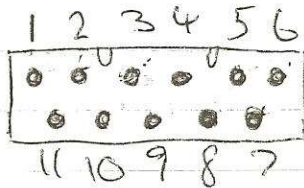
Title		P992E8 Marquette			
Scale		Not To Scale		Dim in mm	
Date		08/10/07		Tol : 0.2	
Drawn		K. J. Rush			

[illegible]

VIAMED
15 Station Rd
Cross Hills, Keighley
West Yorkshire

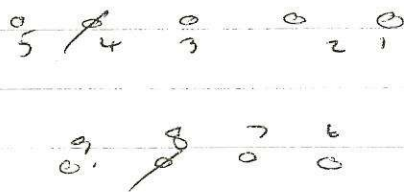
MARQUETTE TESTING.

Front view,



- | | |
|-----------|------------|
| 1, BLUE | 7, LINK |
| 2, YELLOW | 8, LINK |
| 3, RED | 9, BLACK |
| 4, - | 10, - |
| 5, WHITE | 11, ORANGE |
| 6, MS+IS | |

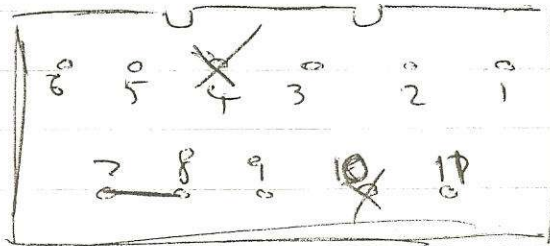
FV,



- | | |
|-----------|-----------|
| 1, BLUE | 6, ORANGE |
| 2, YELLOW | 7, MS+IS |
| 3, RED | 8, - |
| 4, - | 9, BLACK |
| 5, WHITE | |

BUILD. USING 956E8

RV,



- | | |
|-----------|------------|
| 1, BLUE | 7, LINK |
| 2, YELLOW | 8, LINK |
| 3, RED | 9, BLACK |
| 4, - | 10, - |
| 5, WHITE | 11, ORANGE |
| 6, MS+IS | |