

### COMPANY OPERATING PROCEDURES

0018862

Kontron

P886YA

VM3/COP/35.26

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. (Continued over page)

SPK1-A male 12-pin Side			'Y' Probe Side		
Qty	Description	Part No.	Qty	Description	Part No.
1	SPK1-A male 10-pin kit	0010707	1	Pre manufactured cable	0018582
(1)	 Rubber housing	kit			
(1)	 Collar	kit			
(5)	 Pins	kit			
(1)	 Upper casing	kit			
(1)	 Cable clamp	kit			
(1)	 Pin housing	kit			
(2)	 Screws	kit			
(1)	 Lower casing	kit			
(1)	 Maroon Collar	kit			
1	Ø6 x 43mm Clear heat shrink	0032331			
1	Ø6 x 25mm heat shrink	0032321			
1	Ø1.6 x 20mm heat shrink	0032310			
1	3.3 kΩ Resistor	0032070			

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1	2.2 kΩ Resistor	0032060			
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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.

#### SPK1-A male 12-pin Side :

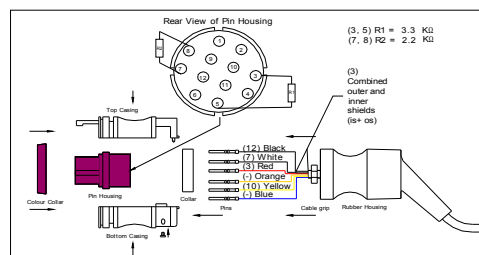


Fig 2.2

1. Cut off the d-type connector from the end of the cable so to leave a cable length of 3m.
2. Feed Ø6 x 43mm (clear) heat shrink, rubber housing, collar, cable grip and Ø6 x 25mm (black) heat shrink over the end of the cable.
3. Strip 25mm off outer jacket of cable to reveal coloured wires, outer shield, and nylon/paper wire packing.
4. Cut all packing orange and blue wire to the base. Trim resistor legs to 4mm and 15mm each.
5. Strip 25mm off inner jacket to reveal black and white wires and the inner shield.
6. Twist inner and outer shields together, and heat Ø1.6x 20mm heat shrink over excess naked wire.
7. Trim ends of wires to the same length.
8. Strip jacket of every wire 2mm to reveal copper core, and solder resistor legs and wires to the rear of individual pins.
9. Insert all pins into correct locations.
10. Insert pin housing into the bottom casing, and screw cable clamp over cable.
11. Push top casing onto bottom casing, and push the collar over mating cases.
12. Push rubber housing over cases, and then the maroon collar over the front of the casing.

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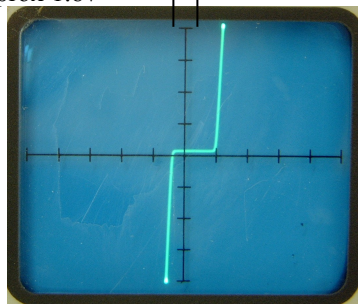
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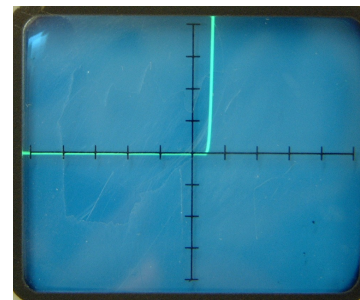
#### TESTING

1. Attach SPK1-A side to a Kontron/Vickers box 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.

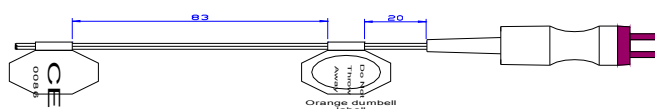


Position 4. Detector

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 SPK1-A side to a Kontron 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.



#### Quality Assurance (QA)

1. Attach SPK1-A side to a Kontron/Vickers box and then to the test box connector marked 'A'.

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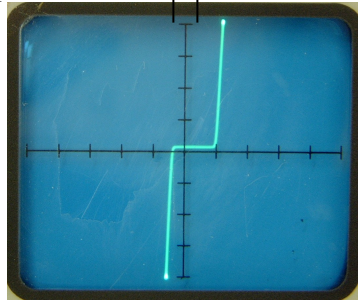
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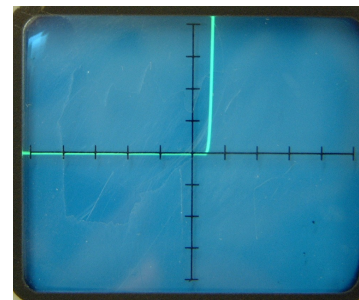
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8. Fill and sign attached paperwork.

#### 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.