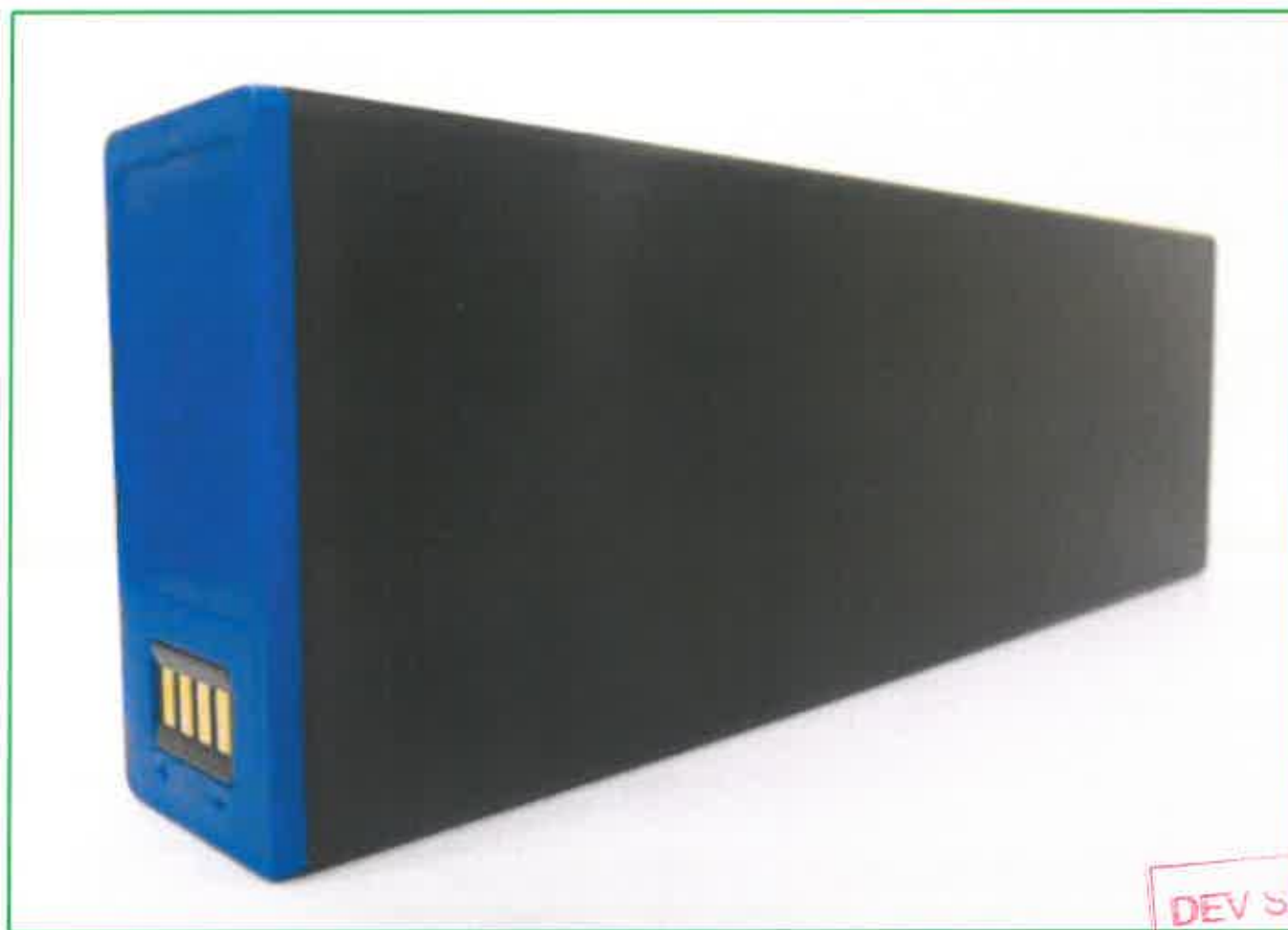


## Covidien Lead Assembly Work Instruction – L6A051BE00004-Stage 1



DEV STAGE 4

FULL PRODUCTION

# Covidien Lead Assembly Work Instruction – L6A051BE00004

## Accutronics Supplementary Documents


<u>Document</u>	<u>Revision</u>
Battery Test_ 0013	0.3

Created By: JME  
Date: 21/05/15

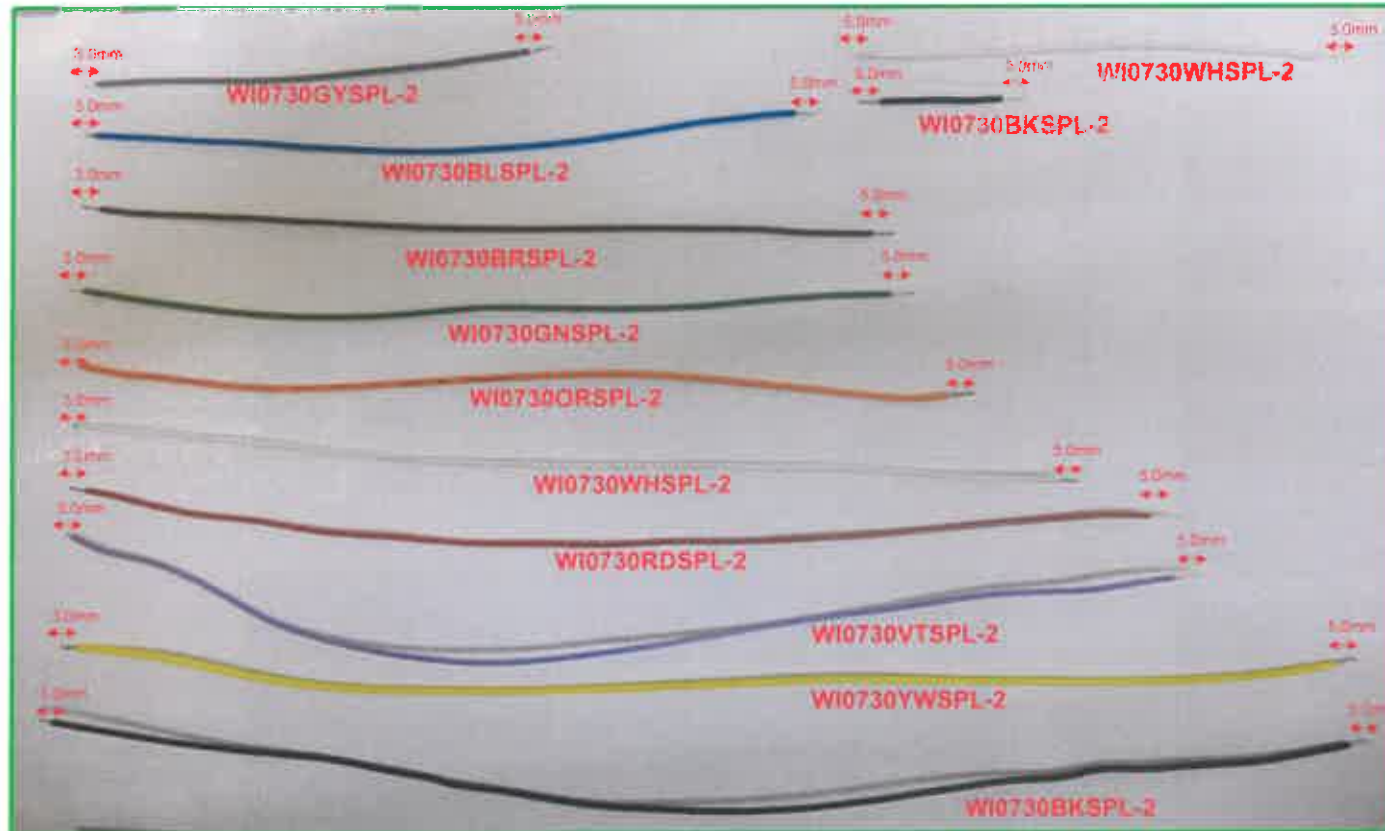
Issue: C

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ISSUE: C	ALTERATION NUMBER: 21/05/15	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 AUTHORISED IN WRITING BY ACCUTRONICS LIMITED.			TITLE: Covidien Lead Assembly Work Instruction	APPLICATION: Covidien PB540/PB560 Ventilator	
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 1	Total: 6	

## Cutting & Stripping the Wires



WI0730GYSPL-2 – 100±2.0mm  
 WI0730BLSPL-2 – 155±2.0mm  
 WI0730BRSPL-2 – 170±2.0mm  
 WI0730GNSPL-2 – 175±2.0mm  
 WI0730ORSPL-2 – 185±2.0mm  
 WI0730WHSPL-2 – 205±2.0mm  
 WI0730RDSPL-2 – 225±2.0mm  
 WI0730VTSPL-2 – 235±2.0mm  
 WI0730YWSPL-2 – 265±2.0mm  
 WI0730BKSPL-2 – 265±2.0mm  
 WI0730WHSPL-2 – 100±2.0mm  
 WI0730BKSPL-2 – 35±2.0mm

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.


Observe wire length tolerance of ± 2.0mm.



Reference HSR0056

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Cut wires to indicated length using the wire cutting machine.

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DATE: 18/6/15	CHKD: DA	NT5			L6A051BE00004_WI_Stage 1	Total: 6	

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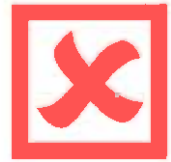
# QUALITY KEYPOINTS



Correct



Correct



Strands of wire cut shorter than others



All strands of wire snapped.



Wire stripped too long.



Wire stripped too short.



First off Quality Inspection  
(Data to be recorded refer to NQA124)

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DATE: 18/6/15	CHKD: DA	NTS			L6A051BE00004_WI_ Stage 1	Total: 6	

# Crimping Terminals



Reference HSR0048



**IMPORTANT NOTE:** Ensure correct crimp setting has been selected.

- 1 Crimp terminals CO0062 to wires using machine displayed above J0251.



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DATE: 21/05/15	NAME: JME	SCALE	Accutronics Ltd. Unit 20, Loomer Road, Newcastle-under-Lyme, Staffordshire, England. ST9 7LB	NDE96004	CAT No.: L6A051BE00004_WI_ Stage 1	SHT: 5
DATE: 18/6/15	CHKD: GA	NTS				Total: 6

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# QUALITY KEYPOINTS



correct



First off Quality Inspection  
(Data to be recorded refer to NQA46)



Too much PVC  
caught in the  
terminal



Terminal not  
crimped the PVC  
of wire.

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DATE: 21/05/15	NAME: JME	SCALE: N/A	Accutronics Ltd. Unit 20, Lonsdale Road, Newcastle-under-Lyme, Staffordshire, England ST9 7LB	NDE96004	CAT NO.: L6A051BE00004_WI_Stage 1	SHT: 8
DATE: 18/6/15	CHKD: JME					Total: 8

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