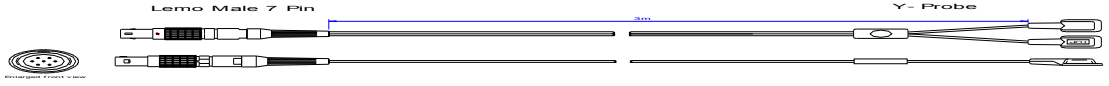
COMPANY OPERATING PROCEDURES

0018782 Invivo P878YA

VM3/COP/35.23

Date: 22-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.

Lemo male 7-pin Side			'Y' Probe Side		
Qty	Description	Part No.	Qty	Description	Part No.
1	Lemo Male 7-pin kit	0010650	1	Pre manufactured cable	0018582
(1)	Housing	Kit			
(1)	Connector	Kit			
(1)	Upper sleeve	Kit			
(1)	Lower sleeve	Kit			
(1)	Collett	Kit			
(1)	Rear Housing	Kit			
1	Strain relief (white)	0030654			
1	∅6 x 43mm Clear heat shrink	0032331			
1	39.2k Ω Resistor	0032100			

1. Pre Heat soldering iron temperature to 240°c.

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ASSEMBLY OPERATIONS

Lemo 7-pin side:

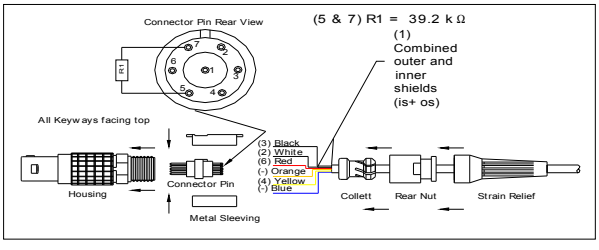


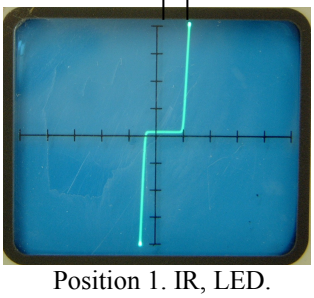
Fig 2.2

1. Cut off the d-type connector from the end of the cable so to leave a cable length of 3m.
2. Feed ∅6 x 43mm (clear) heat shrink, strain relief, rear nut, collett and ∅6 x 25mm (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 wire to the base.
5. Strip 20mm off inner jacket to reveal black and white wires and the inner shield.
6. Twist outer and inner shields together.
7. Trim ends of wires to 13mm long. And resistor legs to 4mm and 15mm.
8. Strip jacket of every wire 2mm to reveal copper core.
9 Heat ∅6 x 25mm (black) heat shrink up to the end of the cable.
10. Solder ends of every wire, resistor and shields to the correct positions on the rear of the connector.
11. Fit metal sleeves over the connector, and insert into the housing ensuring all keyways lie up.
12. Holding the housing fixed with a spanner, tighten the rear nut over the collett and onto the housing.
13. Push the strain relief onto the rear nut.

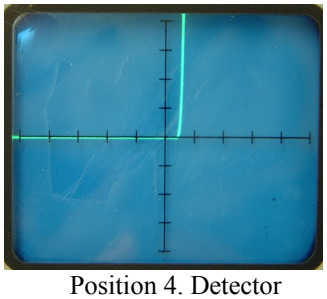
TESTING

1. Attach Lemo 7-pin side to the test box connector marked 'G'.
2. Check display is showing correct characteristics as shown below. (At correct switch positions)

LED should read approx 1.8v



Position 1. IR, LED.

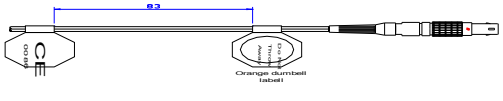


Position 4. Detector

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 Lemo 7-pin side to an adapter cable then to a Nellcor monitor and the probe on to the 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 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)

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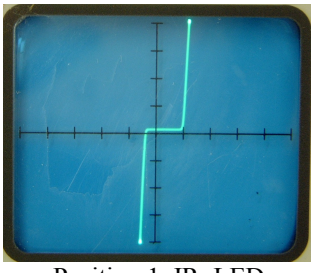

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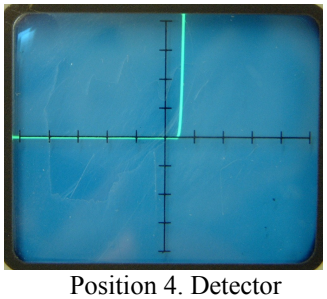

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6. Check the cable is of correct quality standard. (See VM/COP/30.11 for details).
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8. Fill and sign attached paperwork.

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.
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.