

COMPANY OPERATING PROCEDURES

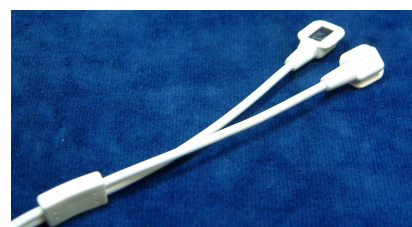
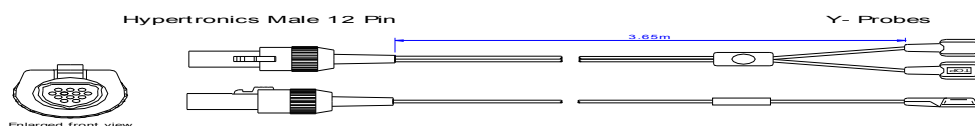
0018572 Spacelabs P857YA

VM3/COP/35.04

Date: 14-May-02

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. (Continued over page)

Hypertronics male 12-pin Side			'Y' Probe Side		
Qty	Description	Part No.	Qty	Description	Part No.
1	Hypertronics male 12-pin Kit	0010602	1	Pre manufactured Y probe assembly	0018582
(1)	Pin Housing	kit			
(12)	Pins	kit			
(1)	Cable grip	kit			
(1)	Strain relief	kit			
(1)	Collett	kit			
(1)	Barrel	kit			
1	10 Ω Resistor	0032010			
1	60.4 k Ω Resistor	0032130			
1	7.5 k Ω Resistor	0032080			
1	Ø6 x 43mm Clear heat shrink	0032331			

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1	Ø6 x 10mm heat shrink	0032321			
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ASSEMBLY OPERATIONS

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

'Y' Probe side:

1. Probe side is pre-manufactured and ready to have the connector assembled to it.

Hypertronics male 12-pin side:

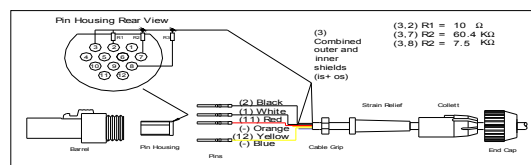


Fig 2.2

1. Cut pre-moulded d-type connector off to leave maximum length of cable.
2. Feed Ø6 x 43mm (clear) heat shrink, end cap, collett, strain relief, Ø6 x 10mm (black) heat shrink and cable grip onto the cable.
3. Strip 20mm off outer jacket of wire- to reveal 4 coloured wires, outer shield, and nylon/paper wire packing.
4. Cut all packing, blue and orange wires to the base.
5. Strip 20mm off inner jacket of wire- to reveal black and white wires and the inner shield.
6. Twist outer and inner shields together and trim to approximately 8mm long.
7. Strip jacket of every wire 2mm to reveal copper core.
8. Apply small amount of solder to ends of each wire and shields.
9. Trim one of the legs of the 10Ω resistors to 4mm and the other to 15mm .
10. Solder the legs to the rear of two separate pins.
11. Trim one leg of each of the other resistors to 4mm and solder this short side to the rear of a pin each.
12. Solder all wires to the rear of pins and push/pull firmly into correct locations as shown in fig 2.2.
13. Solder shields and remaining two legs of the resistors to the leg of the resistor on the pin location 3 side.

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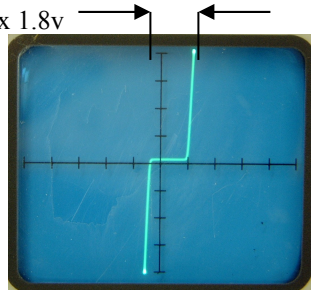
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14. Clamp cable grip approximately 2mm from outer jacket end.
15. Place Ø6 x 10mm heat shrink over cable grip and beginning of wires and heat to shrink firmly around.
16. Push the strain relief up to the cable grip, collett over the strain relief up to the pin housing, and into the barrel and finally screw end cap onto the barrel.

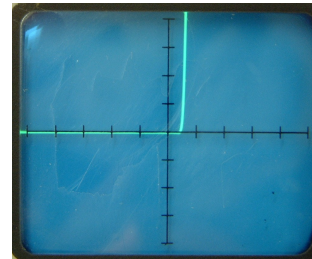
TESTING

1. Attach Hypertronics male 12-pin side to a Spacelabs to Nellcor test lead 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 Hypertronics male 12-pin side to a Spacelabs to Nellcor test lead and then to the Nellcor N200 monitor and the probe on to the ear to check the 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
 - 1x Orange 'Do Not Throw Away' Label (correct one of two is dependant of country unit is being sold to).
 - 1 x serial no. If required

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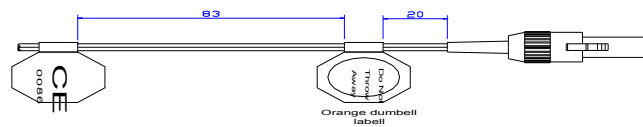
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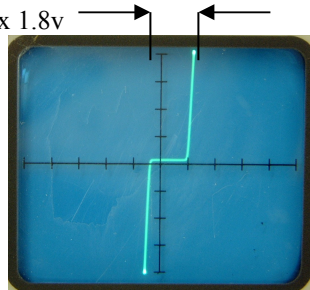
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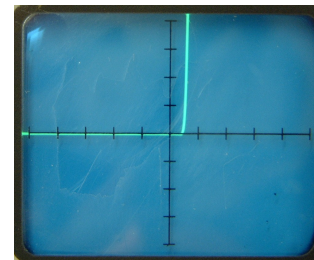
Quality Assurance (QA)

1. Attach Hypertronics male 12-pin side to a Spacelabs to Nellcor test lead 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 Hypertronics male 12-pin side to a Spacelabs to Nellcor test lead and then to the Nellcor N200 monitor and the probe on to the ear to check the SpO₂ level. (Ideal reading 95-100.)
8. Fill and sign attached paperwork.

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.

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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.