

General instruction for welding Charter Medical FP-FLEX™ (1/4" OD X 1/8" ID) tubing to C-Flex® 374(1/4" OD X 1/8" ID) tubing using the Terumo SCD® IIB Sterile Tube Welder

1. Turn on the Terumo SCD® IIB welder and ensure the welding jaws are aligned by pressing the check mark indicator on the device per the manufacturer instructions.
2. Open the clamps to the welding jaws.
3. Insert the FP-FLEX™ tubing and C-Flex™ tubing respectively into the welding jaws (see image 1).
 - a. Inserting FP-FLEX™ tubing into the jaws does require any different handling when compared to loading C-Flex®.
4. Press firmly on both to ensure the tubes are completely inserted and then close clamps to secure.
5. Initiate the welding process and continue the welding process per the manufacturer instructions.
6. Once lights go out on the unit, open the clamps to the jaws to remove the tubing (see image 2).
7. Roll the welded junction of the tubing to open the welded section (see images 3 – 4).
 - a. Note that you may not hear the typical "popping" sound associated with C-Flex® to C-Flex® welded junctions, but this does not indicate the weld failed or didn't open.
 - b. Given the differences in the tubing materials, we recommend waiting a few seconds longer (e.g. 5-10 seconds) compared to normal before rolling FP-FLEX™ to C-Flex® welds to aid in rolling and opening of the welded junction.



Image 1 – Tube Loading



Image 2 – Weld Complete

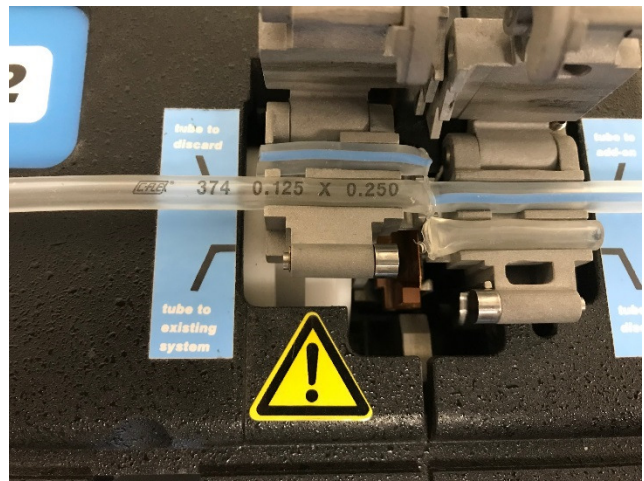


Image 3 – Before Rolling (Closed)

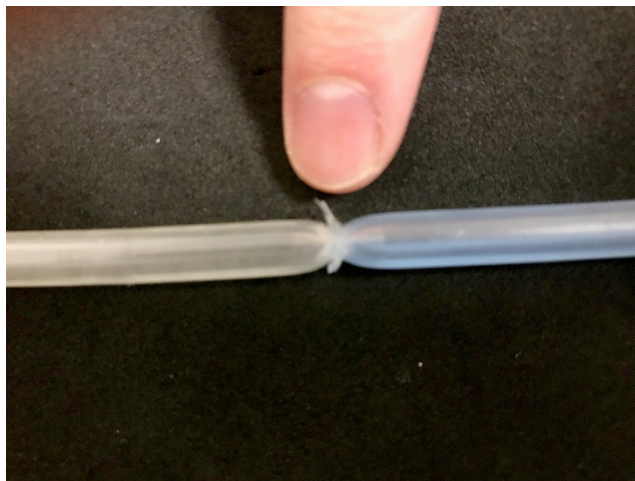


Image 3 – After Rolling (Open)

