

VM3COP40.72 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.



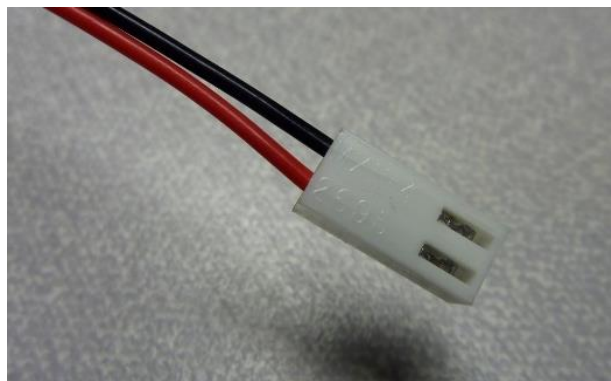
- 3) Remove the white plastic surround from the Molex connector.



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



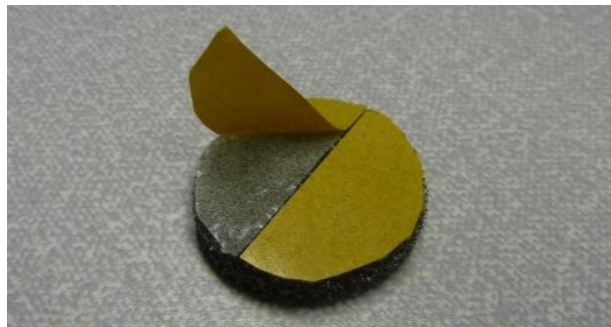
- 5) Cut lengths of black and red wire to 75mm.
- 6) Strip 3mm from each end of each wire.
- 7) Tin one end of each wire.
- 8) Apply a Molex crimp pin to the non-tinned wire.
- 9) Insert the wires, as shown, into the Molex connector.



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



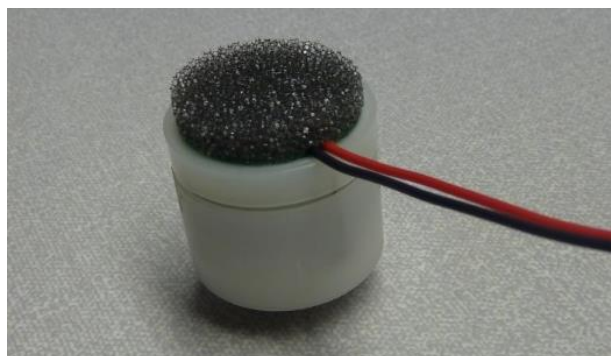
- 11) Prepare the foam cap by placing double sided sticky tape to one side.
12) Peel away the backing from the double sided sticky tape.



- 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.



Revision date: 18-Dec-17

- 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.



Revision date: 18-Dec-17

- 19) Place the O ring over the sensor adapter thread.
- 20) The sensor is now ready for testing.

