


#### NOTES:

- (1) TERMINALS TO BE MACHINE CRIMPED (LOOSE PART NUMBER IS FOR REFERENCE ONLY)
- (2) OBSERVE WIRE LENGTH TOLERANCE
- (3) ALL WIRES TO BE 22AWG, CONSTRUCTED OF 7 STRANDS OF 30AWG, CSA 0.336MM<sup>2</sup>, VOLTAGE RATING 300VAC, UL1569, CURRENT RATING 10A, EXTERNAL DIAMETER 1.57MM.
- (4) SOLDER TO BE LEAD FREE
- (5) WIRE LENGTHS IN PICTURE ARE FOR REFERENCE ONLY. FOLLOW TABLE FOR CORRECT LENGTHS
- (6) SUBSTITUTE PARTS ARE NOT ALLOWED

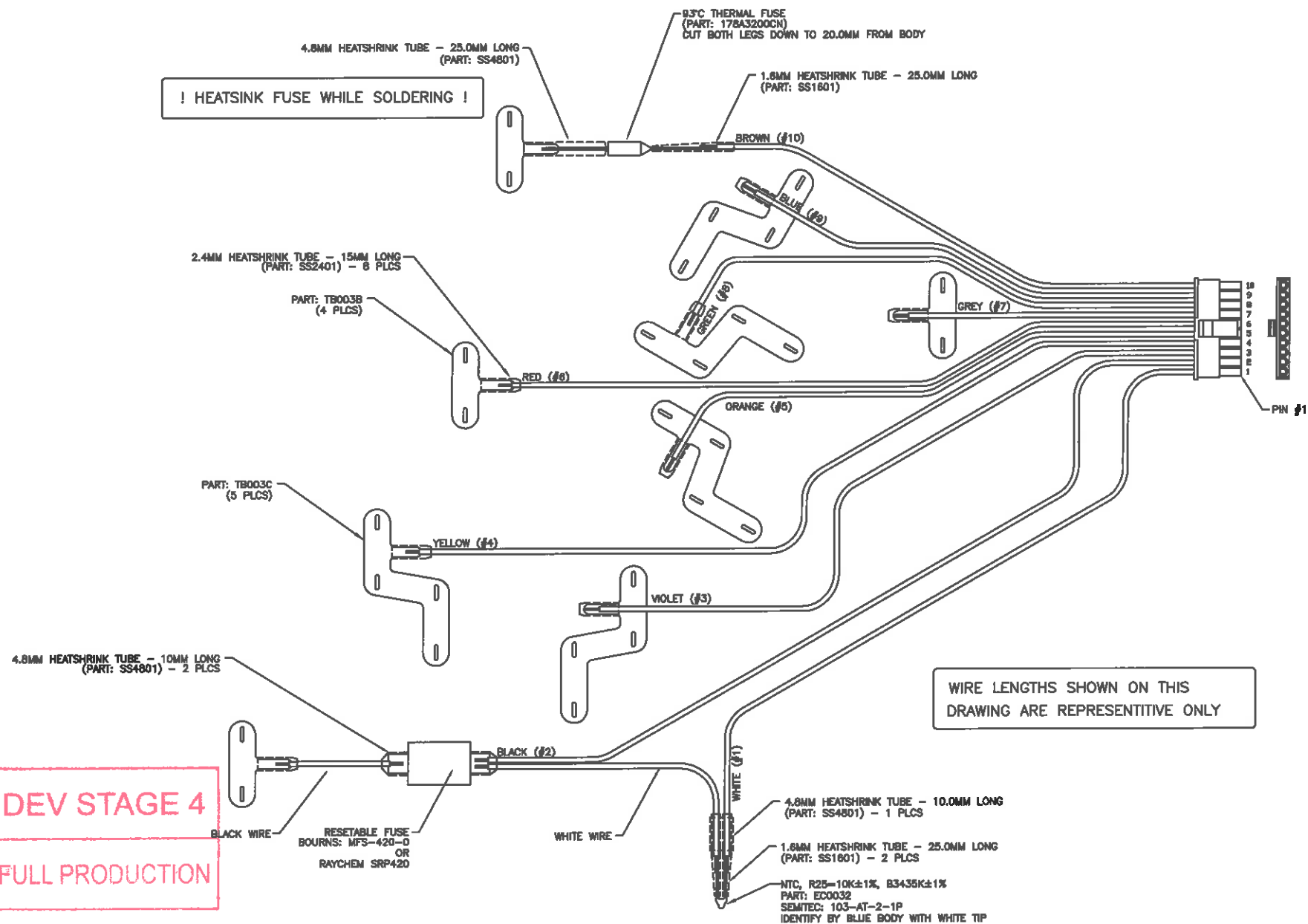
| CONNECTOR POSITION | WIRE COLOUR | WIRE PART NUMBER | LEGEND | STRIPPED WIRE LENGTH (MM) ±1.0MM |
|--------------------|-------------|------------------|--------|----------------------------------|
| 10                 | BROWN       | WI0730BRSPL-2    | BAT 7P | 170                              |
| 9                  | BLUE        | WI0730BLSPL-2    | BAT 6P | 155                              |
| 8                  | GREEN       | WI0730GNSPL-2    | BAT 5P | 175                              |
| 7                  | GREY        | WI0730GYSPL-2    | BAT 5N | 100                              |
| 6                  | RED         | WI0730RDSPL-2    | BAT 4P | 225                              |
| 5                  | ORANGE      | WI0730ORSPL-2    | BAT 3P | 185                              |
| 4                  | YELLOW      | WI0730YWSPL-2    | BAT 2P | 265                              |
| 3                  | VIOLET      | WI0730VTSPL-2    | BAT 1P | 235                              |
| 2                  | BLACK       | WI0730BKSPL-2    | BAT 1N | 265                              |
| 1                  | WHITE       | WI0730WHSPL-2    | NTC    | 205                              |

DEV STAGE 4

FULL PRODUCTION

|                |                            |  |   |   |   |   |
|----------------|----------------------------|--|---|---|---|---|
| Issue: K       | Alteration Number: 15-E048 | THIS DOCUMENT, AND THE INFORMATION APPEARING THEREIN, IS PROPRIETARY TO, AND THE PROPERTY OF, ACCUTRONICS LIMITED AND SHALL NOT, IN WHOLE OR IN PART, BE REPRODUCED, DISCLOSED OR USED UNLESS EXPRESSLY AND DULY AUTHORIZED IN WRITING BY ACCUTRONICS LIMITED. |   |   | Title: 25.2V 4.8Ah Lilon BATTERY<br>2982400 Lead Assembly | Application: COVIDIEN<br>PB540/PB560 VENTILATOR |
| Date: 21/05/15 | Name: JME                  | CAD DATA 1:1<br>ALL DIMENSIONS IN mm<br>DO NOT SCALE   | THIRD ANGLE PROJECTION<br> | ACCUTRONICS LIMITED<br>Unit 20, Loomer Road,<br>Newcastle-Under-Lyme,<br>Staffordshire, England | CAT. No: L6A051BE00004                                    | Sht: 1  |
| Date: 13/6/15  | Chkd: OA                   |  | NDE93001 ISSUE 9  |   |   | Next Sht: 2                                     |

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professional battery solutions



|                |                            |  |                        |  |  |  |  |
|----------------|----------------------------|--|------------------------|--|--|--|--|
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| Date: 18/01/15 | Chkd: DA                   |  | NDE93001 ISSUE 9       |  |  | Next Sht: 3                                  |  |

STAGE 1  
TEST PCB  
PCBA10003A01G  
TEST FIXTURE T0005  
TEST INSTRUCTIONS:  
BATTERY TEST\_0011

STAGE 4  
SOLDER IRON MUST BE SET AT 200 DEGREES  
USE SOLDER TIP (T0182) AND HEATSTAKE JIG (J0252) TO MELT PLASTIC AND RETAIN THE PCB.

STAGE 3  
INSERT CONTACT PAD ON PCB THROUGH APERTURE IN FRONT ENDCAP MOULDING (CA3030BL)

STAGE 5  
USING A GREEN NOZZLE (HW1639) APPLY FLEXIBLE EPOXY IRS2125 (GL0202) BETWEEN THE END-CAP SIDE WALL AND THE PCBA SURFACE WHERE SHOWN BELOW. IT IS VITAL THAT THE EPOXY BONDS TO BOTH THE PCBA AND THE MOULDING WALL.

WHEN THIS STAGE IS COMPLETE REFER TO WORK INSTRUCTION (L6A051BE00004\_WI) TO MAKE SURE THE ENDCAP ASSY PASSES THE FORCE GAUGE TEST.

BLUE FRONT ENDCAP  
PART: CA3030BL

STAGE 2 INSERT 128 DEGREE FUSE (PART: FU0128B) AND SOLDER ON THE BACK OF THE PCB USING JIG No J0087  
CUT OFF THE LEGS AS CLOSE AS POSSIBLE TO THE PCB  
CONTINUITY TEST ON THE FUSE

REAR  
VIEW

FLEXIBLE  
EPOXY


FRONT  
VIEW

STAGE 6 APPLY THERMAL COMPOUND  
PART: GL0145  
OVER THE FUSE (FU0128B)

STAGE 7  
QUALITY CHECK

DEV STAGE 4

FULL PRODUCTION

|                |                            |  |   |   |   |   |  |
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| Date: 18/6/15  | Chkd: JF                   |  |   |   |   | Next Sht: 4                                     |  |

| JOB PLAN  |                            |   |   | AN RECORD FORM  |              |   |                                    |
|---|----------------------------|---|---|---|--------------|---|------------------------------------|
| ESR No.:  |                            | CAT. No.:   |   | ON COMPLETION OF THE ALTERATION NOTICE, ENTER THE APPROPRIATE DETAILS IN THE NEXT INFORMATION BOX.<br>TICK THE DRAWING/BOM/ROUTING BOX AS APPROPRIATE TO THE AN.  |              |   |                                    |
| Customer:   |                            | Description:  |   |   |              |   |                                    |
| <div style="border: 2px solid red; padding: 10px; transform: rotate(-2deg); display: inline-block;"> <b>DEV STAGE 4</b><br/><br/> <b>FULL PRODUCTION</b> </div> |                            | Name:   |   | Date:   |              | <div style="display: flex; justify-content: space-between;"> <div>REVISION</div> <div> <div style="border: 1px solid black; padding: 2px;">DRAWING <input checked="" type="checkbox"/></div> <div style="border: 1px solid black; padding: 2px;">BOM <input checked="" type="checkbox"/></div> <div style="border: 1px solid black; padding: 2px;">ROUTING <input type="checkbox"/></div> </div> </div> |                                    |
|   |                            | B   |   | <div style="display: flex; justify-content: space-between;"> <div>DESCRIPTION OF CHANGE</div> <div>AN NUMBER 08-E133</div> </div> <p>Front cap assembly sheet moved from main assembly to lead assembly</p>   |              |   |                                    |
|   |                            | C   |   | <div style="display: flex; justify-content: space-between;"> <div>DESCRIPTION OF CHANGE</div> <div>AN NUMBER 09-E115</div> </div> <p>Customer part number on drawing changed from 2970500 to 2982400<br/>Change PCB part number from PCBA10003A01B to PCBA10003A01C</p>   |              |   |                                    |
|   |                            | D   |   | <div style="display: flex; justify-content: space-between;"> <div>DESCRIPTION OF CHANGE</div> <div>AN NUMBER 09-E193</div> </div> <p>Update drawing outline<br/>Remove Moltech logo from PCB<br/>On the BOM replace Moltech with Accutronics</p>  |              |   |                                    |
|   |                            | E   |   | <div style="display: flex; justify-content: space-between;"> <div>DESCRIPTION OF CHANGE</div> <div>AN NUMBER 10-E190</div> </div> <p>Changed ref to PCb from PCBA10003A01C to PCBA10003A01D on drawing &amp; bom, changed the controlling document from PCBA10003A1B_2 v1.4 to PCBA10003A01D</p>  |              |   |                                    |
|   |                            | F   |   | <div style="display: flex; justify-content: space-between;"> <div>DESCRIPTION OF CHANGE</div> <div>AN NUMBER 11-E133</div> </div> <p>Changed "Airox Covidien" to "Covidien PB540/PB560 Ventilator" on each sheet<br/>Added note of strip length of wires<br/>Added extra stage of programming the EEprom, Fixture and test instructions number</p>            |              |   |                                    |
|   |                            | H   |   | <div style="display: flex; justify-content: space-between;"> <div>DESCRIPTION OF CHANGE</div> <div>AN NUMBER 14-E086</div> </div> <p>Revision G never Released into production<br/>Updated PCB from PCBA1003A01D to PCBA10003A01F</p>   |              |   |                                    |
|   |                            | J   |   | <div style="display: flex; justify-content: space-between;"> <div>DESCRIPTION OF CHANGE</div> <div>AN NUMBER 15-E008</div> </div> <p>Soldering Iron Tip added (T0182) &amp; Heatstake Jig Added (J0252)<br/>Temperature of the soldering iron added when heatstaking<br/>Flexible epoxy (GL0202) was Terastat<br/>Force gauge added. Issue 1 not released</p> |              |   |                                    |
|   |                            | K   |   | <div style="display: flex; justify-content: space-between;"> <div>DESCRIPTION OF CHANGE</div> <div>AN NUMBER 15-E048</div> </div> <p>Changed part number of PCBA from PCBA10003A01F to PCBA10003A01G</p>  |              |   |                                    |
|   |                            | <div style="display: flex;"> <div style="flex: 1;">Details of alert:</div> <div style="flex: 1;">Details of corrective action:</div> </div>   |   | REVISION  |              | <div style="border: 1px solid black; padding: 2px;">DRAWING <input type="checkbox"/></div> <div style="border: 1px solid black; padding: 2px;">BOM <input type="checkbox"/></div> <div style="border: 1px solid black; padding: 2px;">ROUTING <input type="checkbox"/></div>  |                                    |
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| Date: 18/6/15   | Chkd: JA                   |   |   |   | Next Sht: -- |   |                                    |
| CAD DATA 1:1<br>ALL DIMENSIONS IN mm<br>DO NOT SCALE  |                            | THIRD ANGLE PROJECTION<br><br>NDE94002 ISSUE 7  | ACCUTRONICS LIMITED<br>Unit 20, Loomer Road,<br>Newcastle-Under-Lyme,<br>Staffordshire, England |   |              |   |                                    |