COMPANY OPERATING PROCEDURES

Venticare Single Use Mask Adapter Sensor (1650049)

VM3/COP/46.01

Date: 9-Sep-02 Revision date: 7-Apr-11 Issue: 3

Equipment required: Soldering iron (0060120), Solder (0050012), Small solder tip, Flush cutter (0060010), 'Helping hand' (0060145), Wire strippers (0060030) Snipe nose pliers (0060021), Stub nose pliers, Bench vice with aluminium soft jaws, Rubber gloves.

Parts list: Kit and parts required.

Parts		
Qty	Description	Part No.
1	3.5 mm panel mount enclosed jack socket	1630050
1	Piezo electric film with lead wires	1630010
1	Venticare mask adapter (bag of 1000)	
1	Disposable nitrile gloves (box of 100)	9952050
1	Isopropyl Alcohol 70% isopropyl / 30% water mix – (spray bottle)	0050120
1	Loctite 242	0330221
1	Date of manufacture sticker	
1	Lot no. sticker	

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Notes:

This Product is not sterile but is used in patient airways, and it is therefore important that the following are obeyed:

- Wear clean overalls and tie/cover hair.
- Working area must be cleaned (including tools) using isopropyl alcohol fluid and a clean paper towel.
- Hands must be washed and gloves worn at all times during assembly.
- Use clean polythene bags and containers at all times.
- Use the Laminar flow cabinet whenever possible. (hole punching and soldering may be done outside the cabinet).

Connector Hole Punching:

1. Place the Venticare connector in the punch and create the hole in the bottom of the cup.
2. Wipe the connector using isopropyl alcohol (70 / 30 mix - spray) and kitchen towel, and leave to dry in the laminar flow cabinet.

Assembly:

1. Pre Heat soldering iron temperature to 240ºc.
2. Collect all required parts and equipment listed above from the stores.
3. Cut wires off the sensor.
4. Hold the sensor in a vice using aluminium soft jaws to act as a heat sink and apply a small amount of solder to the inside surface of the rivet lugs and on the pins of the connector, taking extra care not to allow the sensor to get too hot (hold the sensor terminals in the vice). **Red wire to pin no.2, and black wire to pin no.1.**

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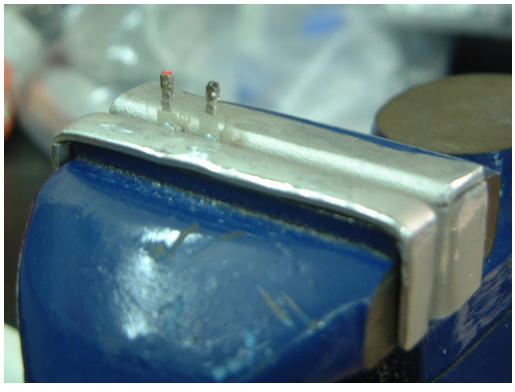
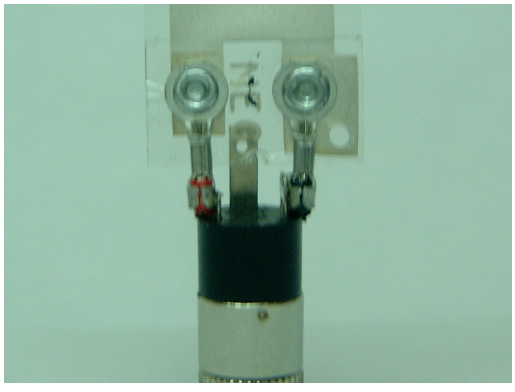
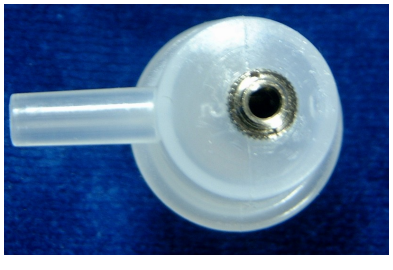
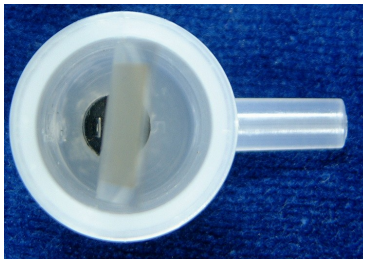




5. Clean the unit using isopropyl alcohol (70 / 30 mix – spray), shake excess liquid off, and allow drying in the laminar flow cabinet. (DO NOT WIPE the sensor surface as this can damage the unit).

6. Fit the sensor into a Venticare mask adapter through the hole at the bottom, with the face of the sensor facing the same direction as the oxygen inlet nozzle. Apply a drop of loctite to the thread to hold securely in place. Use the long nose pliers to hold the sensor in place and tighten with the normal pliers.





Cleaning:

1. Use Isopropyl alcohol in a spray bottle (70 / 30 mix) and shake dry the unit, dry off any excess moisture with a kitchen towel (do not rub) to clean the sensor and socket before packaging, to remove any dirt and fingerprints.

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Testing:

1. Batch test 1 in every 20 units, using a PIPPA monitor, by breathing onto the sensor when placed in a facemask. (The mask used should not be shared. One mask per individual).

Packaging and labelling:

1. Place unit into plastic bags in quantities of 25.
2. Attach the part no. label '1650049 PIPPA Flexicare adaptor sensors'

Despatch:

1. Address the box correctly and fill out necessary paperwork.