



PRODUCTS INC.  
WATERTOWN WI

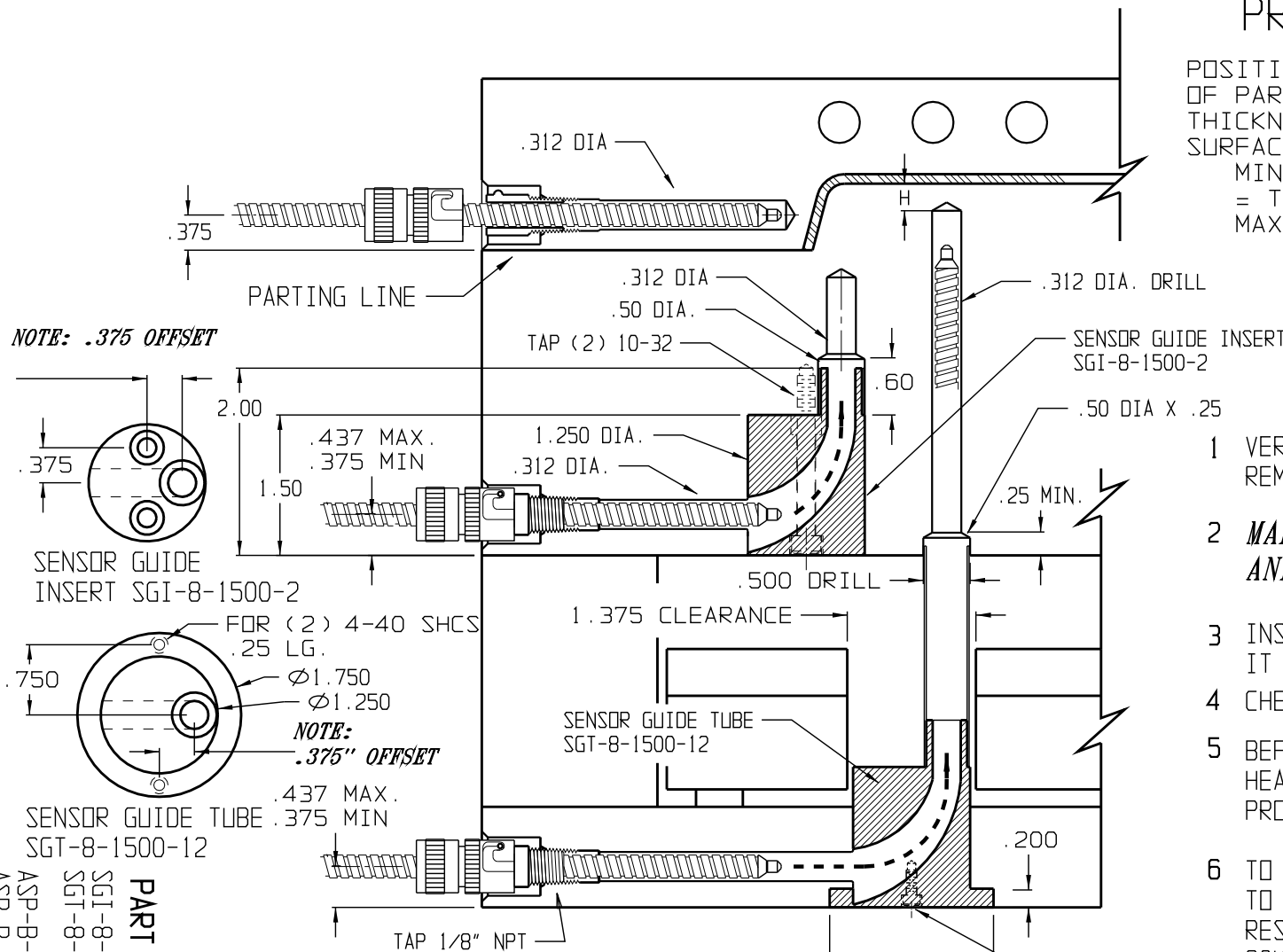
FOR SENSORS:

|   |                                  |
|---|----------------------------------|
| MM-1620-A-1-4-ARM. SPRING-PROBE-BAYONET | PART NO.                         |
| ASP-B-8-20-36-(1/4" DIA. 36" LONG       | SGT-8-1500-2 SENSOR GUIDE INSERT |
| ASP-B-8-20-48-(1/4" DIA. 48" LONG       | SGT-8-1500-12 SENSOR GUIDE TUBE  |
| ASP-B-8-20-96-(1/4" DIA. 96" LONG       |                                  |
| ASP-B-8-20-144-(1/4" DIA. 144" LONG     |                                  |

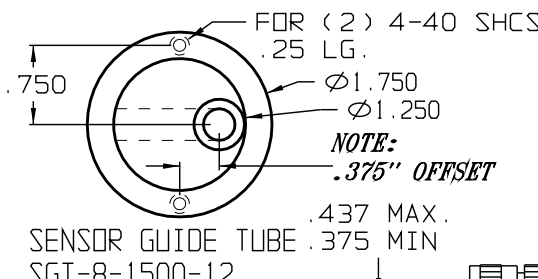
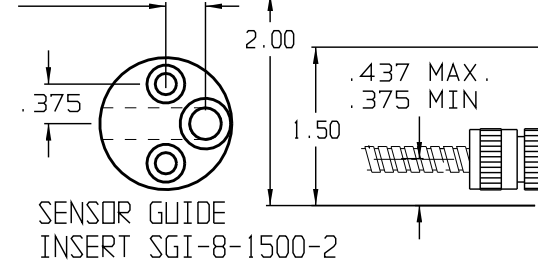
# PROBE DISTANCE H

POSITION SENSOR APPROX IN CENTER OF PART POSITION SENSOR WALL THICKNESS AWAY FROM MOLDING SURFACE

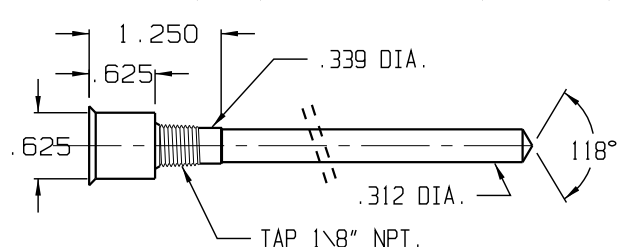
MIN .100 ON THIN WALL PARTS = TO WALL THICKNESS  
MAX .500 ON THICK WALL PARTS



NOTE: .375 OFFSET

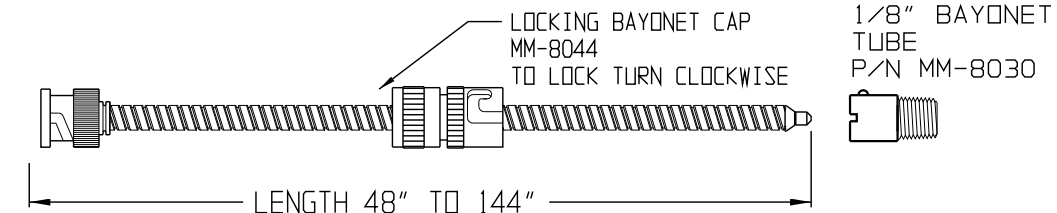


## MACHINING DIMENSIONS



## INSTALLATION

- 1 VERIFY POCKET AND HOLE DIMENSIONS REMOVE BURRS AND SHARP CORNERS
- 2 **MAKE SURE HOLE IS CLEAN AND FREE OF CHIPS**
- 3 INSERT SENSOR. MAKE SURE IT IS PROPERLY SEATED AT TIP
- 4 CHECK WITH PRUSSIAN BLUE
- 5 BEFORE INSERTING PROBE, APPLY HEAT TRANSFER COUPLAND TO PROBE TIP.
- 6 TO TEST PROBE - CONNECT OHM METER TO CENTER PIN AND OUTSIDE CASE RESISTANCE SHOULD READ 20K OHM AT 77 DEGR. F. RESISTANCE WILL DECREASE WITH TEMPERATURE RISE



FOR CAD INFO ON 1/4" SENSOR GUIDES - SEE DWG. MM-1622  
1/4" ARMORED SPRING PROBE (BAYONET TYPE) SENSOR GUIDE INSTALLATION