

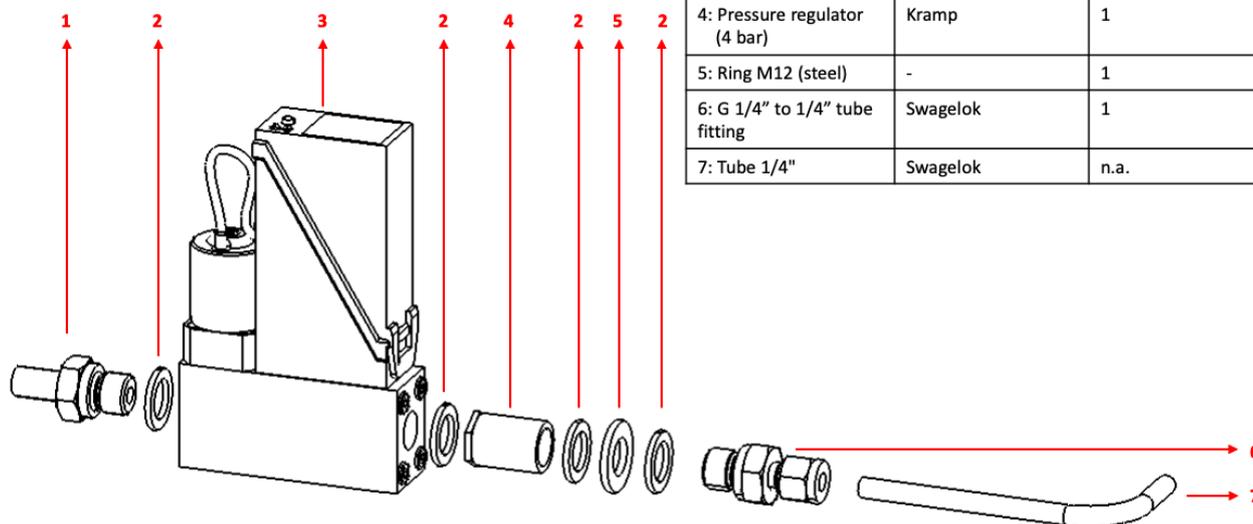
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TITLE: SUB-ASSEMBLY #2 – MASS FLOW CONTROLER - OXYGEN

Revision	Date	Modifications	Author
V1.0	08-04-2020	Setup first version	Imke Gevers
V1.1	09-04-2020	Additions	Sanne Buisman
V1.2	13-04-2020	Image additions and elaborate	Jeroen Roest / Bart Spel
V1.3	16-04-20	Materials overview	Jeroen Roest / Bart Spel
V1.4	27-04-20	Translation from Dutch to English	Josephine Dumas

In this Work Instruction the assembly of the part between the oxygen NIST fitting and the mixing chamber is described. Swagelok parts are called by their product name to assure that the correct parts are used.

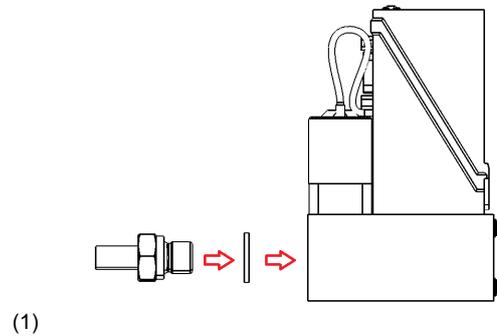
Part	Supplier	Quantity
1: G1/4" to 3/8" tube fitting	Swagelok	1
2: G1/4" gasket (rubber)	Swagelok	4
3: MFC (O ₂)	Bronkhorst	1
4: Pressure regulator (4 bar)	Kramp	1
5: Ring M12 (steel)	-	1
6: G 1/4" to 1/4" tube fitting	Swagelok	1
7: Tube 1/4"	Swagelok	n.a.



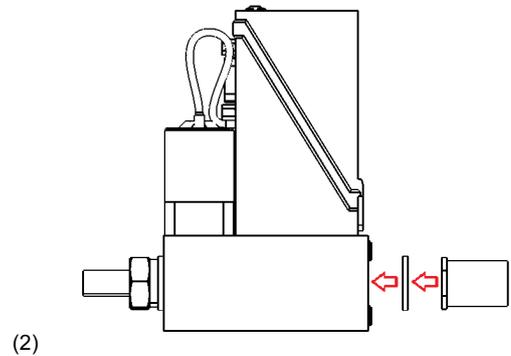
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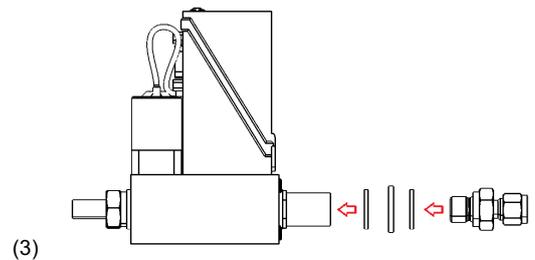
1.
 - Check the label on the Mass Flow Controller (MFC) used for this assembly, it should have the label 'O2'.
 - A G1/4" to 3/8" tube fitting must be mounted to the side of the MFC going to the mixing chamber (the flow arrow points towards this side).
 - Between the fitting and the MFC, a G1/4" gasket must be placed (figure 1)
 - G1/4" gasket: SS-4-RS-2V.
 - G1/4" to 3/8" tube fitting: SS-6-TA-4-RS.



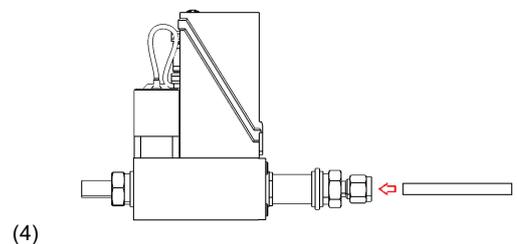
2.
 - A pressure regulator must be turned into the other side of the MFC. (The pressure regulator used has a male connector, which is not in accordance with the figure.)
 - A G1/4" gasket must be placed between the pressure regulator and the MFC (see figure 2)
 - G1/4" gasket: SS-4-RS-2V.



3.
 - A G1/4" to 1/4" tube fitting must be mounted into the other side of the pressure regulator.
 - Two G1/4" gaskets and a M12 metal ring must be used for this connection. The metal ring must be placed in between the two gaskets (see figure 3).
 - G1/4" gasket: SS-4-RS-2V.
 - G 1/4" to 1/4" tube fitting: SS-400-1-4RS



4.
 - A 1/4" tube of ±13.9 cm length must be connected to the fitting from step 3 (see figure 4).



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The correct assembly can be seen in the figures below.

