



SONARtrac[®] Rework Instruction

**Subject: Rework of P/N 20814
Connector and P/N 20812 Base to
Add Guide Pins and Bushings**

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There has been an instance of the P/N 20814 Connector Assembly becoming disengaged from the P/N 20812 Base Assembly. These are used to connect the sensor head to transmitter cable to the sensor head on the latch-style fiberglass sensor cover. Engineering believes this may be due to a radial force being applied to the connector, possibly from the cable.

At this point in time rework of the Connector Assembly and Base Assembly IS NOT MANDATORY. However, for those sites that wish to make this change the following procedure describes how to install Guide Pins to the Base Assembly and Bushings in the Connector Assembly that will eliminate this problem. Manufacturing is incorporating this change into new parts.

Document Change History

Date	Revision	Changed By	ECO #	Description of Change
19Feb09	01	B. Markoja	E09-0011	Initial Release
8May09	02	B. Markoja	E09-0022	Revise Tool



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Tools Required:

Qty	Part No.	Recommended Tools	Qty	Comments
1	52657-01	Screw Driver, Flat Blade with Screw Holder	1	Included in kit

Materials:

Item No.	Quantity	Part No.	Description
1	1	21121-01	KIT, G2 CONNECTOR, ALIGNMENT PIN AND BUSHING UPGRADE

Remove Indicated Screws from P/N 20814 Connector Assembly and Replace with P/N 52649-01 Guide Bushing

- 1.1. Disconnect the sensor head to transmitter connector from the sensor connector base.
- 1.2. Refer to the following figures and remove the indicated screws using a flat blade screw driver.

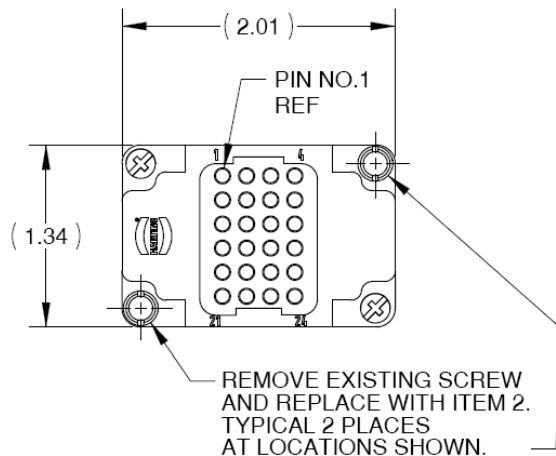


Figure 1 Rework of Base Assembly

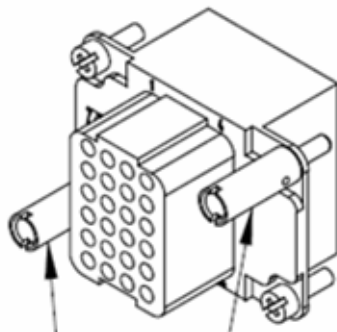


Figure 2 Bushings Installed in Base Assembly

Note: The screws are captive and must be removed in two stages.

Stage 1 is to remove the screw from the base casting; however it cannot be fully removed.

Stage 2 is to grip the underside of the screw using the screw grabber on the P/N 52657-01 screw driver from kit. Pull up on the screw and continue to turn it counter-clockwise until the threads are re-engaged in the metal portion of the insert. Remove the screw.

- 1.3. Install the P/N 52649-01 Guide Bushing in the holes formerly populated by the screws.
- 1.4. Tighten the bushings using a blade screw driver. Torque to 4.5 in-lbs (0.51 N-m).

Remove Indicated Screws from P/N 20812 Base Assembly and Replace with P/N 52648-01 Guide Pin

- 1.5. Disconnect the sensor head transmitter connector from the sensor connector base.
- 1.6. Refer to the following figures and remove the indicated screws using a Flat Blade (CiDRA P/N 52657-01) screw driver.

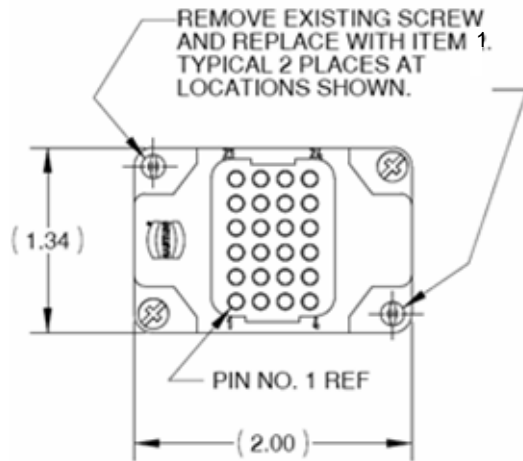


Figure 3 Rework of Connector Assembly

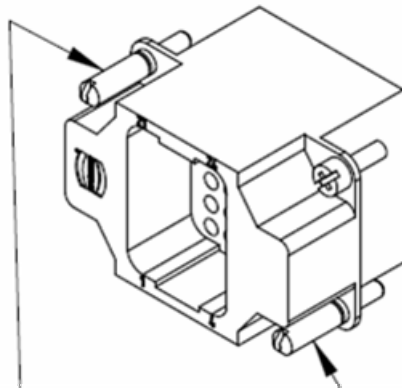


Figure 4 Guide Pin Installed in Base Assembly

Note: The screws are captive and must be removed in two stages.

Stage 1 is to remove the screw from the base casting; however it cannot be fully removed.

Stage 2 is to grip the underside of the screw using the screw grabber on the P/N 52657-01 screw driver. Pull up on the screw and continue to turn it counter-clockwise until the threads are re-engaged in the metal portion of the insert. Remove the screw.

- 1.7. Install the P/N 52648-01 Guide PIN in the holes formerly populated by the screws.
- 1.8. Tighten the pins using a flat blade screw driver. Torque to 4.5 in-lbs (0.51 N-m).