

## COMPANY OPERATING PROCEDURE.

## Quality Assurance Procedure

VM3/COP/50.13

Date: 13-Jul-2015.

Revision date: 20-Jul-15.

Issue: 1.

## Quality Checks: Tom Thumb

**Do not carry out QA checks on Tom Thumbs until at least 1 hour after testing – this allows Oxygen-Compatible threadlock, applied during testing, to be totally dry.**

- 1) Check the Tom Thumb for damage i.e. scratches to plastics, poor chroming, etc.
- 2) Set the adjustable valve to minimum (fully counter clockwise).
- 3) Connect the inlet to the oxygen supply at a pressure of 4 bar.
- 4) Connect the digital manometer (on 0-100.0 mbar range) with T piece adapter to the Tom Thumb outlet.
- 5) Set the flow of oxygen to 10 Lpm.
- 6) Check all mechanical connections between parts for leaks; use Snoop fluid and check for bubbling.

- 7) Check for minimum pressure out: Cover the T piece adapter port. Check the TT pressure gauge is less than 8.0 cmH<sub>2</sub>O. Check that the digital manometer reading is less than 7.8mbar and record on the Tom Thumb Calibration / Test & QA Sheet.

- 8) Set up the adjustable valve: Set the adjustable valve control to maximum. Cover the holes in the precision valve and the T piece adapter port. Ensure a reading of 42.1±1 mbar on the digital manometer and record on the Tom Thumb Calibration / Test & QA Sheet.

- 9) Check for TT pressure gauge sticking: Release and cover the T piece adapter port a number of times, ensuring that TT pressure gauge returns to 43±1 cmH<sub>2</sub>O. Uncover the precision valve holes.

- 10) Set up the precision valve: Cover the holes in the adjustable valve and the T piece adapter port. Carefully adjust the precision valve screw in quarter turns to achieve a reading on the TT pressure gauge of 45±1 cmH<sub>2</sub>O (clockwise adjustment on precision valve screw to increase). Record the digital manometer reading on the Tom Thumb Calibration / Test & QA Sheet

→ still asks for cm H<sub>2</sub>O, also, what range

- 11) TT pressure gauge accuracy check: Cover the T piece adapter port and increase the flow of gas to achieve a displayed reading of 30 cmH<sub>2</sub>O on the TT pressure gauge. Ensure a reading of 29.4±0.5 mbar of the Precision Valve Reading on the digital manometer and record.

→ Phil seems to struggle with this

NO

decrease

in mbar

- 12) Turn the flowmeter and adjustable valve to minimum. Disconnect from oxygen supply and disconnect the digital manometer.

- 13) Clean the Tom Thumb with isopropyl alcohol.

- 14) Ensure the appropriate labels have been fitted and the Instructions for Use card is attached. Complete stock sheets and file. Ensure the unit is booked onto the computerised stock system.

- 15) Check parts cannot be removed without tools?