



P/N: 10095161
Rev: P
Title: PB560 Assembly procedure 1

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DOCUMENTATION ASSOCIATED TO THIS PROCEDURE:

10038461 PB560 DHR

REV	ECO	PREPARED BY	APPROVED BY	DATE	SUMMARY
N/A	N/A	N/A	N/A	N/A	Refer to rev J in Agile for previous revisions
K	ECO-R259799		Refer to Agile	Refer to Agile	Add instruction to record Assembly Part Revisions
L	EC017079		Refer to Agile	Refer to Agile	Update instructions regarding serial number label and product label and remove remove reference to product label application.
M	EC045535		Refer to Agile	Refer to Agile	Updates as per QAP056 redlines.
N	EC102789		Refer to Agile	Refer to Agile	Review for G-QAP056 - FY18
P	EC124148		Refer to Agile	Refer to Agile	Add updated image for Air Inlet Label



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1. PURPOSE

This assembly instruction details the steps required to assemble the PB560.

2. SCOPE

This procedure covers the PB560 product

3. DEFINITIONS

DHR – Device History Record

S/N – Serial Number

OP – Operation

4. REFERENCES

10038461	PB560 DHR
10095162	PB560 Assembly procedure 2
10095163	PB560 Assembly procedure 3
G-QAM001	MITG Quality Manual Support Procedure, Galway Site
10009491	Guidelines to Completion of Records
10021524	Preventative Maintenance PB500
G-AMFG-1814-00	Cosmetic Criteria, Monitors/PB500/Gen1/INVOS 5100C/HT70
G-AMFG-1013-00	MRB Documentation
G-AMFG-2733-00	PB540 / PB560 / PB520 DHR & S/N Printing Procedure
10037309	PB520/PB540/PB560 Line Clearance Procedure
10039893	PB520/PB540/PB560 Line Clearance LOG
10021526	PB540/560/520/500 Powerpack Lot Code and S/N Assignment
10021625	Tube Cutting
10021626	LOG - PB540/PB560/PB520 Tube Cutting
G-AMFG-1771-00	700 Series Silicone Tube Cutting
10106588	PB560 Portable Ventilator

5. GENERAL REQUIREMENTS

Assembly Notes:

- Ensure all relevant materials, tools, fixtures & jigs are available at the work station before commencing assembly/ manufacture.
- When connecting cables to connectors, check that male pins are straight. If not, place board into MRB.
- Ensure all tubing is inserted into connections fully
- The manufacturing assembly sequence of the unit may alter/vary to accommodate manufacturing capability
- Ensure all harnesses are fully pushed into mating connectors
- Images are for reference only

Cosmetic Notes

- **Note:** Paint work can be scratched with sharp objects. To avoid scratching, ensure the Unit is not kept beside sharp objects. Use ESD safe foam to leave unit on during assembly.



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GENERAL REQUIREMENTS cont.

DHR Notes:

- When printing the DHR ensure all pages are double sided, stapled at the top corner & all pages of DHR are present.
- When completing PB560 DHR's – record all entries / data / dates per Guidelines for Completion of Records 10009491.
- Record any components used for FRU in FRU Requirements section of DHR.
- When recording the requested component Serial/Lot numbers on the DHR, note that the component balloon number and description will be hard written on DHR. Please refer to product BOM for corresponding part numbers.
- To produce a component label for the DHR you must scan the yellow “Station 1” barcode chart first and then scan the required component barcode.

Equipment Notes:

- Before using any calibrated equipment, make sure that the calibration data (on calibration label) has not expired and there is no obvious damage to the equipment.
- If a torque tool is dropped on the floor during assembly, send for re-calibration.
- Torx screwdrivers to be used only for screw removal where required, and starting off / aligning screws into the holes. Do not use screwdrivers to tighten screws (there are specific torques for this)

Rework/Repair Notes

- If rework/repair is completed at any stage where dis-assembly is required, record all details in the DHR discrepancy log, 10038461. On the new DHR verify that s/ns and labelling revision are still correct, and that the appropriate final assembly checks are completed. If there is not sufficient space on the DHR, add a second DHR to include the additional information.
- If a unit is being reworked / repaired, the battery must be removed to avoid potential shorting of the power supply in case of a screw dropping on the PCBA. Exceptions to this are when only an upper housing is being replaced (no risk of screws causing shorts).

BOM notes

- 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 or Agile and sign & date it.

Production Operators will perform the following:

- 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

Traceability:

- All component S/N and Lot Numbers as listed on the DHR LOG 10038461 must be recorded.



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6. PROCEDURE

Initiating DHR & Printing labels:

1. Scan blue(PB560) "Product S/N" barcode chart to generate **3 Product S/N Labels** (4-070065-00).

Apply one to the top of page 1 of DHR.

Note: For rework (second and subsequent) DHR's it is acceptable to handwrite the DHR's S/N, in the same location (top of page 1).

The second Product Serial Number label will travel with the DHR until Pack where it will be attached to log 10097245 for backflush and licence plate purposes.

The third Product Serial Number Label is attached to the recess of the bottom enclosure. This is a temporary serial number label only and will be used to generate UDI compliant serial number label at pack station.

Assembly tasks completed per this document are to be recorded on DHR 10038461

FOAM & NEOPRENE CUTTING

Equipment:

- Calibrated ruler
- Scissors / foam cutting device
- 10025172 - Tube Cutter

Materials:

Balloon Number	Part Number	Description	Qty
714	Refer to BOM	Black foam, width 40mm, thickness 10.	2

Process:

1. Using a 6" or 12" calibrated steel ruler and scissors, cut 2 foam strips ref. bln # 714 to length 107.5mm (+/- 2.5mm) and place them in a materials bin for use in the main assembly.

POLYAMIDE TUBE CUTTING

Materials:

Balloon Number	Part Number	Description	Size	Qty
16	Refer to BOM	Polyamide Tubing 6x4 (0.2)	200mm	1

Process:

1. Cut the tube (bln #16) to size. Cut as per procedure 10021625 & record details on log 10021626.



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LOWER HOUSING ASSEMBLY

Materials:

Balloon Number	Part Number	Description	Qty
71	Refer to BOM	Female O2 connector/valve	1
72	Refer to BOM	Label Electrostatic protection	1
73	Refer to BOM	Air inlet label, CSA	1
44	Refer to BOM	Label product 520, 540, 560 O2/RA	1
75	Refer to BOM	Alarm repeater harness II	1
78	Refer to BOM	Retainingring	1
79	Refer to BOM	Knurled captive knob	1
710	Refer to BOM	Adhesive feet	4
714	Refer to BOM	Black foam roll thickness 10mm, 107.5 +/- 2.5mm	2
42	Refer to BOM	Adhesive stop	2
713	Refer to BOM	Adhesive collar	2
16	Refer to BOM	Polyamide tubing 6X4(0.2)	1
45	Refer to BOM	Lower Housing	1
81	Refer to BOM	Cooling Fan with cable	1
82	Refer to BOM	ZINC-Plated Steel TCB Screw Hexalobe D3.0X25	2

Equipment:

- Kim wipes P/N 901731
- Isopropyl Alcohol, 901048
- Scissors
- 10077018, 4.4in-lb angle break torque with 11mm hex head
- 10077017, 8in-lb angle break torque with 13mm hex head
- 10025213, 4.4in-lb angle break torque with 16mm hex head
- 10029105, Polyamide Tube Prep tool
- Long nose Pliers
- 10025245, PB500 Nurse Call Socket Guide Fixture
- 3835100 Stop positioner lower enclosure
- 3834500 Collar Positioner
- Truarc Tool
- Torque driver set 4.4 in-lbs, Torx bit T10

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FAN INSTALLATION

1. Prior to commencing assembly, select the correct length tubing for assembly per BOM and place on assembly bench. Check each tube end for straightness; reject tubes that are not straight.
2. Obtain the lower housing (bln #45) & prior to commencing check for any cosmetic defects (MRB if required)
3. Position the fan (bln #81) with arrow pointing upwards (↑) and the fan power supply cable located on the inside of the housing.
4. Secure Fan using screws (bln #82), torqued to 4.4in-lb. As a check that the screws are fully torqued, verify that there is no gap between the head of the screw and the fan.

Note: Ensure lower housing is not damaged when fan is torqued into position. Rotate unit and inspect area where screws secure fan to housing and ensure no damage has occurred. If lower housing is damaged disassemble and move lower housing to MRB.

Caution: Assemble with the arrow pointing upwards (↑)

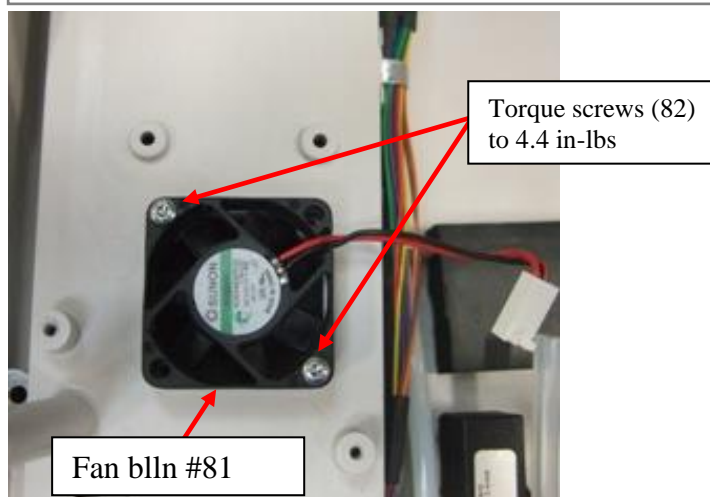


Fig 1

Fan bln #81

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SILICON STOPS, LABELS AND FEET ADDED TO LOWER ENCLOSURE

1. Using alcohol and wipes, clean the lower housing (cosmetic check) in any location where a label or foam/adhesive is applied
2. As each label is applied, apply pressure to ensure it is fully stuck to part. Check that there are no bubbles or cosmetic defects. Check with Quality Department if clarification required.
3. Attach 2 adhesive stops (bln #42) using tool 3835100 to the lower enclosure as per fig 2 of this section.

Attach silicon stops 42 as shown using tool 3835100 to align parts

Fig 2

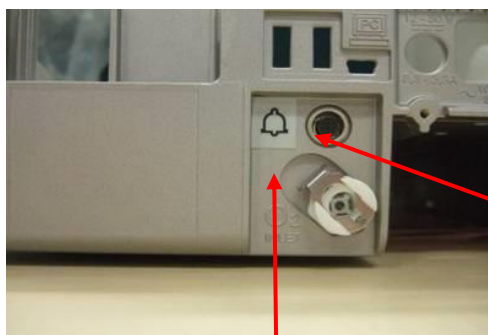


Fig 3



Attach 4 feet in location as shown

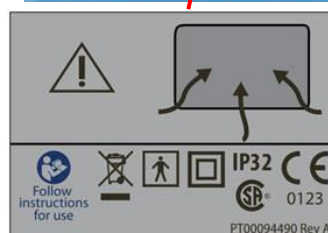
4. Attach the 4 feet (bln #710) in the location shown in Fig 3 of this section.
5. Attach the 'alarm piece' of the O2/RA/ label (bln #44) as shown below in fig 4.
6. Attach air inlet label (bln #73) to rear of unit as per Fig 5.
7. **PHR** - Record the revision of the labels (bln #44 & #73) onto DHR LOG 10038461.



Bln#44

Position the alarm piece of the O2/RA bln # 44 label as shown

Fig 4



Balloon #73

8. Attach the label (bln #72) to the inside of the lower housing. See fig 6 of this section.
9. **PHR** - Record the revision of the Electrostatic label (bln #72) onto DHR LOG 10038461.



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Add ESD label (B1ln #72) here. Take Revision from PB560 printed BOM.

Fig 6

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10. Use Fixture (P/N 10029105) fig 7 to 'flare' tubing to aid assembly.
Slowly slide tube (blln #16) over Flare pin, pushing tube onto pin as much as possible.
Remove tubing. Repeat for other side.

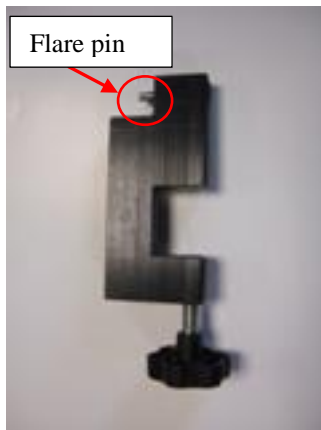


Fig 7

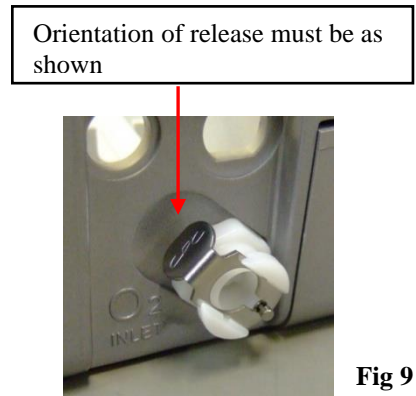
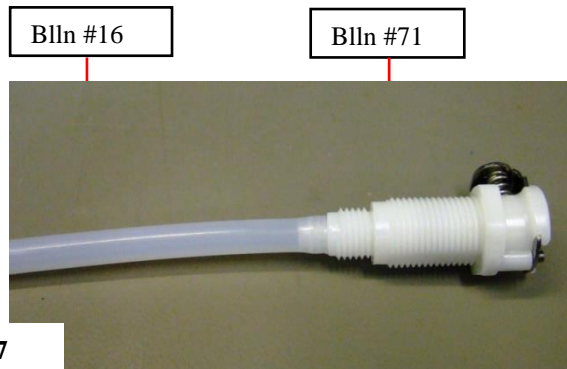


Fig 9

11. Attach tubing (blln #16) to oxygen connector (blln #71) ensuring that the tubing is pushed all the way in. See fig 8
12. Push the tubing from the rear of the enclosure, and mount the oxygen connector (blln #71) and loosely screw in hex nut but do not tighten. See Fig 9 and fig 10 of this section.

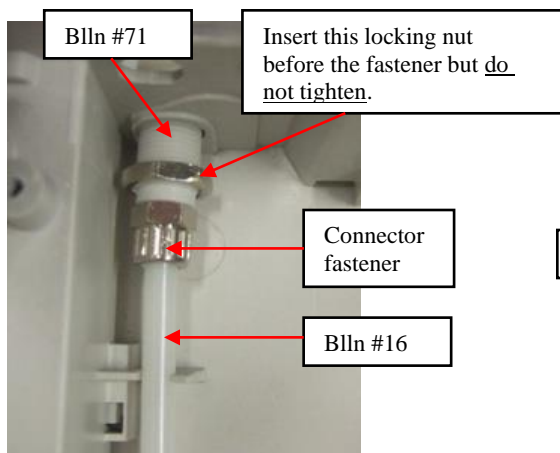


Fig 10

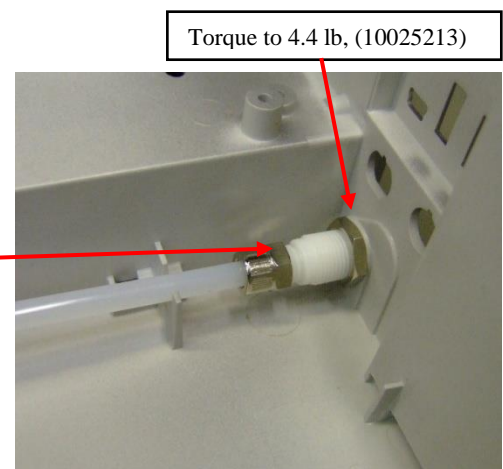


Fig 11

13. Secure the polyamide tubing using connector fastener and torque to 4.4lb using the angle torque breaker with 11mm hex head (10077018) see fig 10.
14. Tighten hex locking nut of oxygen connector to 4.4in-lb angle torque with 16mm head, 10025213. See fig 11.

Note: Ensure that during torquing that the torque hex head is not caught between nut and plastic – this could cause the angle torque to break before the torque specification is reached.

ATTACHING THE COLLARS

1. Attach 2 collars (blln #7.13) as shown in fig 2.
2. Use tool p/n 3834500. Position and attach the collars in location shown in fig 1 & 2 using the tool.

**Fig 1****Fig 2**

Caution: edges of collars can be sharp so handle with care. Use needle nose pliers when handling collars where possible.



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SOLENOID VALVE ASSEMBLY & ATTACHMENT OF PRODUCT SERIAL NUMBER

Materials:

Balloon Number	Part Number	Description	Qty
711	Refer to BOM	Label PB560 product	1
713	Refer to BOM	Adhesive collar	2
11	Refer to BOM	Silicone tubing 3.2x6.4	1 x 50mm
715	Refer to BOM	TCB Hexalobe Screws, D3 x 6	2
716	Refer to BOM	Countersunk screw hexalobe M3x8	2
717	Refer to BOM	Square support, O2 valve	1
718	Refer to BOM	2 Way O2 solenoid valve	1
720	Refer to BOM	Ty-wrap (Collier Insuloid)	1
16	Refer to BOM	Polyamide Tubing 6X4(0.2)	1
722	Refer to BOM	Polyester Label	1

Equipment:

- Ty-Wrap gun
- Kim wipes P/N 901731
- Isopropyl Alcohol, 901048
- Cutting pliers
- 4.4in-lb Torque driver
- 8.9 in-lb Torque driver
- Torx Bit T10
- 10025200 - O2 Solenoid Assembly Fixture, PB540

ATTACHING SOLENOID SUPPORT BRACKET

1. **PHR** - Record Serial Number and revision from Solenoid Valve (blln #718) on DHR LOG 10038461 (fig 1)

Record the number only; do not include forward slash or spaces.

E.g.

If the S/N on the solenoid is: **13/12 030/400** it is recorded as **1312030400**

The S/N location is outlined in fig 1.



Fig 1

Image is for reference only

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2. Place Solenoid valve into fixture (10025200) as shown in fig 2
3. Using a 4.4in-lb torque and T10 torx bit, secure O2 square support bracket (blln #717) to O2 solenoid valve (blln #718) using 2 screws (blln #715) as per fig 3 of this section. Check that screw is torqued fully by ensuring no gaps between screw, bracket or solenoid valve.

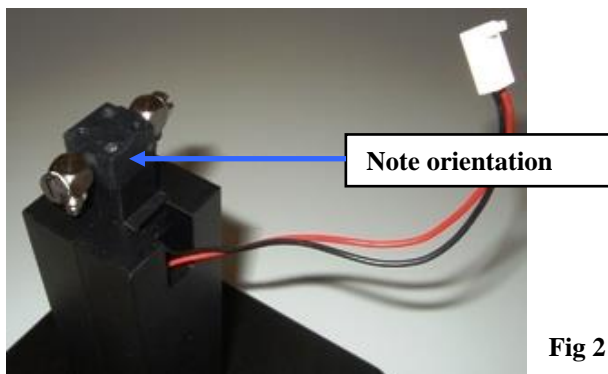


Fig 2

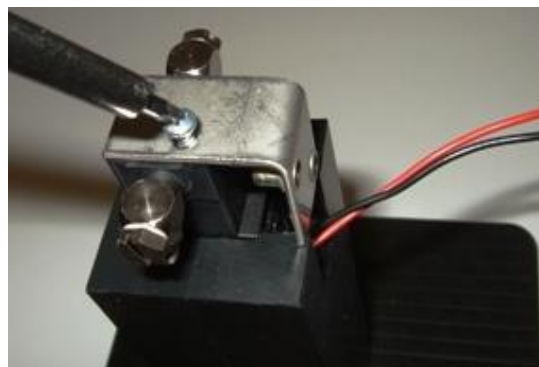


Fig 3

ATTACH TUBING TO CONNECTOR:

Note: Prior to commencing assembly, select the correct length tubing for the below assembly and place on assembly bench. Check each tube end for straightness; reject tubes which are not straight.

1. Remove fastner before attaching the silicon tubing (50mm) (blln #11) to the O2 valve port as per fig 4 of this section, ensuring that the tubing is pushed all the way in, and secure with ty-wrap (blln# 720) using ty-wrap gun see Fig. 4



Fi

2. Remove connector fastener from O2 solenoid valve, blln # 718.,fig 5



Fig 5



Fig 6

3. Slide on connector fastener over polyamide tube (16) as per fig 6.

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4. Attach the polyamide tube (16) from the O2 connector to the O2 Solenoid valve, ensuring that it is pushed all the way in, and secure with connector fastener. See fig 7. Ensure cap is fully tightened.
5. Secure O2 solenoid bracket to lower housing (bln #45) using two countersunk screws (bln #716), using a 4.4in-lb torque and T10 torx driver fig 8. Note: the screws are secured from the exterior side of the lower enclosure as per fig 8



Polyamide tube (16)
from O2 connector

Fig 7



Secure O2 valve to lower enclosure using 2 screws, (bln #716) torqued to 4.4in-lb on exterior side of enclosure

Fig 8

MOUNTING THE ALARM HARNESES

1. Alarm Repeater Harness location as shown in fig 1

Location for harness (blln# 75) on lower housing (blln#45)

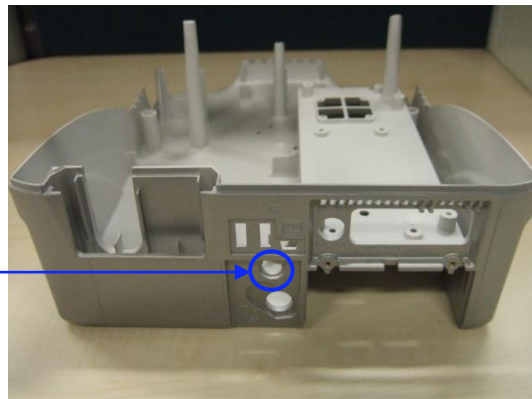


Fig 1

2. Remove the washer and nut from the alarm repeater harness, (blln #75) as per fig 2 & 3

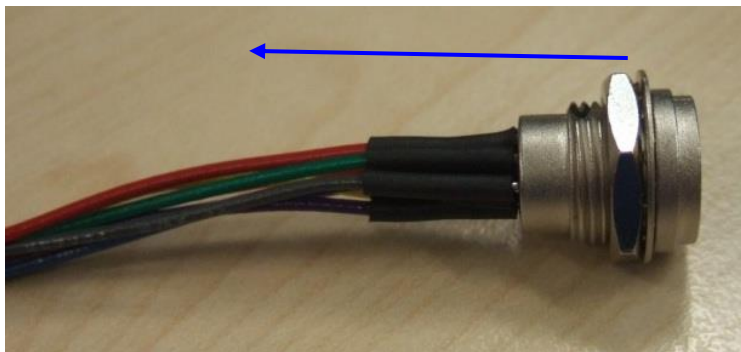


Fig 2



Fig 3

Note: PCBA connector must be orientated as per fig 4 to remove & replace the nut & washer.
Be careful not to damage wire during this operation



Fig 4

3. Feed the alarm repeater harness through the lower housing as per fig 5. Once the harness has been threaded through replace items previously removed; the washer first then the nut as per fig 6.



Fig 5



Fig 6

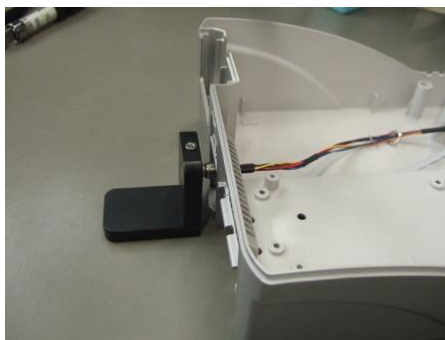
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4. Install the remote alarm connector as per fig 7 ensure the index key on the connector is mated correctly with the slot in the lower housing as per fig 8.

**Fig 7****Fig 8**

5. Once the remote alarm connector is correctly positioned, attach the remote alarm guide fixture 10025245(fig 9) as shown in fig 10, ensure the wide key of the connector head on the remote alarm guide fixture is as per fig 11.

Note: if the orientation of the connector head is not as per fig 11, contact the relevant line technician/engineer.

**Fig 9****Fig 10****Fig 11**

6. Once the remote alarm guide fixture is correctly positioned proceed to tighten the washer & nut to secure the alarm repeater harness, (blln#75) to the lower housing as per fig 12.

**Fig 12**

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7. Use 4.4in-lb angle break torque with 13mm hex head (10077017) to torque the nut correctly into position as per fig 13.

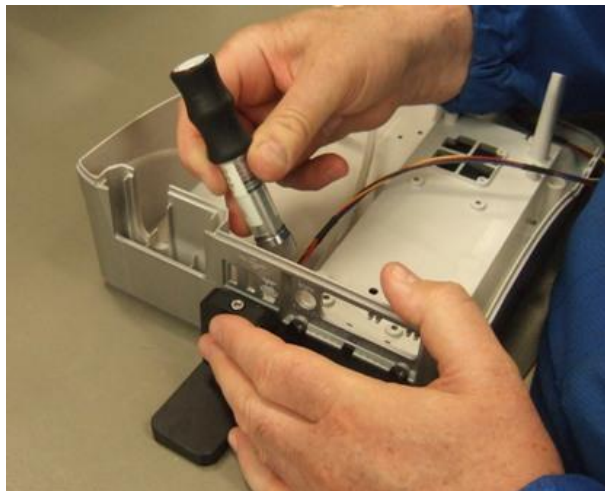


Fig 14



8. To release the guide fixture from the remote alarm socket (once the alarm repeater harness (bln#75) is successfully torqued into position) use a long nose pliers to deactivate the locking mechanism as per fig 14.

MOUNTING THE KNURLED KNOB

1. Mount the knurled knob (bln #79) by feeding it through the bottom of the lower housing as in fig 1.
2. Take the retaining ring (bln #78) and using the truarc tool, click the ring into the recess of the knurled knob, refer to Fig 2.

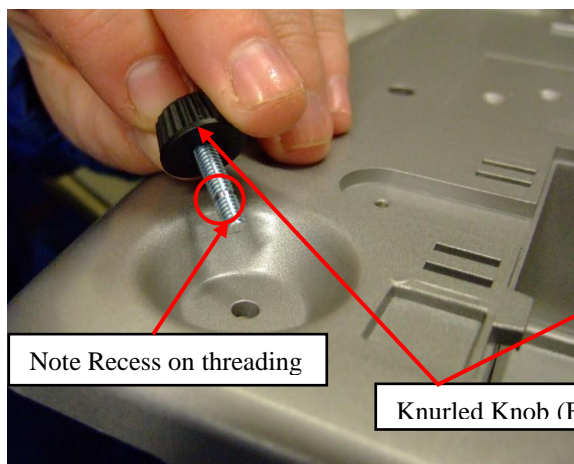


Fig 1

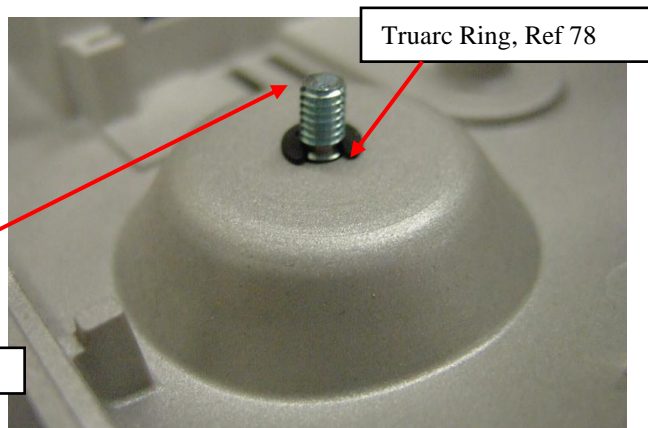


Fig 2



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ASSEMBLE THE SWITCH COVER



Caution: Take care when handling spring as there may be sharp edges on each end.



Materials:

Balloon Number	Part Number	Description	Qty
77	Refer to BOM	Switch cover	1
721	Refer to BOM	Cover Spring	1
726	Refer to BOM	Cylindrical Pin 2x28	1
74	Refer to BOM	PB500 Power Switch Cover Retainer	1
720	Refer to BOM	Cable Tie Wrap (Collier Insuloid)	1

PREPARATION OF THE SWITCH COVER:

1. Inspect for any cosmetic damage as per procedure G-AMFG-1814-00. Place any non-conforming part into MRB.
2. Assemble the Cover spring (blln#721) & Switch cover retainer (blln#74) as per fig 1.
3. Insert the pin (Blln #726) through the hole in one side of the cover (Blln #77) and slide it through the Cover spring (Blln #721) with the flat edge of the spring leaf on the outside as per fig 2



Fig 1



Fig 2

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MOUNT THE COVER ON THE HOUSING:

1. Take the spring cover assembly between your thumb and index as per fig 3 of this section
2. Slide your index finger under the supporting leaf and bring it to a 90° position, use your middle finger and thumb to support the switch cover in this position.



Fig 3

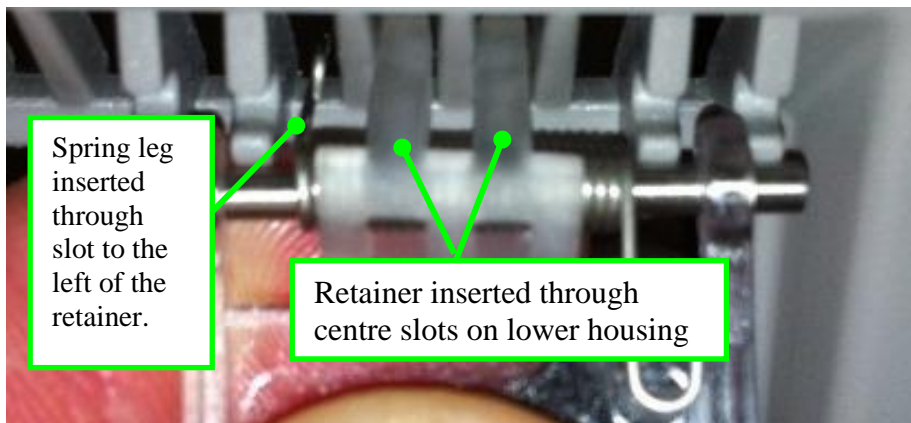


Fig 4

3. Assemble the switch cover assembly onto the rear of the lower housing as per fig 4 & 5

NOTE: Ensure that the switch cover is correctly assembled to the lower housing and take care to ensure that the pin & spring are centred with the slots on the lower housing.

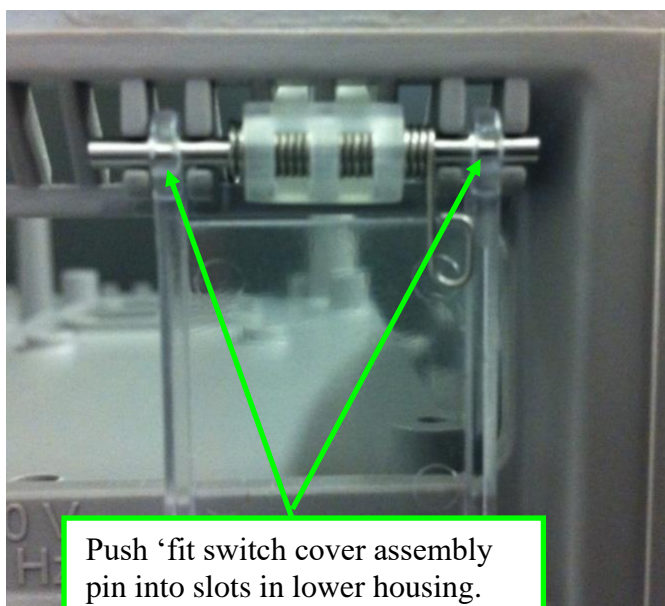
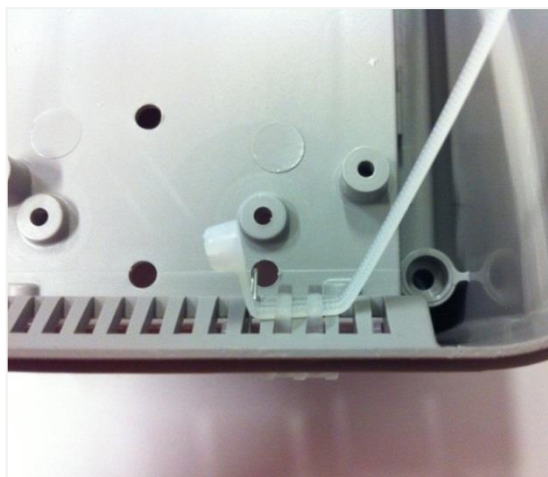


Fig 5

INSTRUCTIONS**Page 19 of 24****ATTACHING THE TIE WRAP TO SECURE SWITCH COVER ASSEMBLY:**

1. Ensure the retainer and spring leg are positioned as per fig 1
2. Insert the tie wrap (blln#720) as per fig 2, Pre-bend cable tie as shown in Fig. 2, this will prevent stress on the retainer when installed.
3. Secure the tie wrap as per fig 3, CAUTION – DO NOT OVER TIGHTEN
4. Remove excess tie wrap material after fully securing as per fig 4
5. Perform a final check to ensure the switch cover is correctly attached as per fig 4 & 5.

**Fig 1****Fig 2****Fig 3****Fig 4****Fig 5**

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CLAMP & FERRITE ATTACHMENT:

Materials

Balloon Number	Part Number	Description	Qty
713	Refer to BOM	Adhesive collar	1
16	Refer to BOM	Polyamide Tubing 6X4(0.2)	1
724	Refer to BOM	Ferrite	1
725	Refer to BOM	Double sided tape	25mm

Equipment

- Scissors

- Clamp the tubing (bln #16) to the lower collar (bln #713) and the Alarm cable in the upper collar (bln #713) as per fig 1 of this section. The collar claws should be closed with only a slight overlap.

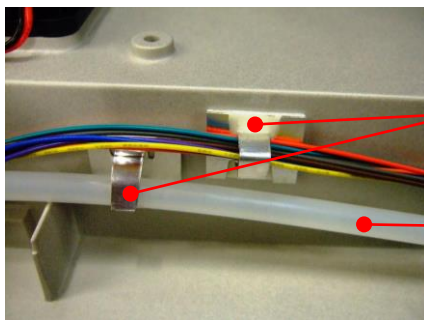


Fig 1

NOTE: Ensure no excessive pressure on cable / tubing collars

Polyamide tubing (bln #16) length 200mm prepared in tube cutting

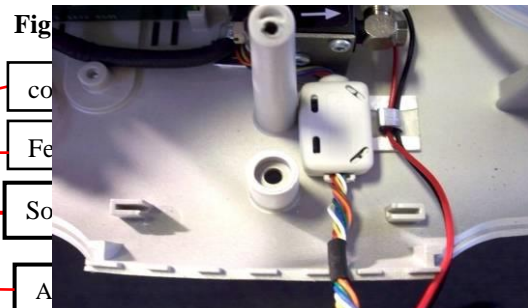
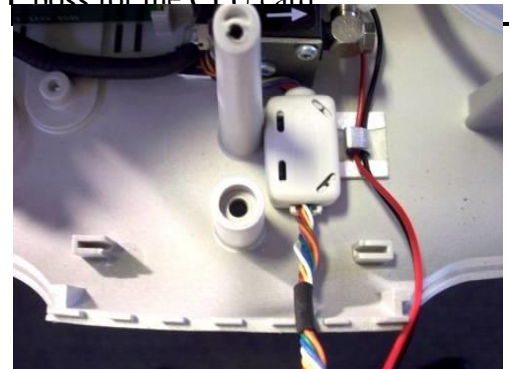


Fig 3

Align the back of the collar with the boss for the CPU card



- Attach Ferrite (bln #724). Using a calibrated ruler and scissors, cut 25 mm of double sided tape (bln #725), attach to underside of ferrite. Route alarm cable through open ferrite as shown in Fig.2, twisting the cable sufficiently to sit freely in ferrite. Clamp by closing ferrite and place in position on unit as shown in Fig 2 & 3.

- Attach the other collar (bln #713) as shown on fig 4, route solenoid cable through as per fig 2.

Note: Leave O2 cable loosely left as in fig 4, i.e. with only little of the cable pulled through the collar. This is to facilitate assembly later in the process and **avoid the wires becoming pinched**.



Fig 4



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LOWER HOUSING

Materials:

Balloon Number	Part Number	Description	Qty
83	Refer to BOM	Battery Connection Card	1
84	Refer to BOM	Power Supply Board- Tantalun	1
85	Refer to BOM	Screw TCB 3.5 x 8 hexalobe	5
86	Refer to BOM	Stop Connection Card	1

Equipment:

Torx bit T10

Torque driver set 4.4 in-lbs



Note: Observe all ESD Precautions

Process:

- Check that threaded caps are fully fitted on both ends of the polyamide tube (from solenoid valve to O2 connection end).

BATTERY CONNECTION CARD & POWER SUPPLY BOARD INSTALLATION

- Move the harness to the side, as the Power Supply Board will be placed above it.
- PHR** - Record Serial Number and revision of the Battery Connection Card (bln #83) on DHR 10038461. Scan yellow "Station 1" barcode chart and then scan component S/N to generate 1 S/N Label for DHR. See fig 1

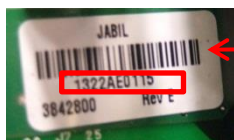


Fig 1

Record S/N from label

Image is for reference only

- Place the Connection Card (bln #83) in its position, as shown in fig 2 below
- Fasten the Connection Card Stop (bln #86) with a screw (bln # 85), torquing to 4.4lbs. (Fig 2). As a check that the stop card is fully secured, verify that there is no gap between the screw head and the stop card, or between the stop card and the lower housing.



Fig 2

Torque to
4.4lbs

INSTRUCTIONS

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5. **PHR** - Record Serial Number and revision of the Power Supply Board on DHR 10038461 (blln#84). Scan yellow "Station 1" barcode chart and then scan component S/N to generate 1 S/N Label for DHR. Fig 3

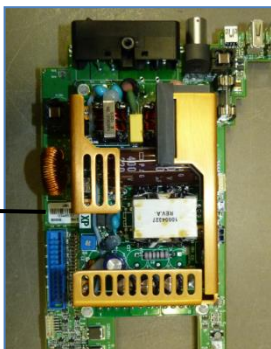
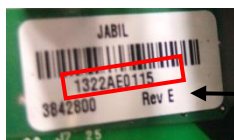


Fig 3

Location of label on power supply board(blln#84) containing requested information

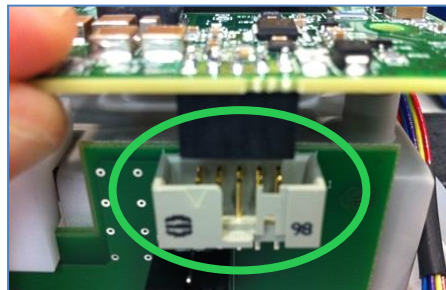


Fig 4

Ensure male pins from battery connection card are correctly installed to female connector on power management PCBA

6. Insert the rear of the Power Supply Board (blln#84) (i.e USB & DC connector end) into the lower enclosure cut out before lining up the pins of the male connector and inserting into the female connector of the connection card, fig 4 (Note: Ensure connections are fully pushed home)
7. Connect the fan cable as per fig 5 and ensure the cables are correctly routed through the fan housing and over the power supply board. Also ensure the clip is correctly secured.
8. Push the fan cable through the window, over the power supply board (blln#84) with connection on the outside. Connect the fan wiring to the power supply board, ensure that the connection is fully secured.

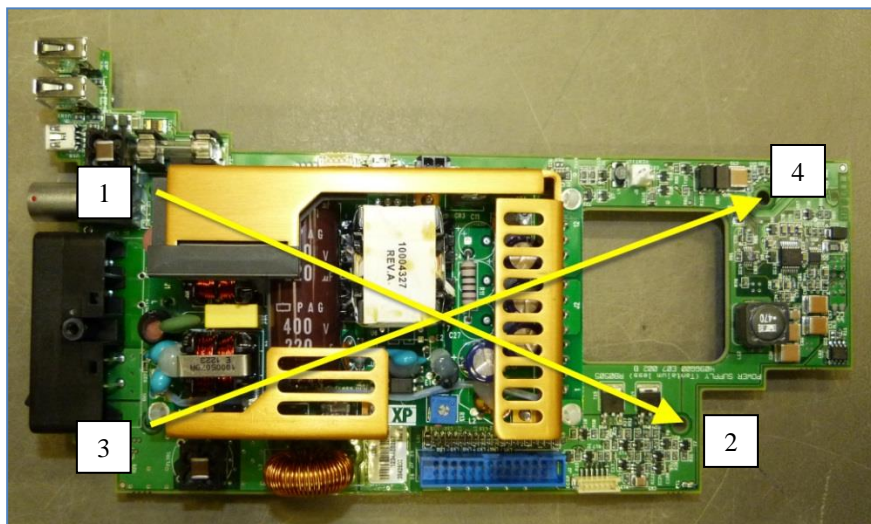
Correct routing



Ensure clip is correctly secured

Fig 5

9. Fasten the power supply board (bln #84) with 4 screws (bln #85), torquing to 4.4lbs in a diagonal sequence Fig 6. As a check that the power supply is fully secured, verify that there is no gap between the screw head and the power supply board.



with 4 screws bln# 85,
sequence

Fig 6

10. Ensure that switch SW2 is in the correct position as illustrated in fig 7



Ensure that switch SW2
is in the correct position

Fig 7

11. Place foam strips (blln# 714) in the housing as shown in fig 8.

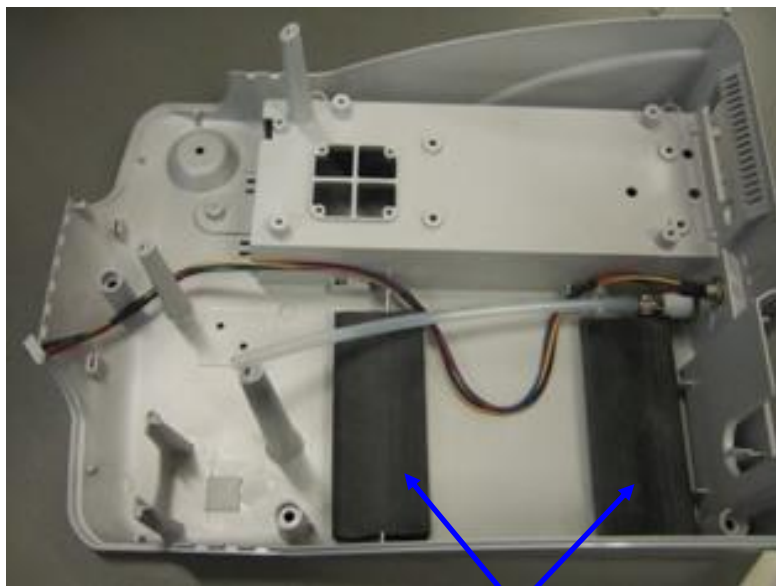
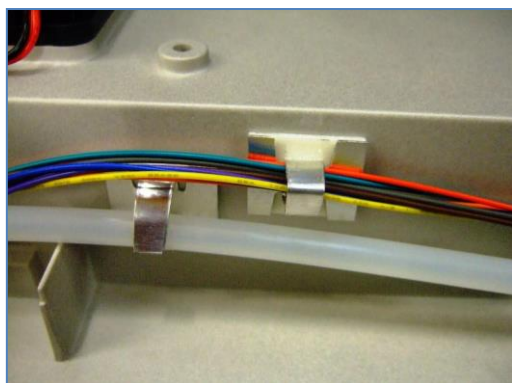


Fig 8

Blln #714 x 2

12. Ensure no excessive pressure on cable / tubing collars



Ensure no excessive
pressure on cable /
tubing collars

Fig 9

DHR 10038461

1. Before moving unit to next stage, ensure that all applicable sections of DHR 10038461 are completed.
2. Sign & date DHR.