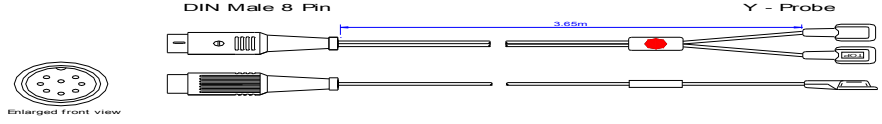
COMPANY OPERATING PROCEDURES

0018642 Datascope P864YA

VM3/COP/35.11

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)

Din male 8-pin side			'Y' Probe Side		
Qty	Description	Part No.	Qty	Description	Part No.
1	Din male 8-pin kit	0010790	1	Pre manufactured 'Y'probe cable	0018672
(1)	Barrel	kit			
(1)	Cable grip	kit			
(1)	Connector	kit			
1	22.1 Ω Resistor	0032020			
1	47.5 kΩ Resistor	0032110			
1	∅6 x 43mm Clear heat shrink	0032331			
1	∅6 x 40mm heat shrink	0032321			

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.

DIN male 8-pin side:

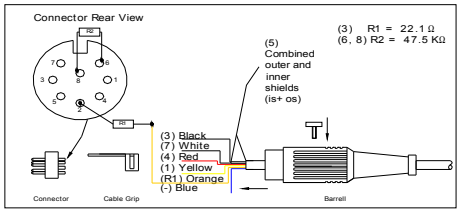


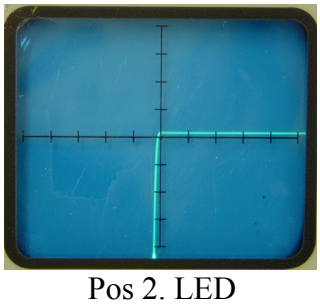
Fig 2.2

1. Remove Hypertronics connector from the end of the cable.
2. Trim legs of (R2) 47.5 kΩ resistor to 4mm and 15mm.
3. Cover resistor (R2) with ∅1.6 x 19mm heat shrink leaving 2mm of wire showing either end, and heat to cover extra naked wire.
4. Form 15m side around so both resistor legs will fit into correct locations in the connector then solder into place.
5. Trim both legs of (R1) 22.1 kΩ resistor to 4mm, and solder one end to pin no.2 in the rear of the connector.
6. Feed ∅6 x 43mm (clear) heat shrink, barrel and ∅6 x 40mm heat shrink over the end of the cable.
7. Strip 20mm off outer jacket of wire to reveal coloured wires, outer shield, and nylon/paper wire packing.
8. Cut all packing and blue wire to the base.
9. Strip 20mm off inner jacket to reveal black and white wires and the inner shield.
10. Twist outer and inner shields together.
11. Heat ∅1.6 x 17mm heat shrink over shields to cover excess naked wire.
12. Trim ends of wires and shields to the same length.
13. Strip jacket of every wire 2mm to reveal copper core.
14. Solder all wires to the correct locations on the rear of the connector.
15. Insert ∅1.6 x 8 mm heat shrink over the orange wire, solder wire to remaining leg of (R1) and then heat the heat shrink over the resistor and wire connection.

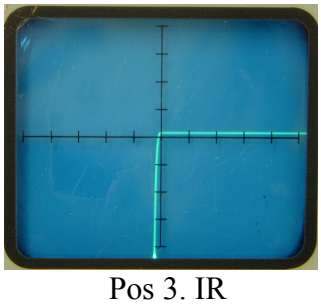
16. Heat ∅6 x 40mm heat shrink over the end of the cable outer jacket to hold the beginning of the wires firmly.
17. Attach the cable clip to the connector, and clamp the other end firmly to the cable.
18. Push barrel over the connector and screw the barrel firmly to the connector.

TESTING

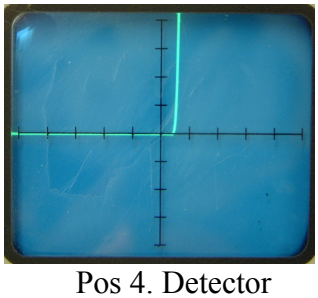
1. Attach DIN male 8-pin side to the test box connector marked 'F'.
2. Check display is showing correct characteristics as shown below. (At correct switch positions)



Pos 2. LED



Pos 3. IR

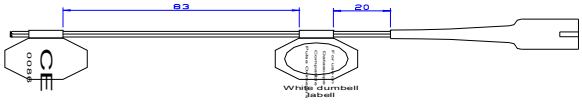


Pos 4. Detector

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. Connect DIN male 8-pin side to a Datascope monitor and attach probe on ear 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 White Datascope Label



Quality Assurance (QA)

1. Attach DIN male 8-pin side to the test box connector marked 'F'.
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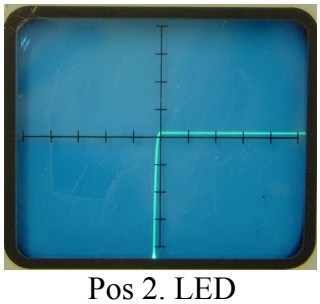
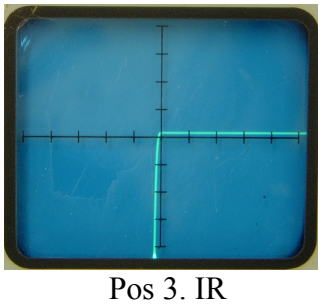
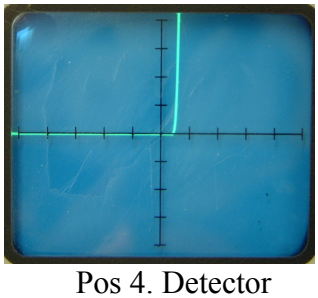


Pos 2. LED



Pos 3. IR



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5. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
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7. 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.
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.