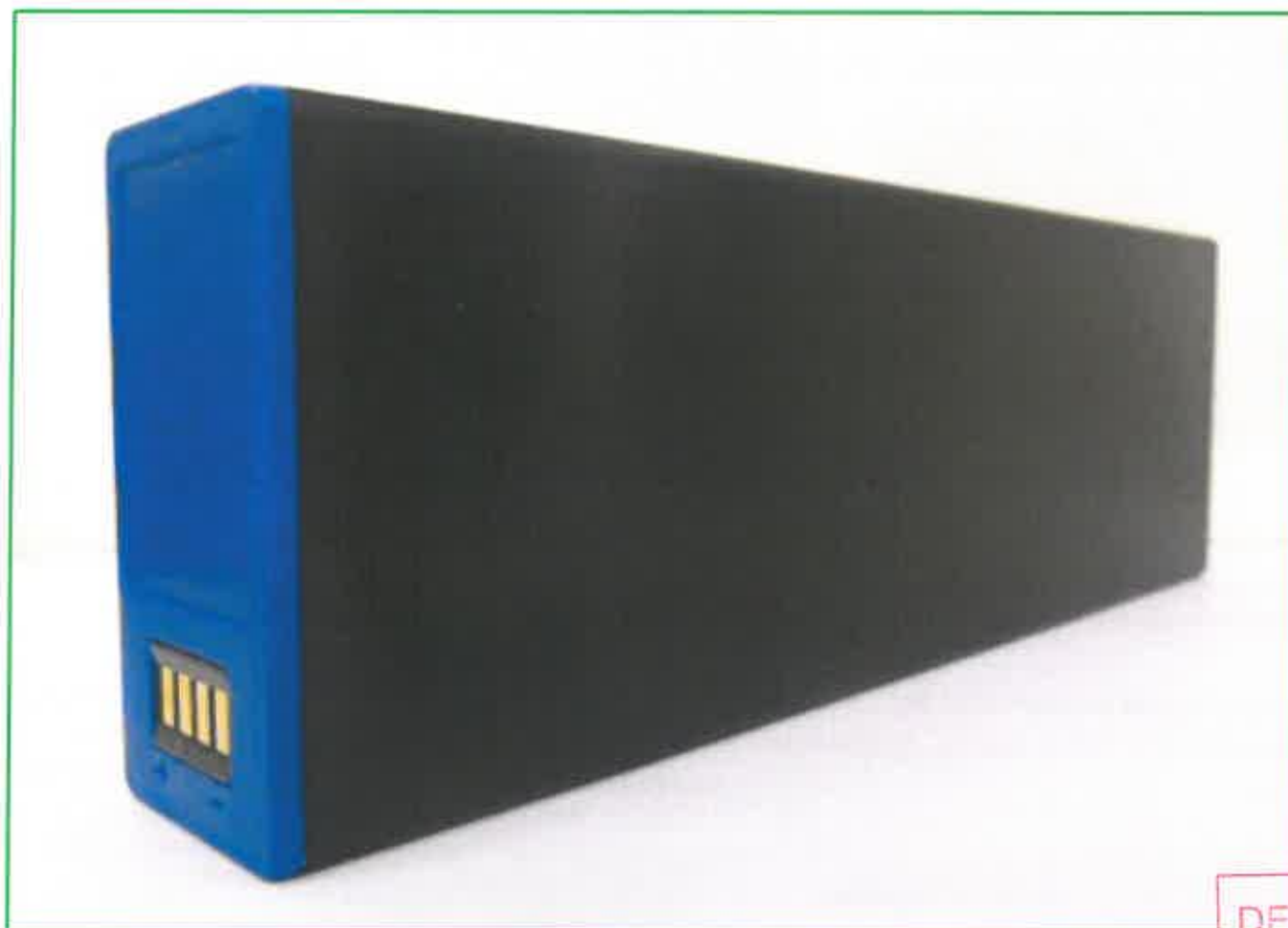


Covidien Lead Assembly Work Instruction – L6A051BE00004-Stage 2



DEV STAGE 4

FULL PRODUCTION

IMPORTANT NOTE: Make sure that the heatshrink is flush to the edge of the tab.

IMPORTANT NOTE: Ensure crocodile clip is used when soldering to attract the heat away from the fuse.

IMPORTANT NOTE: When cutting the following pieces of heatshrink make sure you check the measurement of the first off .

SS4801 Length 25.0mm

SS4801 Length 10.0mm

SS2401 Length 25.0mm

SS2401 Length 15.0mm

SS1601 Length 25.0mm

IMPORTANT NOTE: Make sure that the information written on the polyswitch is on the outside and is visible.

IMPORTANT NOTE: Please ensure that the soldering iron is tested and verified for the required temperature before use.



Reference HSR0049



ESD Cutters



Heat Gun

Reference HSR0005



Note: Soldering Iron set at 400°C.



Note: Use lead free solder HW1012.

DEV STAGE 4

FULL PRODUCTION

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DATE: 21/05/15	NAME: JME	SCALE:	Accutronics Ltd, Unit 10, Leamster Road, Pennington, Lymington, Hampshire, England, ST15 7LB	NDE96004	CAT No: L6A051BE00004_WI_Stage 2	SHT: 2	accutronics professional battery equipment
DATE: 18/6/15	CHKD: OA	HTS				Total: 8	

Fuse Assembly

1

Cut both legs down to 20mm from body on fuse 178A3200CN. Using ESD cutters below.



178A3200CN

3

Solder the fuse 178A3200CN to wire WI0730BRSPL-2.



WI0730BRSPL-2



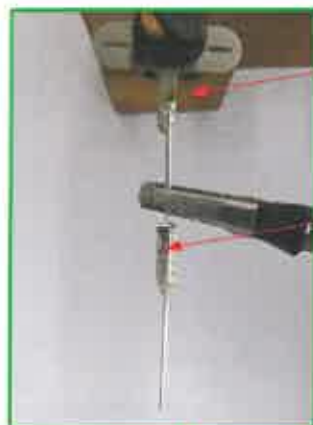
Note: Soldering Iron set at 400°C.



Note: Use lead free solder HW1012.

2

Solder the fuse 178A3200CN to tab TB003B.



TB003B

178A3200CN

DEV STAGE 4

FULL PRODUCTION

4

Blow down the heatshrink tubes using a heat gun. Temperature set at 240°C



Attach heatshrink to fuse when soldering.




SS4801

SS1601

IMPORTANT NOTE:
Make sure to test the fuse after assembly with a fluke tester to make sure it is not damaged.

IMPORTANT NOTE:
Ensure crocodile clip is used when soldering to attract the heat away from the fuse.

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DATE: 21/05/15	NAME: JME	SCALE NTS	Accutronics Ltd. Unit 20, Loomer Road, Newcastle-under-Lyme, Staffordshire, England. ST5 7LB	NDE96004	CAT No.: L6A051BE00004_WI_Stage 2	SHT: 3	
DATE: 18/6/15	CHKD: PA					Total: 8	

QUALITY KEYPOINTS



Heat shrink is not covering all solder joint.



Heat shrink not blown down enough. If too loose it will slide off the link.



Heat shrink torn.

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DATE: 21/05/15	NAME: JME	SCALE:	ACCUTRONICS LTD, Unit 20, Loxley Road, Newcastle-under-Lyme, Staffordshire, England, ST5 2LB	NOE6004	CAT NO.:	SHT: 4	accutronics professional battery solutions
DATE: 18/6/15	CHKD: DS	NTS			L6A051BE00004_WI_Stage 2	TOTAL: 8	

NTC Assembly



Note: Soldering Iron set at 400°C.

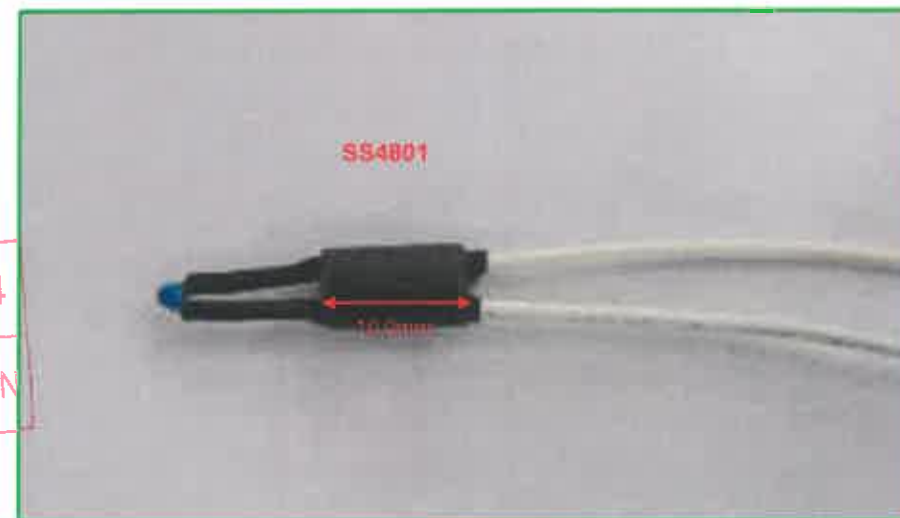


Note: Use lead free solder HW1012.

- 1 Attach heatshrink to wire before soldering the NTC EC0032 to the white wires WI0730WHSPL-2, solder one wire to the outside of one of the NTC legs and the other wire to the inside of the other NTC leg.




- 2 Fit and blow down heatshrink piece SS4801 to NTC. Temperature set at 240°C.



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DATE: 21/05/15	NAME: JME	SCALE	Accutronics Ltd. Unit 20, Loomer Road, Newcastle-under-Lyme, Staffordshire, England. ST3 7LB	NDE96004	CAT No.:	SHT: 5	 professional battery solutions
DATE: 18/6/15	CHKD: DA	NTS			L6A051BE00004_WI_Stage 2	Total: 8	

QUALITY KEYPOINTS



Quality Points:

1: Make sure the heat-shrink is blown down correctly.

2: Make sure all soldered joints are covered.

3: Make sure all three pieces of heat-shrink is fitted.

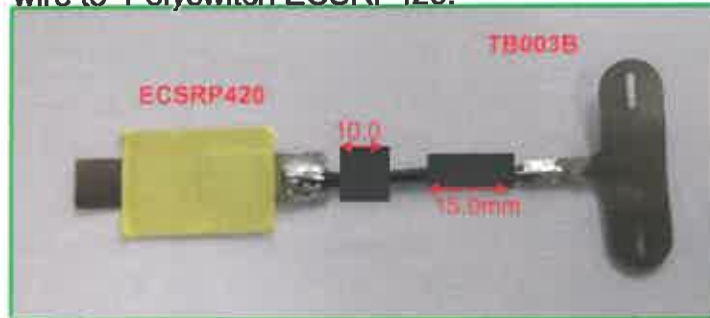
DEV STAGE 4

FULL PRODUCTION

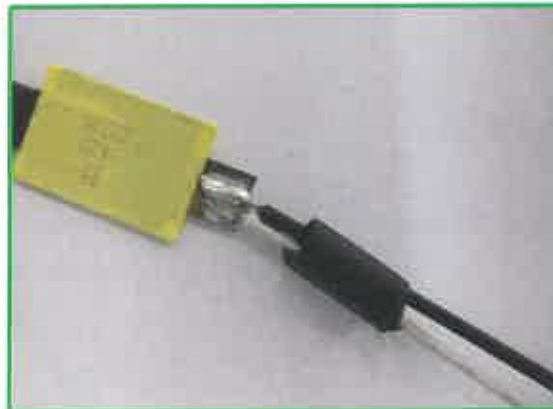
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DATE: 21/09/15	NAME: JME	SCALE: NTS	Accutronics Ltd. Unit 20, Loover Road, Hemsworth-under-Lyme, Staffordshire, England. ST5 7LB	NDE96004	CAT No.: L6A051BE00004_WI_Stage 2	SHT: 6	
DATE: 18/6/15	CHKD: ON					Total: 8	

Polyswitch Assembly

1 Solder the Black wire (WI0730BKSPL-2) Length 35.0mm to the tab TB003B. Attach heat-shrink as shown before soldering the other end of the black wire to Polyswitch ECSR420.



2 Solder the Polyswitch ECSR420 to the black wire WI730BKSPL-2 and the white wire WI730WHSPL-2 that is connected to the NTC EC0032.



IMPORTANT NOTE:

Make sure that the information written on the polyswitch is on the outside and is visible.



Note: Soldering Iron set at 400°C.



Note: Use lead free solder HW1012.

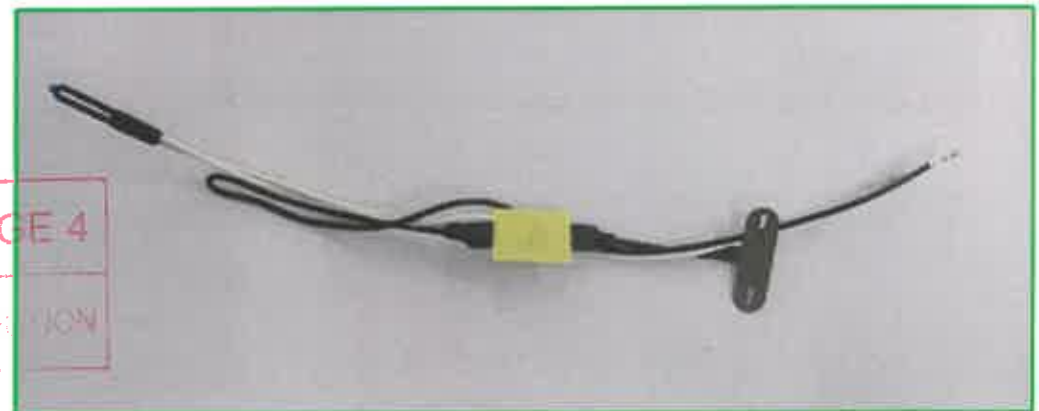
3

Blow down heatshrink pieces SS4801 and SS2401. Temperature set at 240°C



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DATE: 21/09/15	NAME: JME	SCALE: NTS	Accutronics Ltd. Unit 20, Loomer Road, Newcastle-under-Lyme, Staffordshire, England. ST5 7LB	NDE96004	CAT No.: L6A051BE00004_WI_Stage 2	SHT: 7
DATE: 18/6/15	CHKD: DA					Total: 8

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QUALITY KEYPOINTS



Quality Points:

1: Make sure the heat-shrink is blown down correctly.

2: Make sure all soldered joints are covered.



Poly switch soldered incorrectly. Soldered joints must be on the same side as the writing of the poly switch.

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DATE: 25/05/15	NAME: JME	SCALE: NTS	Accutronics Ltd, Unit 20, Laxmer Road, Newcastle-under-Lyme, Staffordshire, England ST15 7LB	NDC96004	CAT No.: L6A051BE00004_WI_Stage 2	SHT: 8	
DATE: 18/6/15	CHKD: Jm					Total: 9	