# 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 veryfied for the required temperature before use.

#### **ESD Cutters**





Reference HSR0005



Note: Soldering Iron set at 400°C.



Note: Use lead free solder HW1012.
DEV STAGE 4

FULL PRODUCTION

#### Reference HSR0049

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**Heat Gun** 

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### **Fuse Assembly**

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



Solder the fuse 178A3200CN to wire WI0730BRSPL-2.





WI0730BRSPL-2



**Note: Soldering** Iron set at 400°C.



Note: Use lead free solder HW1012.

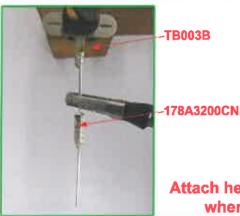
**IMPORTANT NOTE:** Make sure to test the

fuse after assembly

with a fluke tester to make sure it is not damaged.



Solder the fuse 178A3200CN to tab TB003B.



SS4801

**DEV STAGE 4** 

**FULL PRODUCTION** 

Blow down the heatshrink tubes using a heat

gun. Temperature set at 240°C





SS1601



#### **IMPORTANT NOTE:**

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

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## **QUALITY KEYPOINTS**







Heat shrink is not covering all solder joint.



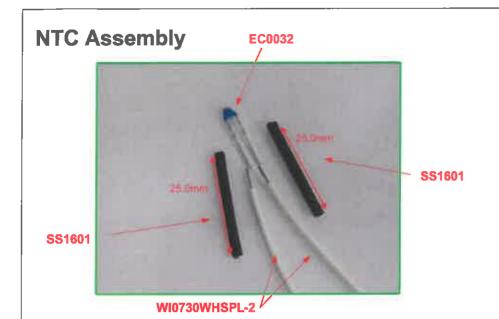


DEV STAGE 4 DEV STAGE 4 Off the link.

Heat shrink torn.

FULL PRODUCTION

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Note: Soldering Iron set at 400°C.



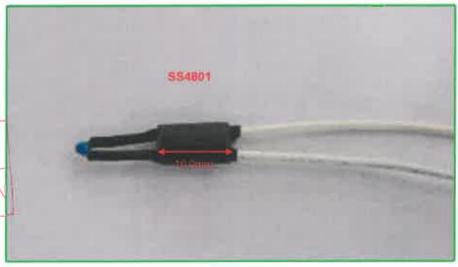
Note: Use lead free solder HW1012.

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.



DEV STAGE 4
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Fit and blow down heatshrink piece SS4801 to NTC. Temperature set at 240°C



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

DEV STAGE 4

**FULL PRODUCTION** 

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### **Polyswitch Assembly**

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

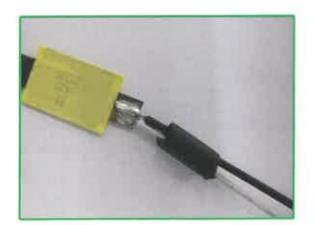
wire to Polyswitch ECSRP420.

TB003B

10.0

TB003B

Solder the Polyswitch ECSRP420 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.

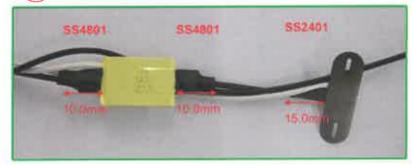


Note: Soldering Iron set at 400°C.



Note: Use lead free solder HW1012.

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





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## **QUALITY KEYPOINTS**



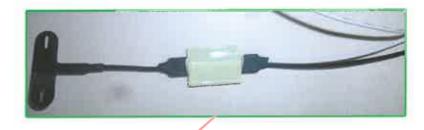




1: Make sure the heat-shrink is blown down correctly.

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.

**DEV STAGE 4** 

**FULL PRODUCTION** 

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