

Title: XXXXXXXXXXXXXXXX		Number: 600-1186	Revision: J	Type: MPI	Page 1 of 10
Responsible Department:					
Initiator: XXXXXXXXXXXXXXXX	ECN: 6416	Date Approved: 09/04/07	Date Issued: 09/07/07	Date Effective: 09/12/07	

EQUIPMENT



Microscope and light



Razor blades



Lint free wipes



Gloves



Alcohol (70%)



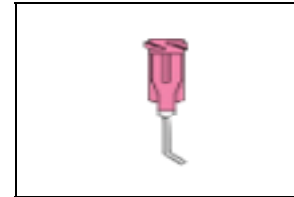
Acticure 4000



EDF Dispenser



510-1406 Go/No Go
Gauge, Obturator
Release Rod



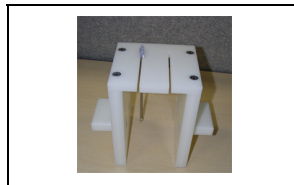
Pink or Green Tip



Loctite 4304



510-1395 Obturator
Release Rod UV Bonding



500-0367 StarClose
Release Rod Assembly
Rack

■ Setup

■ Assembly

■ Reprocessing

■ Verification

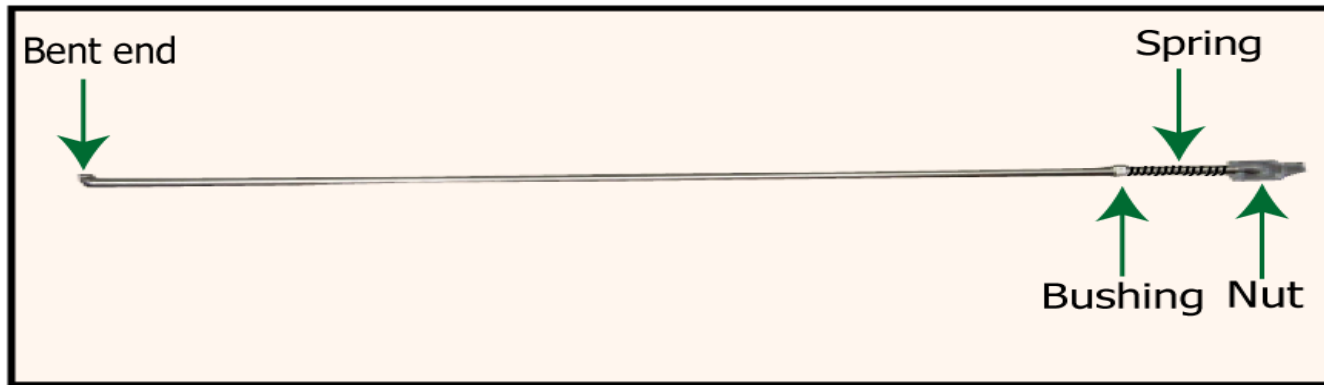
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1**

Change gloves before starting procedure.



1

Place the Bushing, Spring, and Nut over the rod. Place assembly into Obturator Release Rod UV Bonding Fixture holding plate.



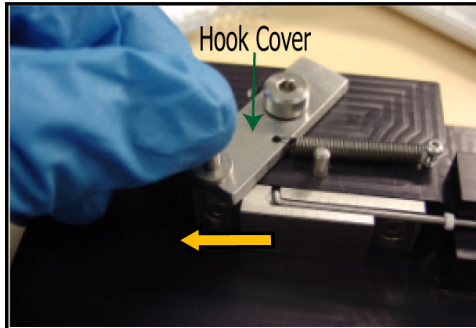
■ Setup

■ Assembly

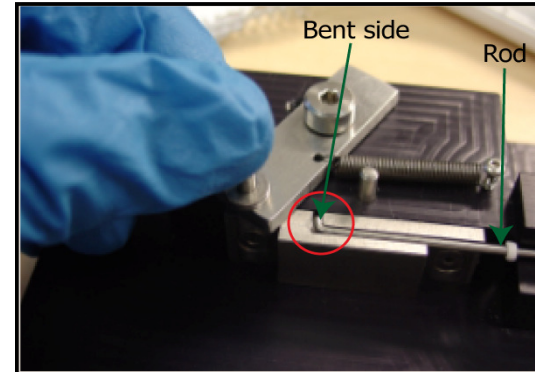
■ Reprocessing

■ Verification

2 Open Hook Cover by pulling handle left.

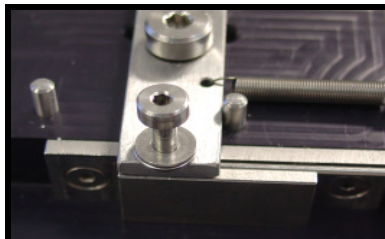


3 Place Release Rod in slot, bent end towards fixture.

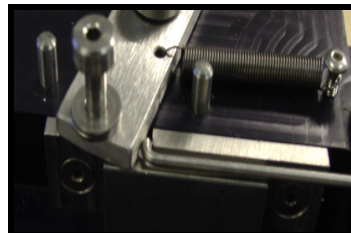


4 Release Hook Cover over the Bent End to hold Release Rod in place.

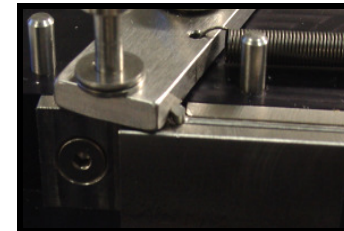
ACCEPTABLE



UNACCEPTABLE



UNACCEPTABLE



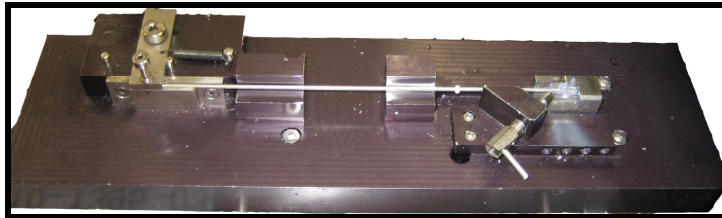
■ Setup

■ Assembly

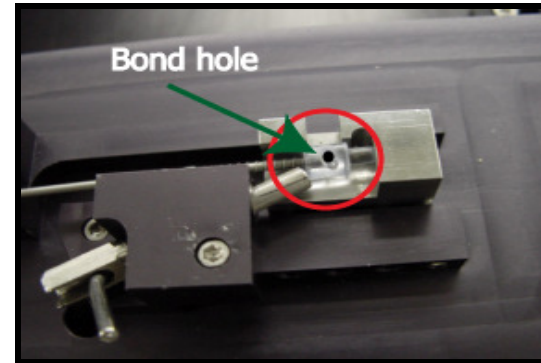
■ Reprocessing

■ Verification

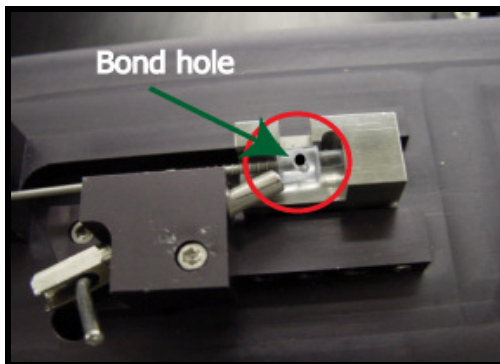
5 Verify: Release Rod must be properly placed into fixture, as shown:



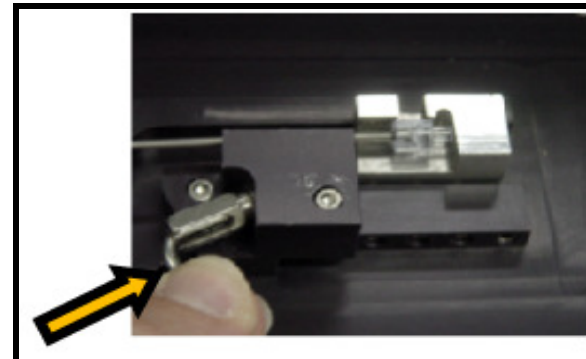
6 Position top of Obturator Nut against the front of the fixture.



7 Bond Hole should be facing up.



8 Release lever to secure nut.





Setup



Assembly



Reprocessing



Verification

9

Place needle tip at bottom of fill hole.



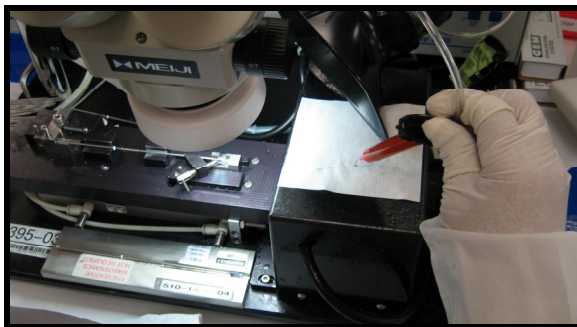
10

Inject Fill Hole with Loctite 4304. **Do not move nut or rod until Loctite is cured.**



11

Use lint free wipe to remove excess adhesive from the needle tip.



12

Use microscope to verify Loctite wicks to the rod.





Setup



Assembly



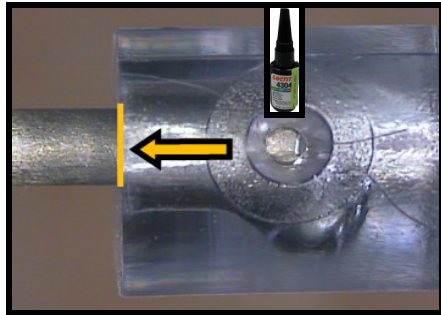
Reprocessing



Verification

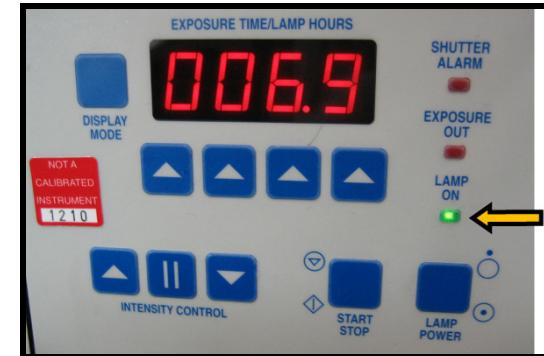
13

Inject more adhesive if Loctite doesn't wick to end of Nut.



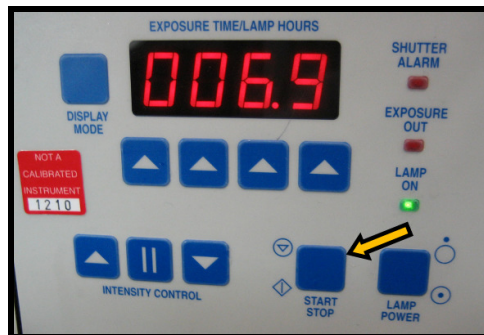
14

Ensure EXFO Lamp light is ON.



15

Press and hold Start Stop button if light is OFF.



16

Shutter Alarm light will stop blinking when UV lamp is ready.



■ Setup

■ Assembly

■ Reprocessing

■ Verification

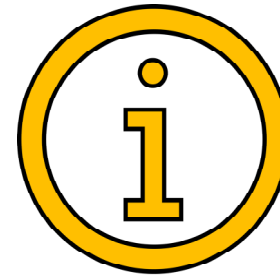
17

Press Start button to slide assembly into UV chamber.



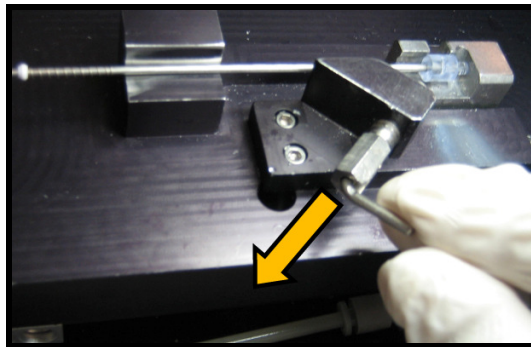
18

When complete, assembly will slide back out of UV chamber.



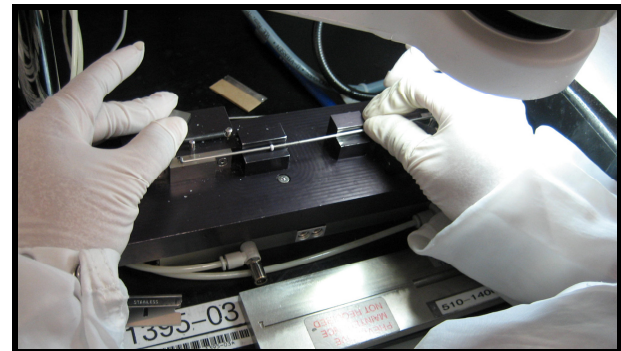
19

Pull the clamp away to release the nut.



20

Open the Hook Cover over Bent End and remove Rod.





Setup



Assembly



Reprocessing



Verification

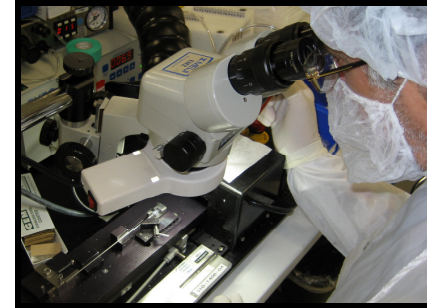
21

DO NOT REMOVE ROD WITHOUT
RELEASING CLAMP AND OPENING HOOK
COVER.



22

Check joint for excessive adhesive.



23

Remove any extra adhesive with razor
blade.



24

Use Go/No Go Gauge to verify length.



■ Setup

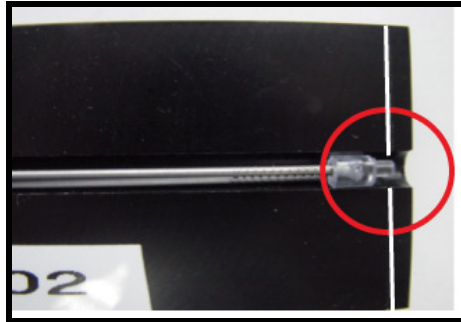
■ Assembly

■ Reprocessing

■ Verification

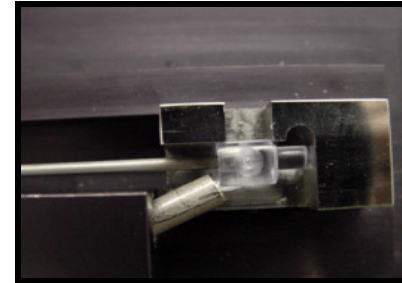
25

Tip of nut **must** meet the 2 lines at the edge.



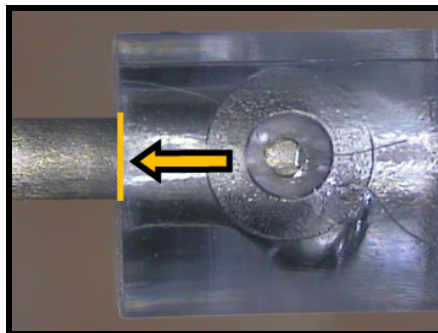
26

Check that cut-out portion of Release Rod Nut is centered with Bent End of Rod.



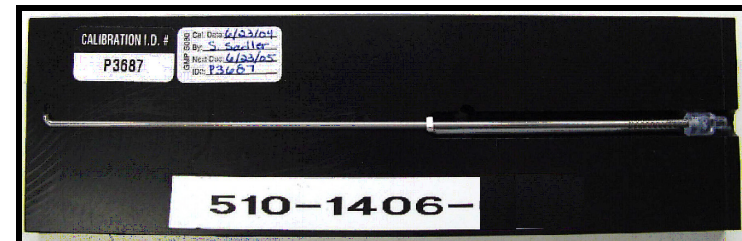
27

Check for excessive adhesive between Pull Rod and Release Rod Nut.



28

Re-check length of Release Rod with Go/No Go Gauge.



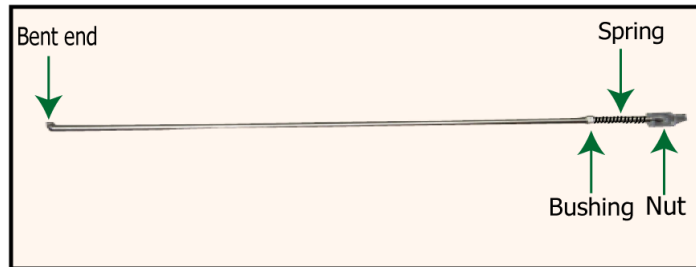
■ Setup

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■ Reprocessing

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29 Check Spring is loaded over Release Rod.
Bushing slides free over Release Rod.



30 Place finished Release Rod on
Assembly Rack.

