VANDAGRAPH SENSOR TECHNOLOGIES

Company OPERATING PROCEDURE

Oxygen Sensor manufacture

R-33VAN-4 Sensor

VM3/COP/40.47

Date: 30-Sep-03	Revision Date: 17-Aug-12	Issue 1

Only to be attempted by trained personel

Used in Analox 101D2 analyser

This sensor is basically an R-33VAN with a cable 1.2mtrs long terminating in a 3.5mm Jack plug. The easiest method is to have an original and replace the sensor part To do this the Top is carefully removed. The sensor can be pushed out by pressing a round abject up the Case funnel. Unsolder the wires and replace the sensor. Re-assemble and test

Parts Required for New version			
Quantity	**Description**	**Part No.**	
1	R33S1	0110214	
1	R-17 Top		
1	R-33VAN Body	9720200	
1	O ring VIT-0130 10-274	9730201	
1	Cable tie	9711018	
1	Co-ax cable 1.2 mtr long not critical .To fit grommet.		
1	Tini Jack 3.5mm plastic cover	9071007	
1	Grommet 6mm	9040031	
1	Sensor Serial number label		
1	Serial number Label for Outer bag		
1	Polythene Bag (outer)		
1	Gas Barrier bag		

Warning Use Soldering Iron set at 400C Do Not overheat the PCB on the Sensor

Method.

1. Fit a grommet into the R-17 Top.
2. Remove the molex and wires from the R-33S1 sensor
3. Strip the co-ax cable pass through the grommet and solder to the sensor. Screen to RED insulated wire to Black
4. Strip the other end of the 1.2mtr co-ax cable and solder the Insulated core to the centre pin and the screen to the screen.
5. Carefully fit the cap and glue into position.
6. Test for the correct out put 25mV +/- 2mV
7. Tip of Jack is -ve Screen is +ve
8. Relabel the sensor and test