

VANDAGRAPH COMPANY OPERATING PROCEDURE		
Oxygen Sensor manufacture		
Modification of Sensor case		
VM3/COP/40.11		
Date: 30-Sep-03	Revision Date: 4-Jul-11	Issue 1
<u>Only to be attempted by trained personel</u>		

Parts Required			
Quantity	Description	Part No.	
1	R22 Any version can be used but R-22D is preferred		

Method.

1. Open the packaging and remove the O₂ sensor
2. Check the O₂ sensor for damage and signs of leaking electrolyte.
3. Remove the O₂ sensor specification leaflet and discard.
4. Remove excess outer case unto level of PCB.



- a. Insert Flow divertor into the Drill chuck
There is a brass equivalent to the flow divertor
- b. Screw the sensor onto the Flow divertor
- c. Switch on the drill and ensure the sensor rotates vertically and evenly
- d. Switch off the drill



- e. Lower the chuck so that the top of the vice jaws are level with the top of the PCB
- f. The chuck jaws should not grip the sensor. They are used as a guide only and prevent any lateral movement during removal



- g. Switch on the drill
- h. Using a sharp blade gently apply pressure just above the PCB until the casing parts
- i. Ensure the PCB is still attached to the housing
- j. If it has parted glue back together

