



P/N: 10128152

Rev: J

Title: PB500 series POWERPACK 2 pack procedure

INSTRUCTIONS

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DOCUMENTATION ASSOCIATED TO THIS PROCEDURE: 10124919 PB500 Series Power Pack2 DHR LOG

REV	ECO	PREPARED BY	APPROVED BY	DATE	SUMMARY
N/A	N/A	N/A	N/A	N/A	For previous revision history see rev C in Agile.
D	EC026064		Refer to Agile	Refer to Agile	Clarify backflush process with respect to licence plate log and Ship carton serial number.
E	EC045537		Refer to Agile	Refer to Agile	Update to clarify that AC Out Cord needs to be bagged prior to pack.
F	EC072308		Refer to Agile	Refer to Agile	Add Visual Aid for Outer Label Verification requirement.
G	EC102789		Refer to Agile	Refer to Agile	Update PB500 series POWERPACK 2 pack procedure to address minor issues relating to a procedure v's practice review and incorporate G-QAP056 (2018) updates.
H	EC117495		Refer to Agile	Refer to Agile	Update to meet EMC 4 th edition standard requirements; add ferrite to AC out cord.
J	EC129900		Refer to Agile	Refer to Agile	Add update for generation of additional label for liscence plate – needed for scanning of unit to SAP at shipping.



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1. PURPOSE

This is the pack procedure will be used to package PB500 series POWERPACK units.

2. SCOPE

This procedure covers the the PB500 series POWERPACK product.

3. DEFINITIONS

S/N – Serial Number

A/R - As required

4. REFERENCES

4098100	Powerpack
10099745	PB500 series POWERPACK2 assembly & test procedure
10021754	Product Release Authorisation
10021500	Rework/Repair Procedure
G-AMFG-2909-00	BPCS Backflushing Procedure
G-AMFG-2910-00	BPCS Picking Procedure
G-AMFG-1165-00	Pareto Chart Procedure
10039893	PB560/PB540/PB520 Line Clearance log
10012479	Generic Cleaning Log
G-AMFG-1814-00	Cosmetic Criteria, Monitors / PB540 & PB560
G-AMFG-2913-00	Printing Labels Using Labelview
10124919	PB500 PowerPack2 DHR LOG
10149038	Verification scanner operating procedure
10148650	Printing generic shipping carton labels using click print

5. GENERAL REQUIREMENTS

Tool List:

Equipment Description	P/N
Safety Knife	N/A
Kim wipes	901731
Lint free cloth	N/A
Isopropyl Alcohol	N/A
Cable retainer fixture	10025244

BOM P/Ns and Balloon numbers

- At the start of each week, it is the responsibility of the Line Leader / Production Supervisor to print out a copy of the BOM from Galway BPCS and sign & date it.
 - Compare revisions for any changes from previous week's build.
 - Prior to recording revisions on DHR, ensure that they match revisions on printout
 - Contact a quality engineer, line supervisor or manufacturing engineer when any discrepancies noted
- Refer to the approved Galway BPCS BOM for the cross reference of p/ns to balloon numbers as referenced in this procedure



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6. PROCEDURE

LABELING SCAN VERIFICATION

Follow instruction as per 10149038 "verification scanner operating procedure" and sign and date the relevant section of the PHR.

Balloon No.	Description	Qty
7	POWERPACK 2 assembly	1
11	Label Battery charge date Legendair xl2	1

1. Remove Assembly unit

with corresponding DHR (10124919) from Battery charger fixture. Ensure battery is fully charged by pressing battery symbol, all leds for battery 1 will flash ON as shown in fig 1. Complete battery verification on DHR.

2. Print Battery Charge Date label from labelview and attach to pack DHR, label is attached to external carton later in the process.

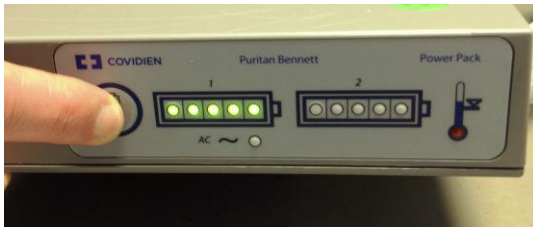


Fig 1

LABEL/COSMETIC INSPECTION PRIOR TO PACK

Labelling & keypad checks:

- Check that all labelling is present on the unit. See figs 2-4 of this section (labels highlighted with red dots).
- Check that there are no air bubbles or cosmetic defects on the labels or keypad
- Check that orientation / straightness is acceptable
- Check that the labels and keypad are correctly bonded to the unit

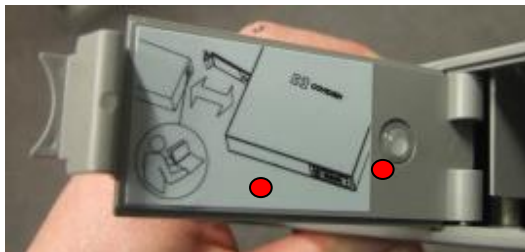


Fig 2

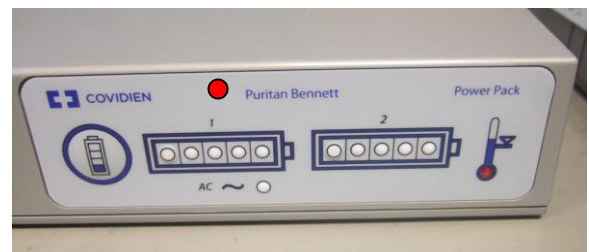


Fig 3



Fig 4

Note: The images are for representation purposes only



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Cosmetic Check

- Do a visual inspection of unit, checking for cosmetic defects, and clean it if necessary using alcohol and lint free cloth. Ensure use of protective gloves when using alcohol.
- Check to ensure adhesive battery stop is applied in correct location on door as per fig 2.
- Check Serial Number on unit matches Serial Number on DHR.

Adhesive feet and door latch check:

- Check for correct application of 4 adhesive feet fitted to cover, as per fig 5.
- Check to ensure all 6 screws are present to secure cover and housing as per fig 5.
- Open and close the Door to ensure hinge operation & ensure door latch is operating correctly, (latch may need to be clipped into place to secure). (See fig 6).

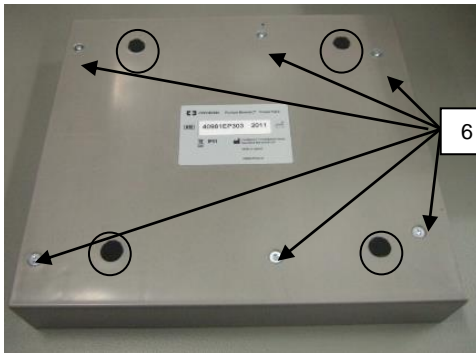


Fig 5

6 Screws are present



Fig6

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PREPARATION OF CABLE GRIPS

Materials

Balloon No.	Description	Qty	Balloon	Description	Qty
8	AC out-vent AC in Cord PPK2	1	13	Hang cable 6.6x4.3	3
10	AC mains power cord	1	14	PPK2 cable retainer clip	3
15	Ferrite	1	N/A	N/A	N/A

- As per the instructions to follow attach cable retainers to *AC out* and *AC mains power* cords

AC OUT CORD (8)

- Loop cable through ferrite as shown Fig. 7. Note orientation of closed ferrite (the numbers are to the front as highlighted below). There should be a distance of 45mm between the end of the closed ferrite and top of the inlet port as shown.

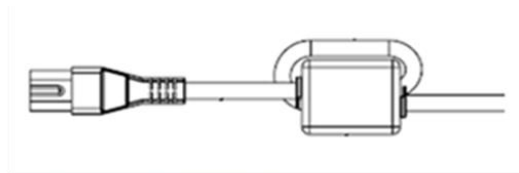


Figure 7: Loop cable through ferrite

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2. Install 2 x PKK2 cable retainer clips (A and B) in orientation shown as per figure 8. Distances given are in mm ± 10 mm.

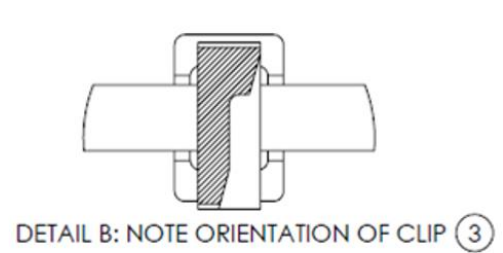
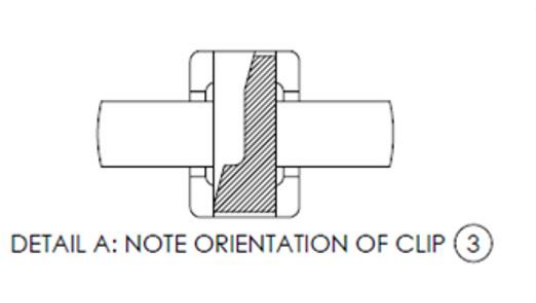
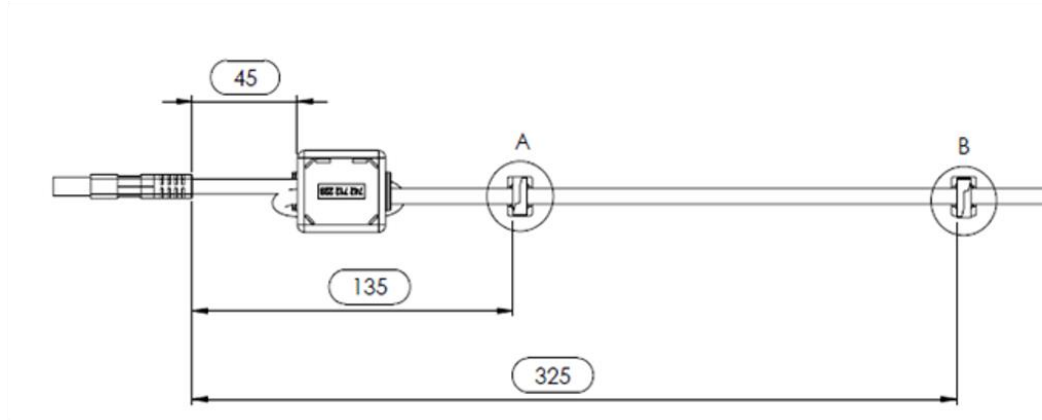


Figure 8: Installation and orientation of clips

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AC MAINS POWER CORD (10)

One cable retainer attached and orientated as shown in figure 9.

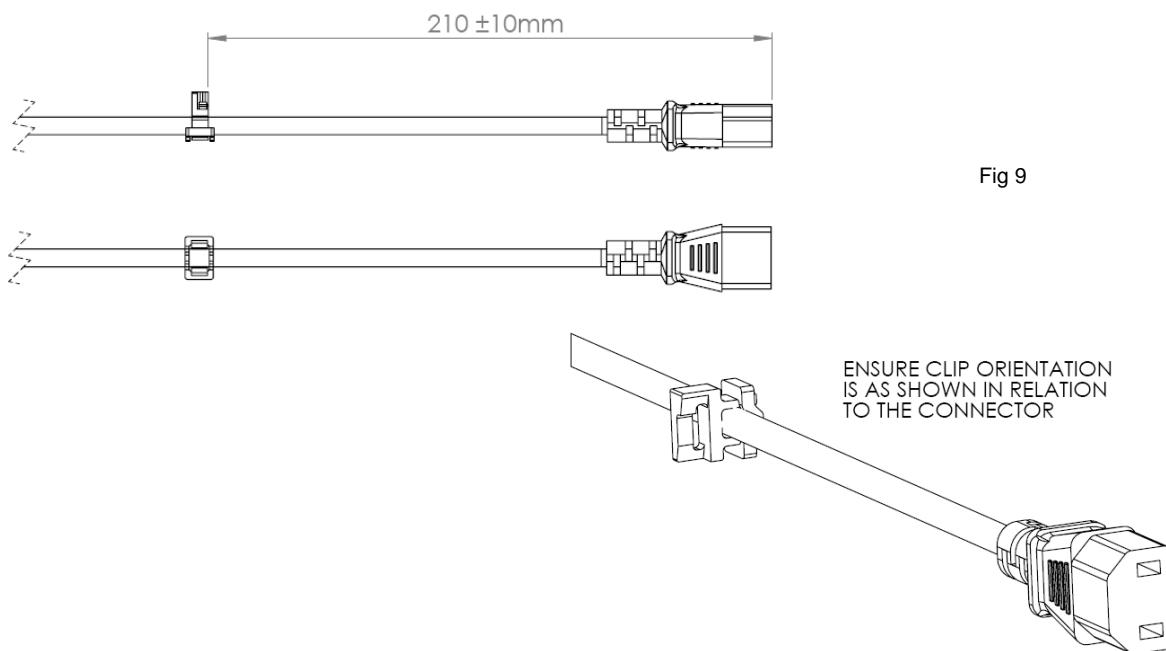


Fig 9

Push the retainer onto the cable at the required location as per fig 10a.

Using fixture (10025244), squeeze the legs of retainer as per fig 10b and push clip the grip on as per fig 10c. Ensure that the clip is securely in place on the cable.

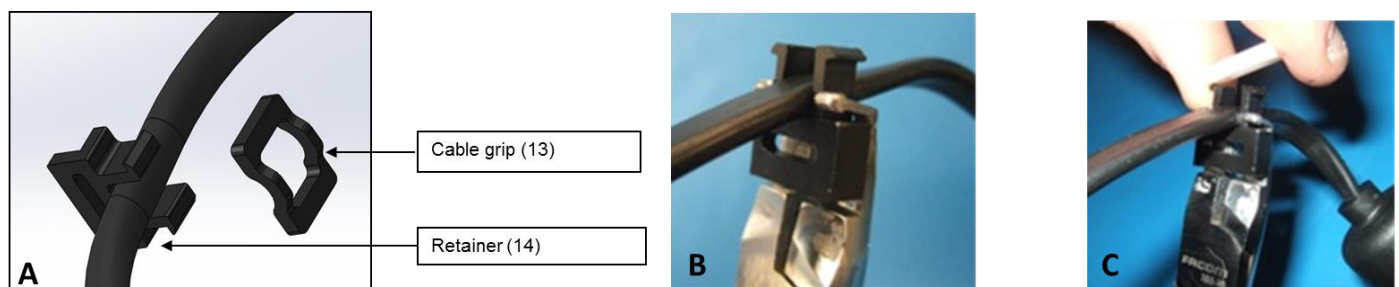


Figure 10: Installation of clips



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PACKAGING OF PB500 POWERPACK UNIT

Materials:

Balloon No.	Description	Qty
2	Scotch tape ¾"	A/R
3	Sealing tape 2"	A/R
4	Large bag	3
5	Packaging POWERPACK	1
6	Label Outer Carton POWER PACK	2
7	POWERPACK 2 assembly	1
8	AC out-vent AC in Cord PPK2	1
9	DC out cable 25cm	1
10	AC mains power cord	1
11	label battery charge date legendair xl2	1
12	Label PB540 class 9	1

Process Instruction:

1. Place unit into large plastic bag (4) and secure using scotch tape (2) as per fig 11.

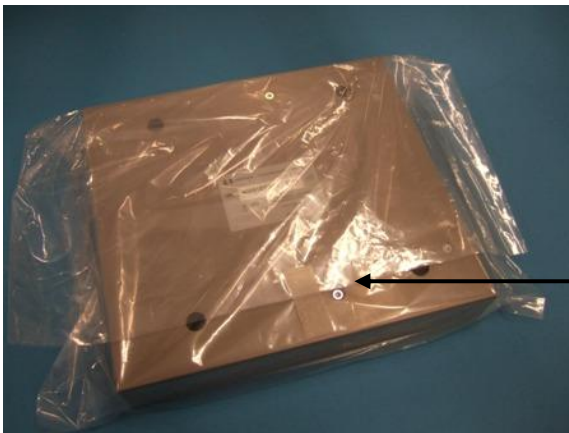


Fig 11

2. Open a shipping carton (5) and remove top foam piece as per fig 12.



Fig 12



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3. Place assembly (7) into location as per fig 13



Fig 13

Power Pack assembly (7)

Bagged Power Cord (10), Bagged AC Out Cord (8) & DC Out Cable (9) (Not bagged)

4. Place power cord (blln#10) and AC Out Cord (8) both with added cable grips into plastic bags (blln#4) as per fig 14 & 15 and place into location shown fig 13.



Fig 14



Fig 15

5. Place DC Out Cable (9) into carton as shown in fig 13.
6. Place the 2nd copy of Hipot & Leakage test report from DHR on top of the unit.

PACK CHECKS

- Check that 3 cords are packaged in clear plastic bags.
- Ensure the Hipot & Leakage test report is placed on top of unit the s/n on report must match the s/n on the PHR.

7. Place top foam piece into carton as per fig 16.



Fig 16



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8. Seal carton using 3 runs of tape (3) as per fig 17



Fig 17



Fig 18

Apply outer carton labels (bln#6) to these locations. Ensure both labels have the same orientation.

9. Print out the outer carton labels (6) refer to procedure G-AMFG-2913-00. Record revision in DHR.

10. Apply to locations as per fig 18.

Note: Labels pictured in fig 18 & 19 are for positional & dimensional representation only.

11. Retrieve Battery Charge Date label (11) from DHR and attach to carton as shown in figure 19.

12. Attach Class 9 label (12) to carton as shown in figure 19.

13. Record revision of Class 9 and Battery Charge Date labels in DHR.



Fig 19

FINAL PACK CHECKS

- Ensure the carton is correctly closed and carton is sealed.
- Ensure all information is correctly recorded & signatures/initials/dates have been completed on DHR.
- Check to ensure the serial number on outer carton label matches serial number on DHR.

○ SERIAL NUMBER SCANNING VERIFICATION

- Using designated scanner follow instruction to verify labels as per 10149038 verification procedure and sign and date the relevant section of the PHR.

- Sign and Date **PACK & Battery Charge Verification Section**



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Covidien Ireland Limited,
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10064401 Rev D

Above is a representation of a complete carton label.



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PLACING PACKAGED UNITS ON PALLET FOR SHIPPING

1. Stack units on pallet so that the shipping label faces outwards (where possible).
2. Stack the cartons as per fig 20, 21 & 22 noting the orientation of the cartons. Note each level is stacked in alternative orientations to the previous one.
3. Once cartons are stacked for shipment on the pallet, add plastic band and shrink wrap pallet.
4. Conduct the product release authorisation as per 10021754.
5. Initiate log 10097245.
6. Procedure for completion of log 10097245:

Record: part number, description & revision.

Retrieve additional DHR serial number label from DHR and attach to log **10097245**.

Generate additional 2D barcode label containing S/N and GTIN number. Attach to log 10097245.

Tick box for completion of packaging.

Sign and date log when complete.

Note: This pack log/ licence platelog will be used for for shipping purposes only. For backflushing purposes the serial number must be scanned from the PHR barcoded serial number label.
7. Trained personnel to complete back flushing and licence plate (ref G-AMFG-2909-00 & G-AMFG-2913-00 respectively).
8. Attach licence plate to pallet once PHR's have been used to complete backflushing process.
9. Move to product release authorisation.
10. Once product release authorisation has been signed, the product can be moved to shipping area

Forming the carton (if applicable)

If the carton is received in flat pack, form the carton and using three runs of clear tape to seal the bottom of the carton.

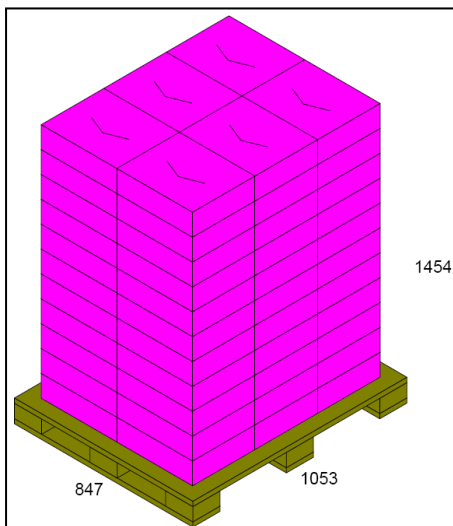


Fig 20

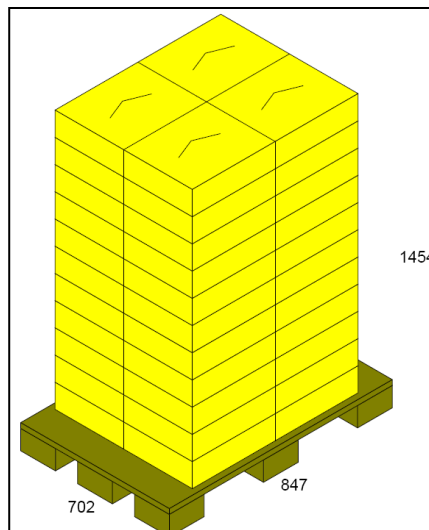


Fig 21

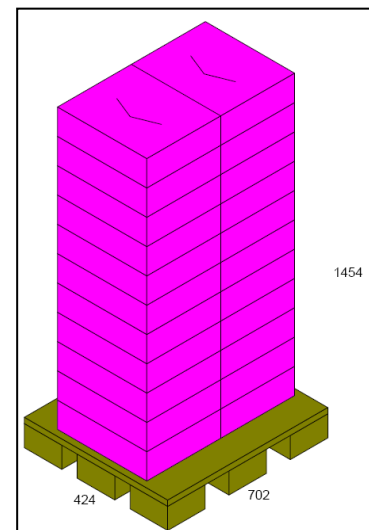


Fig 22