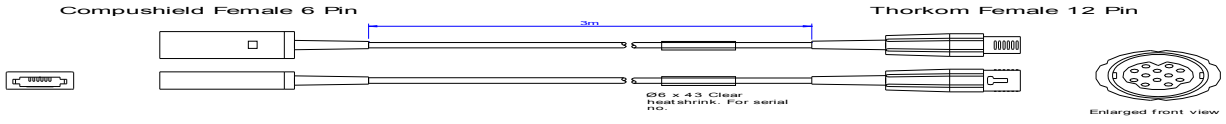
COMPANY OPERATING PROCEDURES

0019650 CRITIKON & SENSORMEDICS P965E10

VM3/COP/33.11

Date: 18-Dec-01 **Revision date: 7-Apr-11** 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.

Compushield female 6-pin side			Thorkom female 12-pin side		
Qty	Description	Part No.	Qty	Description	Part No.
1	Compushield female 6-pin kit	0010712	1	Thorkon female 12-pin kit	0010781
(1)	Housing	kit		Rear nut	Kit
(1)	Connector	kit		Strain relief	Kit
(1)	Cable grip	kit		Collett	Kit
(1)	Rear insert	kit		Pins	Kit
1	Strain relief	0010618 (50 off)		Pin housing	kit
			1	∅6 x 43mm Clear heat shrink	0032331 (roll)
			1	∅6 x 10mm heat shrink	0032321 (roll)
			2	∅1.6 x 17mm heat shrink	0032310

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					(roll)

ASSEMBLY OPERATIONS

1. Pre Heat soldering iron temperature to 240°c.
2. Collect all required parts and equipment listed above.
3. Cut a 3.1 metre length of special 6-core cable. Shown below.

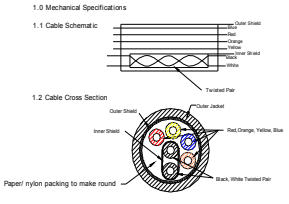


Fig 1.

Compushield female 6-pin side:

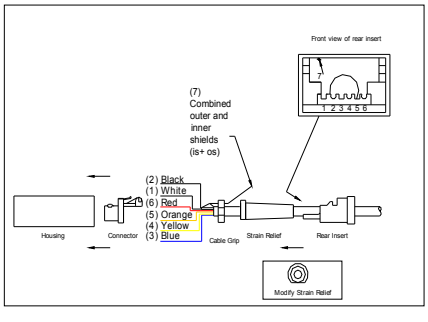


Fig 2.1

1. Cut a flat side on the strain relief as shown in fig 2.1.
2. Feed rear insert, strain relief and ∅6 x 10mm heat shrink (black) over end of cable.
3. Strip 20mm off outer jacket of cable to reveal coloured wires, outer shield, and nylon/paper wire packing.
4. Cut all packing to the base.
5. Strip 20mm off inner jacket to reveal black and white wires and the inner shield.

6. Twist inner and outer shields together, and form wire backwards along cable outer jacket surface.
7. Clamp cable grip over shields and 2mm from the end of the cable outer jacket (see fig 2.1).
8. Push strain relief up to cable grip, and push rear insert around strain relief as far as possible.
9. Push wires firmly into correct locations. (Apply small amount of glue if necessary).
10. Trim any excess wire 'overhanging' from the front end of the rear insert.
11. Solder shields to the metal plate in the rear insert and trim remaining wire.
12. Push connector onto rear insert, and use pliers to push pins down through wires.
13. Push housing over connector and rear insert to cover the unit.

Thorkom female 12-pin side:

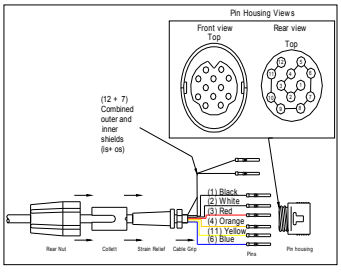


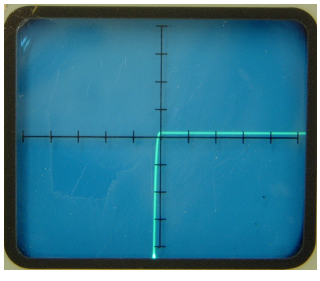
Fig 2.2

1. Feed ∅6 x 43mm Clear heat shrink, rear nut, collett, strain relief, cable grip, and ∅6 x 10mm heat shrink over the end of the cable.
2. Strip 20mm off outer jacket of cable to reveal coloured wires, outer shield, and nylon/paper wire packing.
3. Cut all packing to the base and strip 20mm off inner jacket of wire to reveal black and white wires and the inner shield.
4. Combine outer and inner shields together then split to form 2 wires, each containing inner and outer shield wire.
6. Trim ends of wires and shields to the same length.
7. Strip jacket of every wire 2mm to reveal copper core.
8. Place ∅1.6 x 17mm heat shrink over each twisted inner and outer shields to cover naked wire, and solder the ends to the rear of 2 separate pins.
9. Solder all remaining wires to the rear of separate pins and insert firmly into correct locations shown in fig 2.2.
10. Clamp cable grip approximately 2mm from the end of the outer jacket.
11. Place ∅6 x 10mm heat shrink over cable grip and beginning of wires and heat to shrink firmly over.

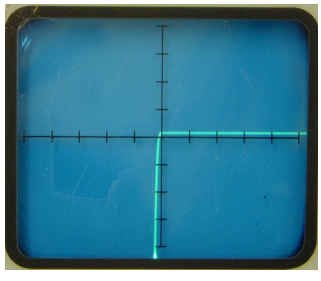
12. Push Strain relief up to the cable grip, collett over the strain relief, and screw the rear nut to the pin housing.

TESTING

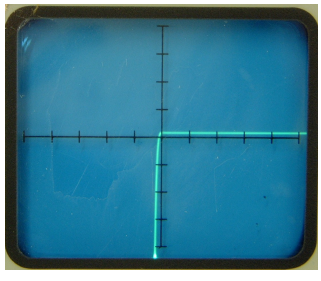
1. Attach Thorkom female 9-pin side to a Thorkom adapter cable and then to the test box connector marked 'J'.
2. Attach Compushield female 6-pin to a Sensormedics finger probe.
3. Check display is showing correct characteristics as shown below. (At correct switch positions)



Pos 2. LED



Pos 3. IR

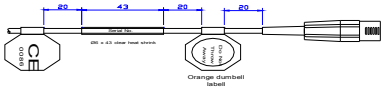


Pos 4. Detector

5. 'Play' with wire at connections to see if any change in the display (i.e. flickering etc).
6. If there is any movement of signal, the extension wire must be taken apart and all connections checked and re-soldered. Then tested again until results are satisfactory.
7. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
8. Connect Thorkom female 9-pin side to a Sensormedics oxyshuttle monitor and attach probe on finger to check SpO_2 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 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)

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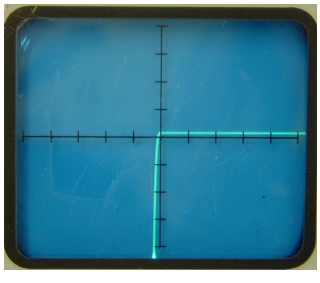
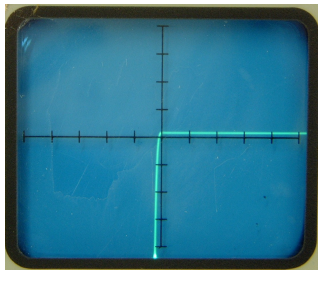
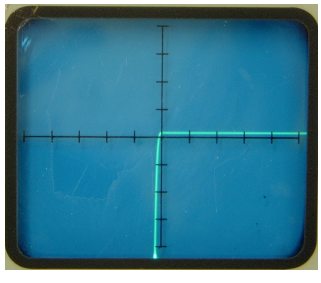


Pos 2. LED



Pos 3. IR



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9. Fill and sign attached paperwork.
10. Test 10 % of batch on DL3000 simulator.
11. 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.