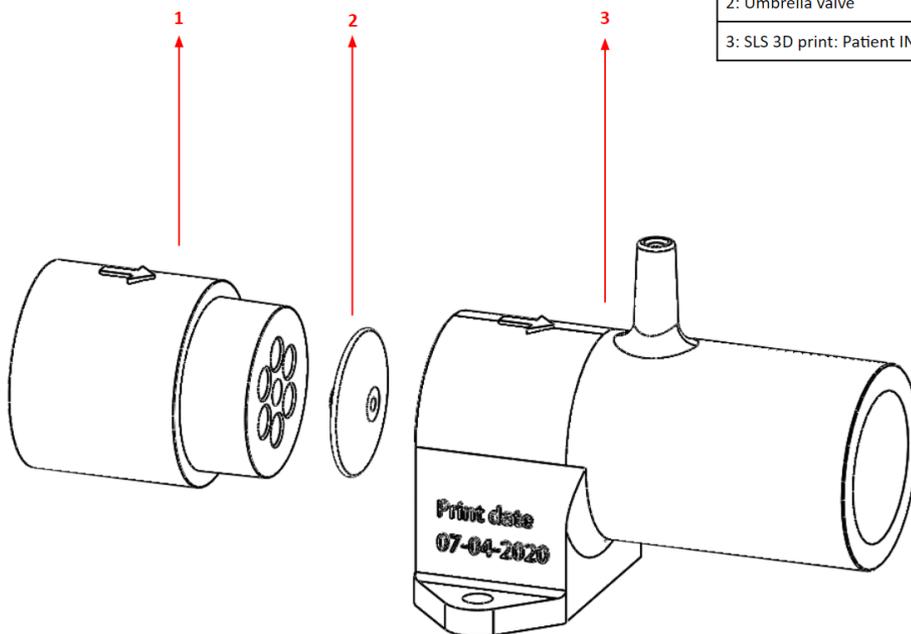


	Work Instruction:
	Release Date 27-04-2020
	Rev Work Instruction V1.3
	Page
<b>TITLE: SUB-ASSEMBLY #4B – Inspiratory track (3D block to tube mounting)</b>	

Revision	Date	Modifications	Author
V1.0	08-04-2020	Setup First Version	Guusje Jans
V1.1	13-04-2020	Images and elaboration	Jeroen Roest/ Bart Spel
V1.2	16-04-2020	Materials overview	Jeroen Roest/ Bart Spel
V1.3	27-04-2020	Translation from Dutch to English	Karin Olthof

This subassembly describes the assembly of the mixing chamber and the inspiratory 3D printed-complex. This assembly together with subassembly 4A forms the inspiratory part. The Swagelok components that are used in every step are named explicitly to ensure correct component placement.

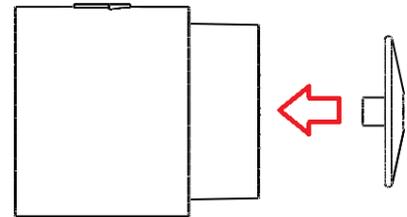
Part	Supplier	Quantity
1. SLS 3D print: Check valve mount	Shell	1
2: Umbrella valve	Minivalve	1
3: SLS 3D print: Patient IN	Shell	1



	Work Instruction:
	Release Date 27-04-2020
	Rev Work Instruction V1.3
	Page

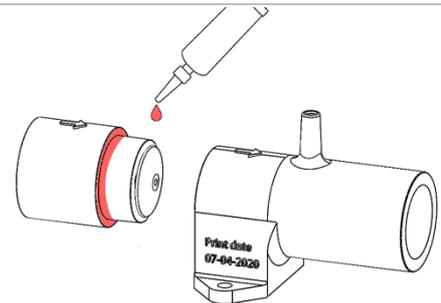
**TITLE: SUB-ASSEMBLY #4B – Inspiratory track (3D block to tube mounting)**

1.
  - The inspiratory 3D complex consists of two parts: Patient IN and check valve mount.
  - The umbrella valve has a protruding part which should be attached to the smallest part of the 3D-complex (see figure 1).

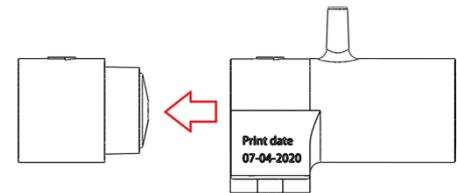


(1)

2.
  - The two parts should be connected manually. Dimensions of the parts play a decisive role in a good fitting of the parts (see figure 2.1).
  - To ensure a good connection, the use of biocompatible glue is necessary (Loctite 4601).
    - Apply a thin layer of glue as described in figure 2.2.



(2.1)



(2.2)

3.
  - On the protruding parts of the inspiratory 3D complex, a tube (6 mm) should be attached. This can be difficult, but has to be done with care.

	Work Instruction:	
	Release Date	27-04-2020
	Rev Work Instruction	V1.3
	Page	

**TITLE: SUB-ASSEMBLY #4B – Inspiratory track (3D block to tube mounting)**

If executed correctly, the subassembly should look as can be seen in the figures below.

