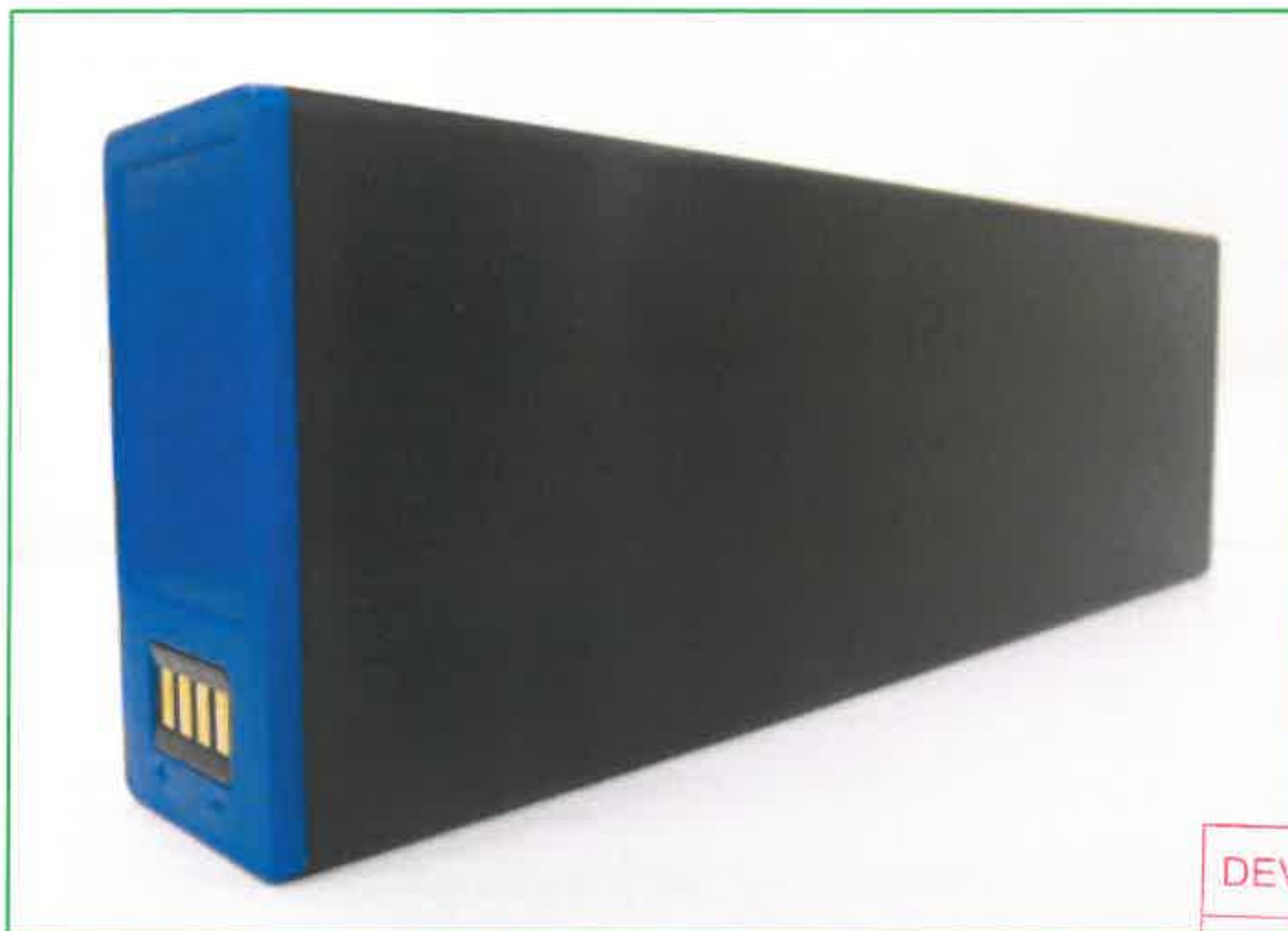


Covidien Lead Assembly Work Instruction – L6A051BE00004-Stage 3



DEV STAGE 4

FULL PRODUCTION

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

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

IMPORTANT NOTE: When cutting the following pieces of heatshrink make sure you check the measurement of the first off .
SS2401 Length 15.0mm



Reference HSR0049



Heat gun



Reference HSR0005
Note: Soldering Iron set at 400°C.



Note: Use lead free solder HW1012.

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

Solder Lead Assembly to Links

- 1 Solder the lead assembly wires to the correct tabs as displayed.



Note: Soldering Iron set at 400°C.

Note: Use lead free solder HW1012.



DEV STAGE 4

FUL

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

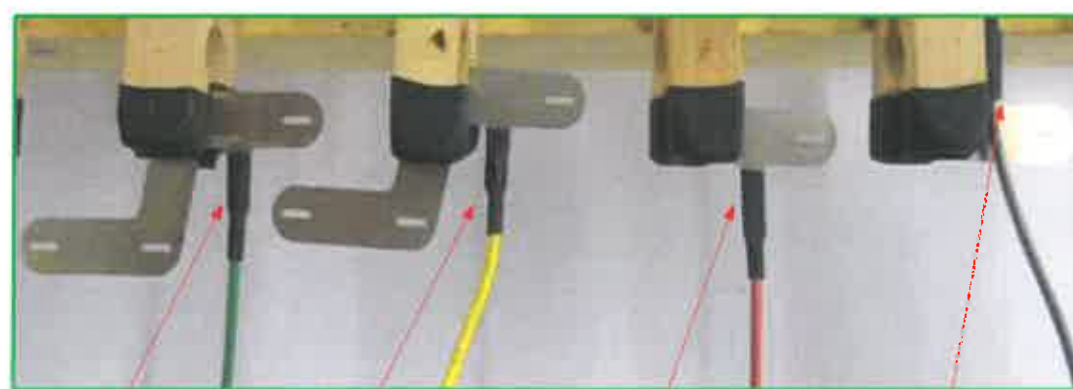
- 2 Fit and blow down 7 pieces of heatshrink SS2401 Length 15.0mm where required. Using Heat gun . Temperature set at 240°C



SS2401

SS2401

SS2401



SS2401

SS2401

SS2401

SS2401

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C	15-E048				Covidien Lead Assembly Work Instruction	Covidien PB540/PB560 Ventilator
DATE:	NAME:	SCALE		CAT No.:	SHT:	
21/05/15	JME		Accutronics Ltd, Unit 20, Loomer Road, Newcastle-under-Lyme, Staffordshire, England. ST5 7LB		3	
DATE:	CHKD:	NTS	NDE96004	L6A051BE00004_WI_Stage 3	Total:	7
18/6/15	PA					accutronics professional battery solutions

QUALITY KEYPOINTS



PVC burnt



Wire not central of link.



PVC squashed and melted.



Strands of wire sprayed



Heat shrink is not covering all solder joint.



DEV STAGE 4
FULL PRODUCTION



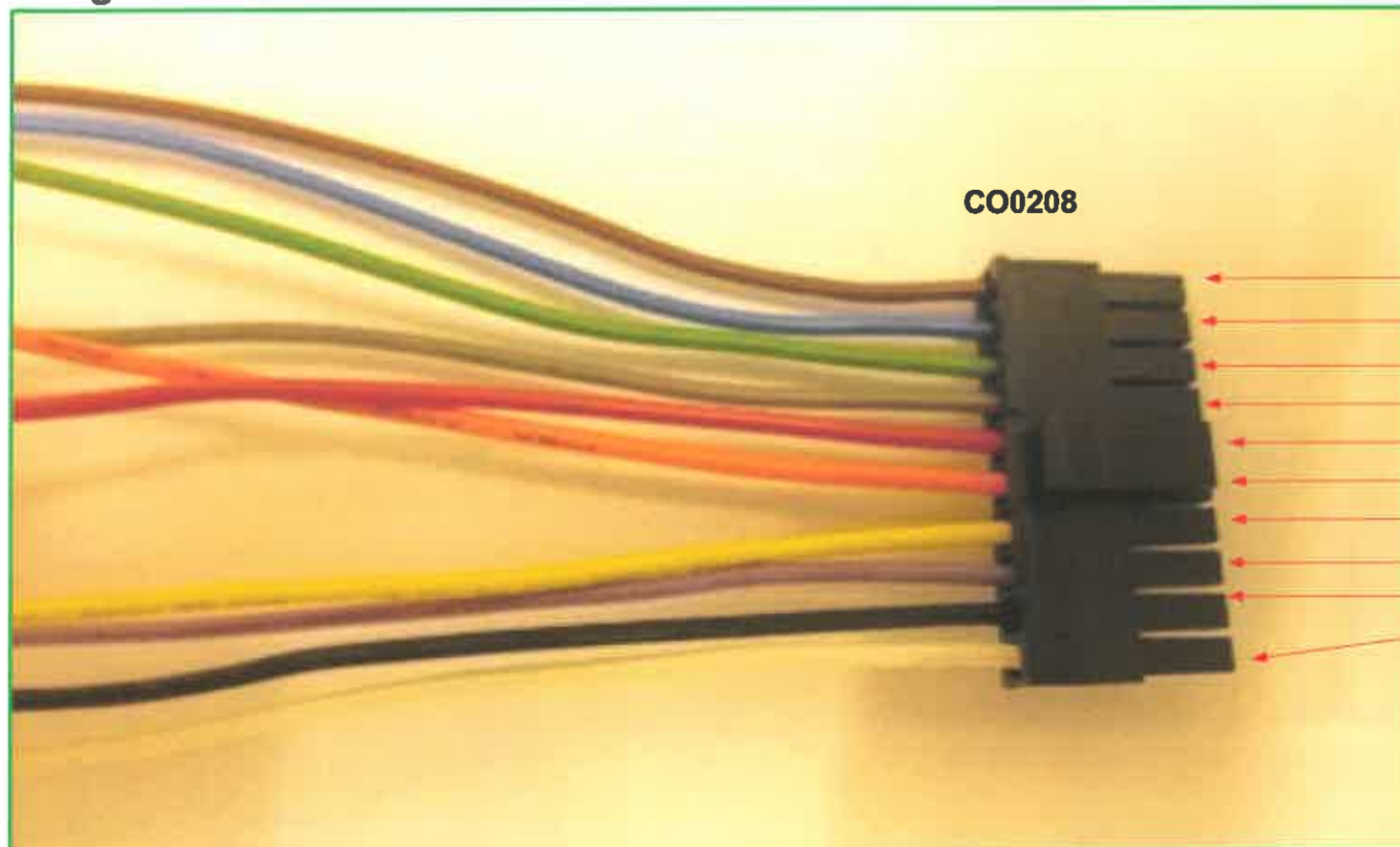
Heat shrink not blown down enough. If too loose it will slide off the link.



Heat shrink torn.

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DATE: 18/6/15	CHKD: DT					Total: 7	

Fit Housing



- Position 10 (Brown)
- Position 9 (Blue)
- Position 8 (Green)
- Position 7 (Grey)
- Position 6 (Red)
- Position 5 (Orange)
- Position 4 (Yellow)
- Position 3 (Violet)
- Position 2 (Black)
- Position 1 (White)

DEV STAGE 4

FULL PRODUCTION

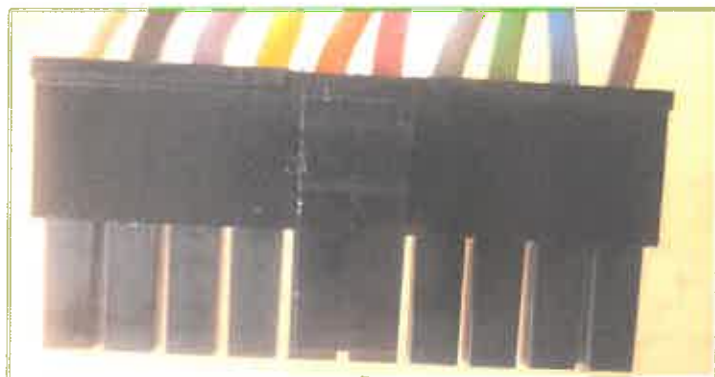
1

Fit wires to housing connector CO0208 using the table displayed as a guide to where each wire belongs.

Connector Position	Wire Colour	Wire Part Number	Legend	Stripped Wire Length (mm) $\pm 1.0\text{mm}$
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

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DATE: 18/6/15	CHKD: DA	NTS				Total: 7	

QUALITY KEYPOINTS



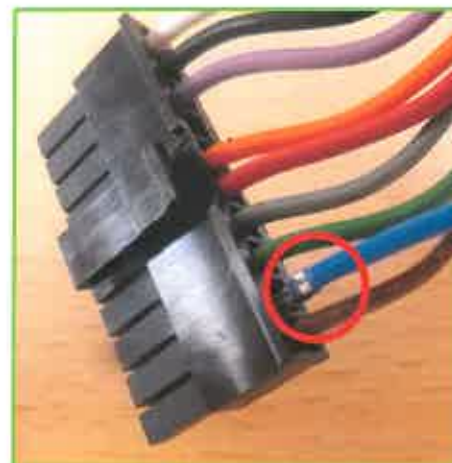
Correct, all
wires fitted in
correctly



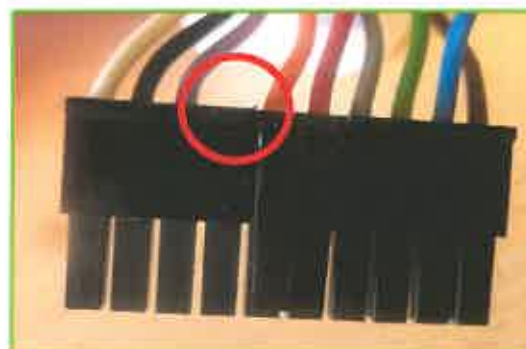
NOTE:

- 1: All colours should be in correct numbers in housing.
- 2: All Terminals must be pushed in housing correctly.

DEV STAGE 4
FULL PRODUCTION



Terminal is not
pushed in the
housing



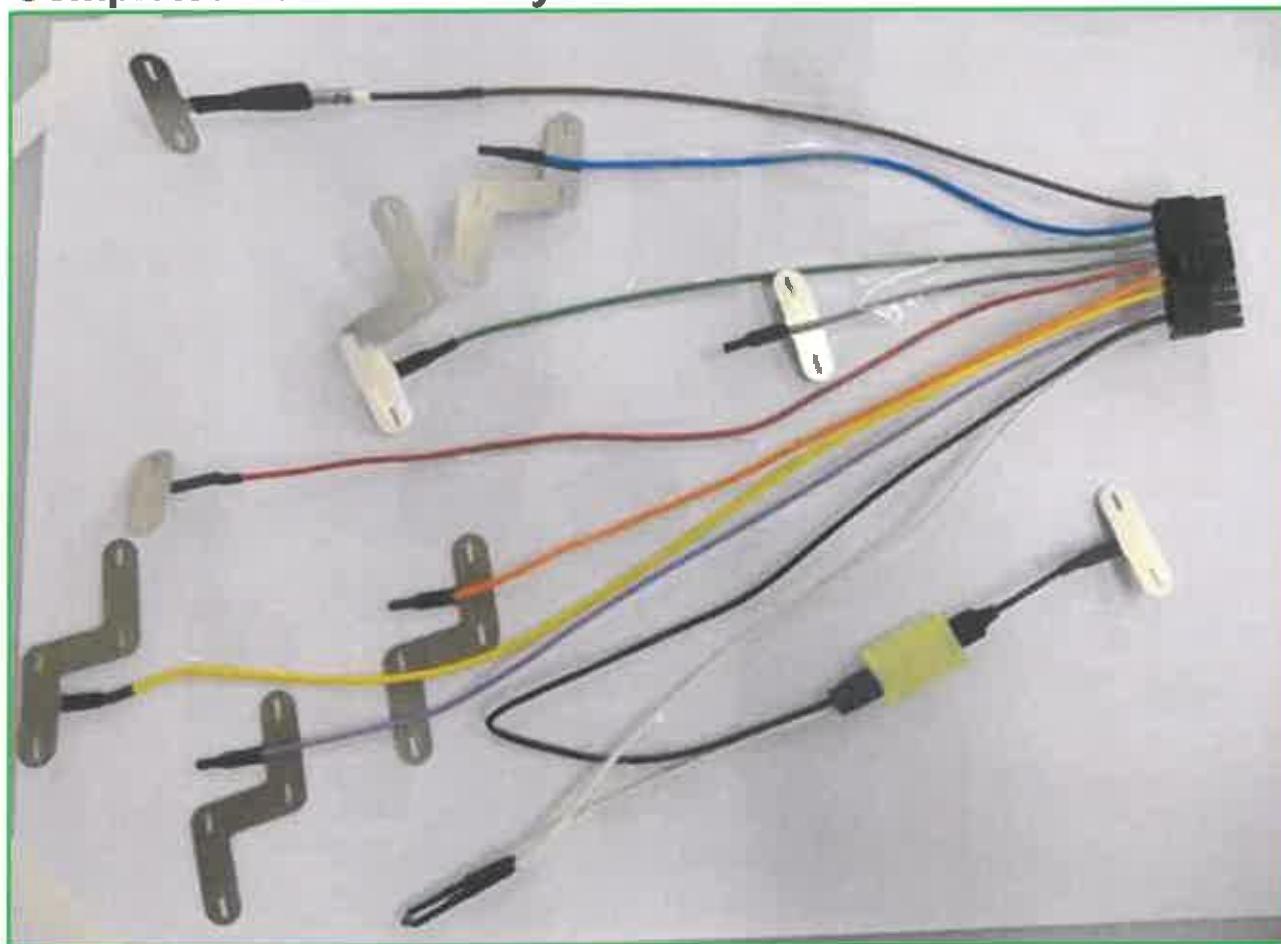
Wire missing



Terminal is
crushed for this
to happen

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DATE:	16/6/15	CHKD:	QA							Total:	7	

Completed Lead Assembly



1: Make sure all wires are in correct order.

2: All heat shrink fitted correctly.

3: All tooled links fitted to correct wires.

4: The connector is not damaged.

5: The poly-switch is fitted the correct way.

6: Make sure there are no cuts or melted wires.



**100% Quality Check at this point
(IDENTIFICATION LABEL TO BE
APPLIED AT THIS STAGE)**

COMPONENT IDENTITY LABEL	
DESIGN NO.	
DRAWING NO.	L6A051BE0004 Label for reference only
QTY	10
CUSTOMER	Covidien
ORDER NO.	W034235
DATE	24/3/15
SUPPLIER	
STOCK LOCATION NO	

DEV STAGE 4

FULL PRODUCTION

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