

## COMPANY OPERATING PROCEDURE

### R-33VAN Assembly VM3/COP/40.31

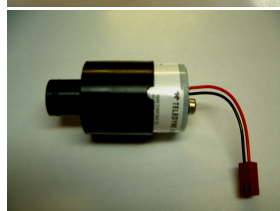
Date: 30-Sep-03

Revision Date: 7-Apr-11

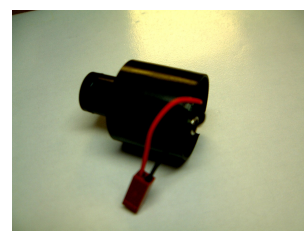
Issue: 1

#### Parts Required

Quantity	Description	Part No.	
1	R33D Sensor		
1	Sensor Body enclosure		
1	"O" Ring	097711003	
1	White Box & Lid		
1	Packing Material		
1	White "Washer" Label		
1	Round "Vandagraph" Label		
2	Serial number Labels		
1	Serial number Label for Outer bag		
1	Polythene Bag (outer)		



- 1.0 Insert the "O" ring into the groove on the Sensor body – DO NOT use any grease, as the product must be Oxygen clean.
- 2.0 Remove the R33D Sensor from the Gas barrier bag, and carefully insert it into the Sensor body so that the wires can be bent to meet one of the two grooves.
- 3.0 Ensure that the Sensor is pushed firmly home. DO NOT damage the PCB components or wires.
- 4.0 Add a small dab of Glue ( UHU) to fix the sensor in the housing. This may be necessary due to the moulding tolerances of the sensor housing and the holder
- 5.0 Exchange Red & Black leads in the Molex
- 6.0 Add Serial number and date Carefully remove the paper backing and stick the transparent cover down.



Carefully mount one label on the sensor and one label on the white container so that the edges of the labels are parallel to the edges of the container and Sensor.

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- 7.0 Test the Sensor .The output should be between 23mV and 27mV.
- 8.0 Place packing material in the bottom and top of the white container and add the cap. Ensure it is sealed.
- 9.0 Add the Vandagraph round label to the top of the cap. Add the instruction leaflet, and place the whole into the polythene bag, seal it and affix a Serial Number Label.

