

VANDAGRAPH COMPANY OPERATING PROCEDURE		
Gas Pump Box for use with internal sensor VM3/COP/40.49		
Date: 30-Sep-03	Revision Date: 9-May-14	Issue 1
<u>Only to be attempted by trained personel</u>		

Parts Required			
Quantity	Description	Part No.	
1	Drilling Former Top of Case		
1	Drilling Former Side of Case		
1	Drilling Former Chassis insertTop of Case		
1	Enclosure 126.5x3.75 cm Black	9090012	
1	Batt Holder 3xAA (pp3 conn)	9060014	
1	Micro pump Thomas		
1	Pump housing chassis plate insert		
2	M3 x 8 Pozi Pan A2		
2	M2 x 8 Pozi Pan A2		
2	M2 Full nuts ZC		
2	M3 Full nuts ZC		
2	M3 SPG Washer		
2	Tie wraps	7930031	
1	Switch Yellow		
1	Switch waterproof kit		
1	10 cms Red wire		
1	Sensor Clip nylon 6/6 Blk	9040020	
1	Luer fitting		
1	Flow divertor adapter Black		
1	Straight fitting 2.4mm x 1.6mm N220/210-1		
1	Elbow fitting 2.4mm x 1.6mm L220/210-1		
2	M3 x 8 Slotted Cheese Head A2		
2	M3 x 8 P.Pan machine screw ZC		
2	Self adhesive foam 2cmx x 6.5cms		

Procedure

1. Drill the Chassis Insert using the Master as a guide.
2. Assemble the Battery box with Ms CS screws and battery cable
3. Fix the pump with M2 screws
4. Using Master template drill the hole in the centre of the case
5. Open up using the rotobore 13mm 9041018
6. This hole needs a small groove for the switch locating lug.
7. Drill top pilot hole and open up with taper drill to allow the Flow divertor adapter to fit.
8. Fit the switch and waterproof assembly
9. Fit the Flow divertor adapter and araldite into position
10. Fit the sensor clip with M3 ch screws
11. Fix the adhesive foam strips to the underside of the chassis insert.
12. Tie wrap the Black and Red battery leads

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13. Solder the black wire to the pump
14. Using the box side template mark the holes required
15. The centre hole is 5mm to fit the Luer fitting
16. The right hand hole is 6.5mm to take the Jack socket
17. The left hand hole is 2mm and is used to exhaust the gas from the box.