

Revision date: 20-Jun-17

VM3COP37.54 0110436 Maxtec Oxygen Sensor Production Procedure

Tools required:

Description:

Soldering iron
Long nose pliers
Small vice
Wire cutters

Parts list:

Part number:

0110432
0131525
0131526
0032310

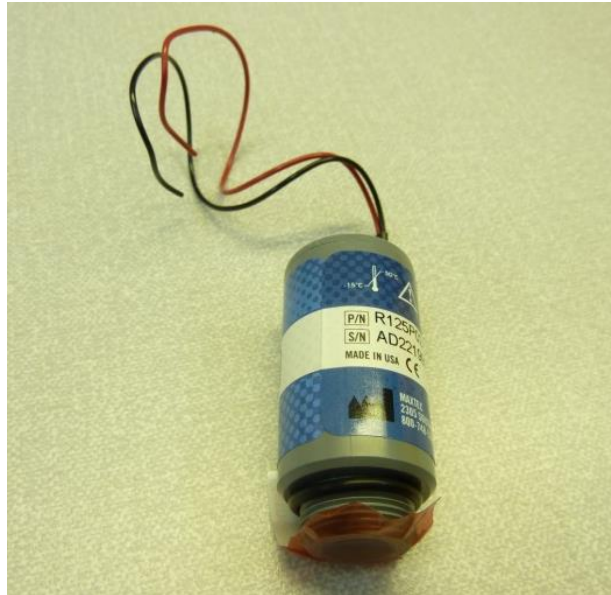
Description:

Oxygen sensor MAX-250B
Connector 2 pole black socket 1mm
Connector hood black
Heat shrink tubing – black 1.6mm

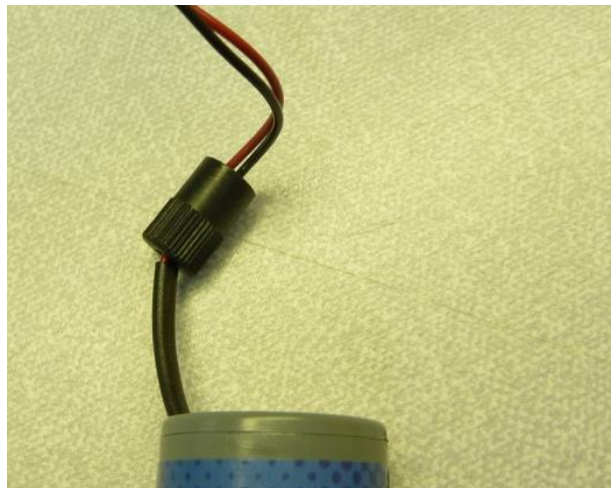


Revision date: 20-Jun-17

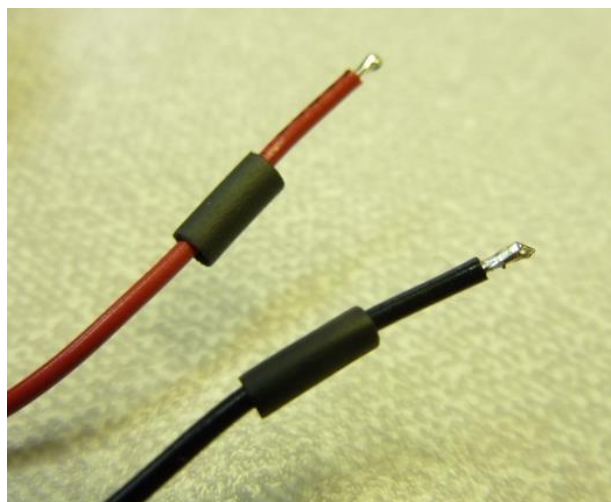
- 1) Remove the sensor from the outer packaging.



- 2) Place the connector hood over both sensor wires.



- 3) Strip and tin 2mm of each wire. Place 5mm of 1.6mm heat shrink over each wire.

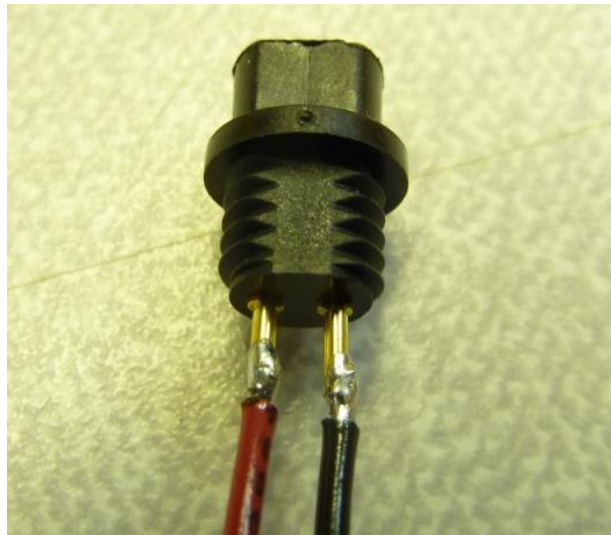


Revision date: 20-Jun-17

- 4) Apply solder to the connector pins.



- 5) Solder the wires to the connector pins.



- 6) Cover the pins with the heat shrink. Shrink the tubing leaving none of the pin exposed.



Revision date: 20-Jun-17

- 7) Screw the connector hood to the connector. If the wires are not compact enough then there may be resistance when tightening the hood, this can cause the pins to bend.



- 8) Affix a serial number label to the sensor.

The sensor is now ready for QA.

