

## Production procedure for 0110238 Oxygen sensor (R-22AT)

Parts list		
Qty	Description	Part No.
1	Oxygen sensor - Automotive R-22AV	0110132
1	2 pin Molex connector	
2	Molex pin	
1	Sensor adapter	
1	Sensor label	

Tool list	
Soldering iron	
Wire cutters	
Stanley knife	
Sensor cap removal tool	
Super glue (Loctite 435)	

- 1) Remove the sensor from the sealed protective bag.



- 2) Remove the top cap from the sensor.



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- 3) Remove the white plastic surround from the Molex connector.



- 4) Using a soldering iron and pliers, remove the pins.

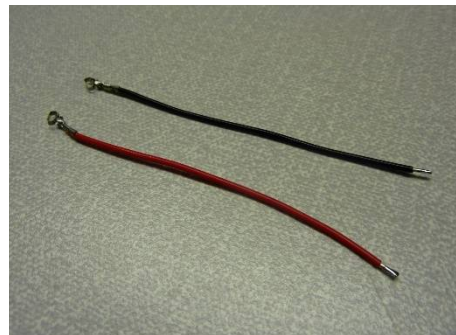


- 5) Cut lengths of black and red wire to 75mm.

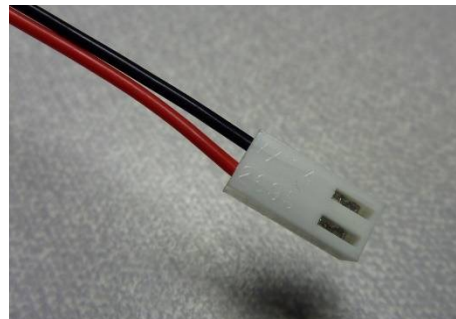
- 6) Strip 3mm from each end of each wire.

- 7) Tin one end of each wire.

- 8) Apply a Molex crimp pin to the non-tinned wire.



- 9) Insert the wires, as shown, into the Molex connector.

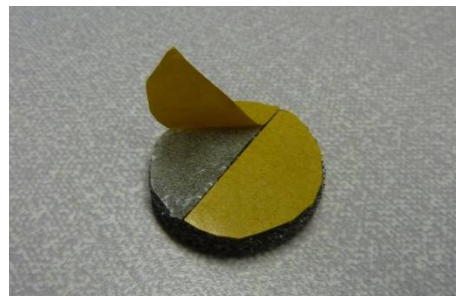


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- 10) Solder the wires to the solder points as shown.



- 11) Prepare the foam cap by placing double sided sticky tape to one side.

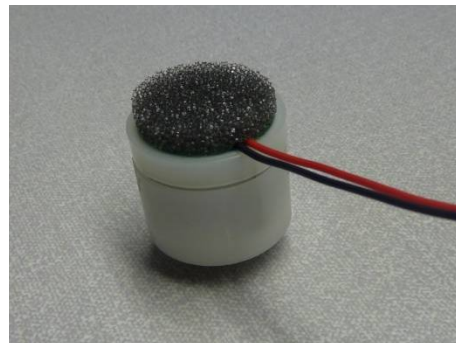


- 12) Peel away the backing from the double sided sticky tape.

- 13) Place the foam cap, sticky side down, onto the top of the sensor and gently press into place.



- 14) Noting the serial number, remove the sensor label.



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15) Apply the new label, ensuring that the serial number matches the one previously removed.



16) Remove the black O ring.



17) Place a drop of super glue onto the thread.



18) Attach the sensor adapter to the sensor thread.



19) Place the O ring over the sensor adapter thread.

20) The sensor is now ready for testing.

