

COMPANY OPERATING PROCEDURES

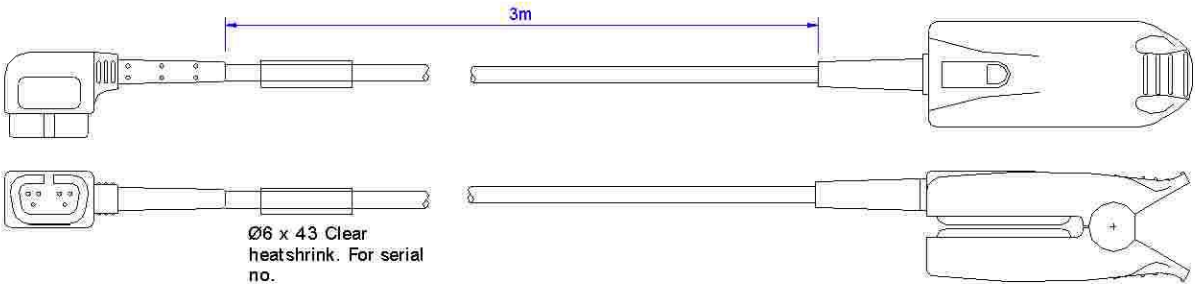
0018700 Criticare P870RA

VM3/COP/32.15.2

Date: 23-Oct-02 Revision date: 17-May-04 Issue: 3

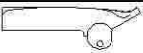
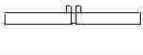
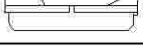
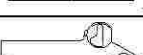
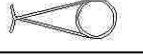

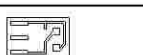
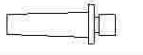


90° D-Type Male 9 Pin (service cable)

Finger Probe



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)

D-Type male 9-pin Side			Finger Probe Side		
Qty	Description	Part No.	Qty	Description	Part No.
1	D-Type male 9-pin 90 degree service cable.	0038897	1	 Top Shell (x25)	0010110
			2	 Pad Support (purple) (x50)	0010164
			1	 Top Pad (white)(x25)	0010130
			1	 Bottom Pad (white)(x25)	0010131
			1	 Bottom Shell (x25)	0010111
			1	 Spring (x25)	0010140
			2	 Button (purple) (x50)	0010184
			1	 Detector	0030901
			1	 LED/ I.R.	0030952
			1	 Strain Relief	0010150

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ASSEMBLY OPERATIONS

1. Pre Heat soldering iron temperature to 240°c.
2. Collect all required parts and equipment listed above.

D-Type male 9-pin side:

1. Use a 0038897-service cable, which is pre-manufactured and only requires the probe to be fitted.

Finger Probe side:

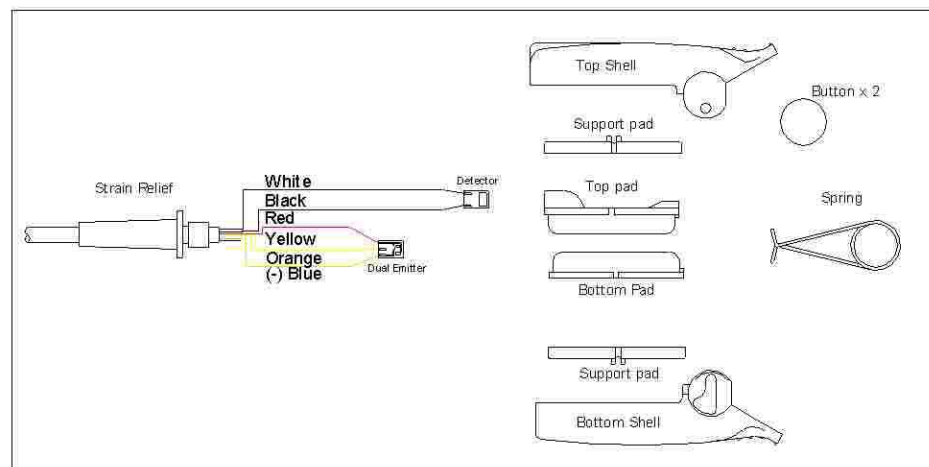


Fig 2.3

1. Wire comes ready to be soldered and assembled.
2. Solder wires to the detector, LED/I.R as shown in fig 2.3
3. Place the assembly on the drying rack, and apply a small amount of clear silicon to the front of the detector and LED/I.R and mount into the pads (Led/IR in the top pad and Detector in the bottom pad) allowing the sensors to be seen and central, and scrape excess silicon. Then place the drying rack in the drying cabinet and leave to dry overnight.
4. Superglue loose cable to the pads and fill the rears with white silicon.
5. Glue pads onto the pad supports (prime first).
6. Place spring around pads and into place.
7. Clip upper and lower shells (use a little super glue) into place and glue buttons onto the sides.

TESTING

1. Attach D-Type male 9-pin side to a CSI extension cable then to the test box connector marked 'J'.
2. Check display is showing correct characteristics as shown below. (At correct switch positions)

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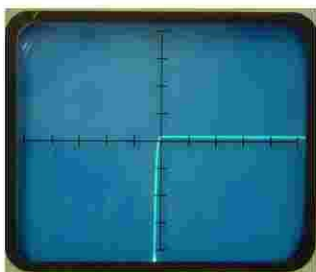
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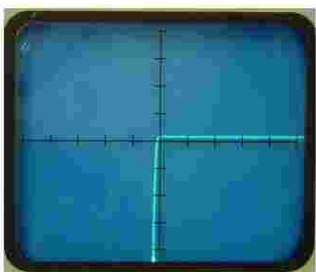
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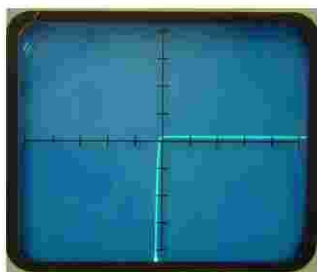
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Pos 2. LED



Pos 3. IR

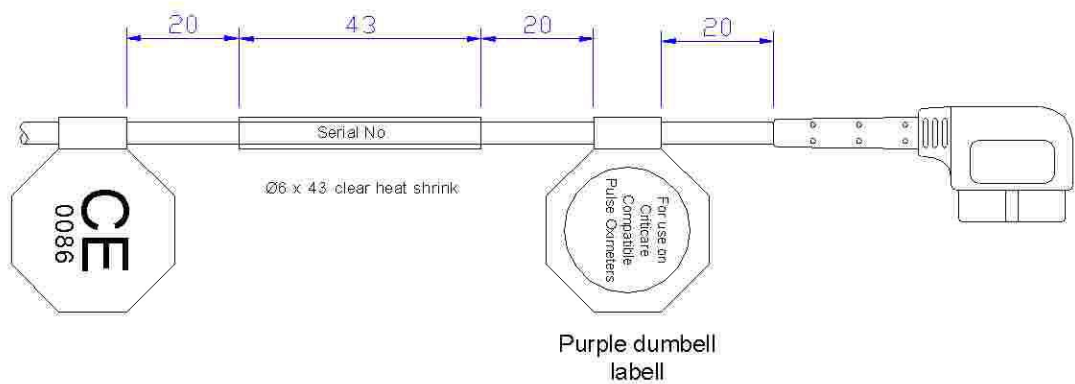


Pos 4. Detector

- 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. Attach D-Type male 9-pin side to a CSI 504 monitor and the probe on to the finger to check SpO₂ 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 Viamed shell label on probe lower shell.
 - 1 x Serial no. Label
 - 1 x Purple Criticare Label



Quality Assurance (QA)

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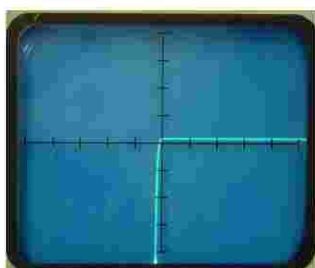
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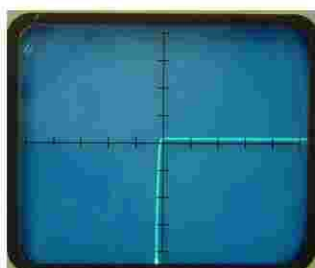
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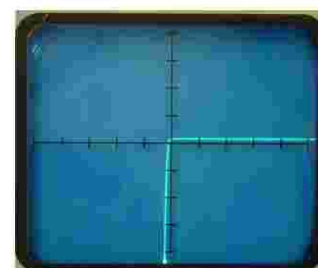
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Pos 2. LED



Pos 3. IR



Pos 4. Detector

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7. Fill and sign attached paperwork.
8. Test 10 % of batch on DL3000 simulator.
9. Log all results on compatibility sheet.

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.