

### COMPANY OPERATING PROCEDURES

0018592 Pace Tech P859YA

VM3/COP/35.06

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)

Switchcraft Female-5 side			Finger Probe Side		
Qty	Description	Part No.	Qty	Description	Part No.
1	Switchcraft female 5 socket kit	0010789	1	Pre-manufactured 'Y' probe	0018582
(1)	Outer Sleeve	Kit			
(1)	Connector Pin	Kit			
(1)	Cable Grip	Kit			
(1)	Strain Relief	Kit			
1	Ø6 x 43mm Clear heat shrink	0032331			
1	Ø6 x 10mm heat shrink	0032321			
1	Ø1.6 x 10mm heat shrink	0032310			

### ASSEMBLY OPERATIONS

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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.

#### Switchcraft Female 5 plug side:

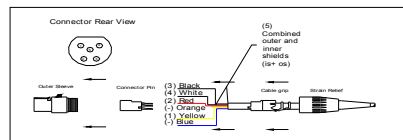


Fig 2.2

1. Cut off d-type connector.
2. Feed Ø6 x 43mm (clear) heat shrink, strain relief, Ø6 x 10mm (black) heat shrink over end of cable.
3. Strip 20mm off outer jacket of wire to reveal coloured wires, outer shield, and nylon/paper wire packing.
4. Cut all packing, orange and blue 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.
7. Trim (tidy) ends of all wires and shields to 12mm.
8. Strip jacket of every wire 2mm to reveal copper core.
9. Apply small amount of solder to ends of each wire and shields.
10. Heat Ø1.6 x 10mm heat shrink over twisted shield pair to insulate leaving enough to allow for the solder.
11. Solder wires and paired shields to the rear of the connector pins as shown in fig 2.2.
12. Place Ø6 x 10mm heat shrink over base of coloured wires and outer jacket and heat to shrink firmly around.
13. Push strain relief over the connector pin and screw onto the outer sleeve.

### TESTING

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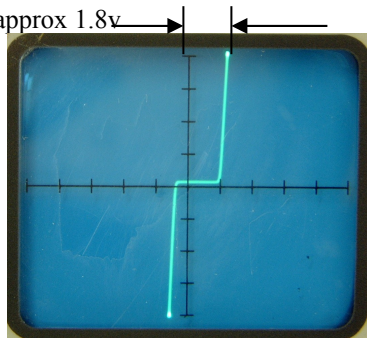
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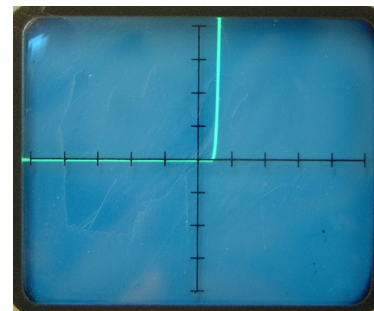
Issue: 3

1. Attach Switchcraft female 5 pin side to a Pacetech to Nellcor test lead and then 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.

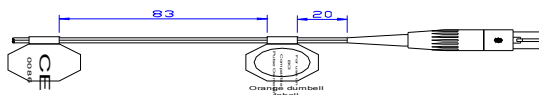


Position 4. Detector

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 Switchcraft female 5 pin side to a Nellcor monitor, and the probe on to the ear to check SpO<sub>2</sub> 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 if required.
  - 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 Switchcraft female 5 pin side to a Pacetech to nellcor test lead and then to the test box connector marked 'A'.

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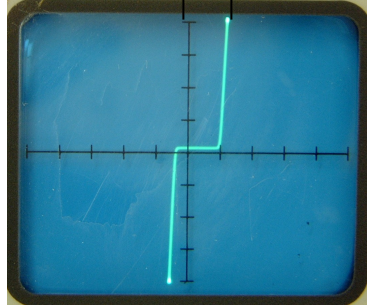
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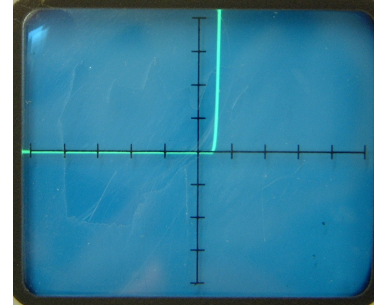
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- Check display is showing correct characteristics as shown below. (At correct switch positions)

LED should read approx 1.8v



Position 1. IR, LED.



Position 4. Detector

- If the LED signal is at the bottom then it is wired incorrectly.
- 'Play' with wire at connections to see if any change in the display (i.e. flickering etc).
- 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.
- Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
- Attach Switchcraft female 5-pin side to a Nellcor monitor, and the probe on to the ear to check SpO<sub>2</sub> level. (Ideal reading 95-100.)
- Fill and sign attached paperwork.

#### Packaging

- Visually check all labels are attached properly
- 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.
- Place a serial number sticker (supplied with the batch) on the front face of the box.
- 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

- Final inspection. Visually ensure cable sit neatly within the box and is in a presentable state.
- Boxes are ready to stock in stores.