

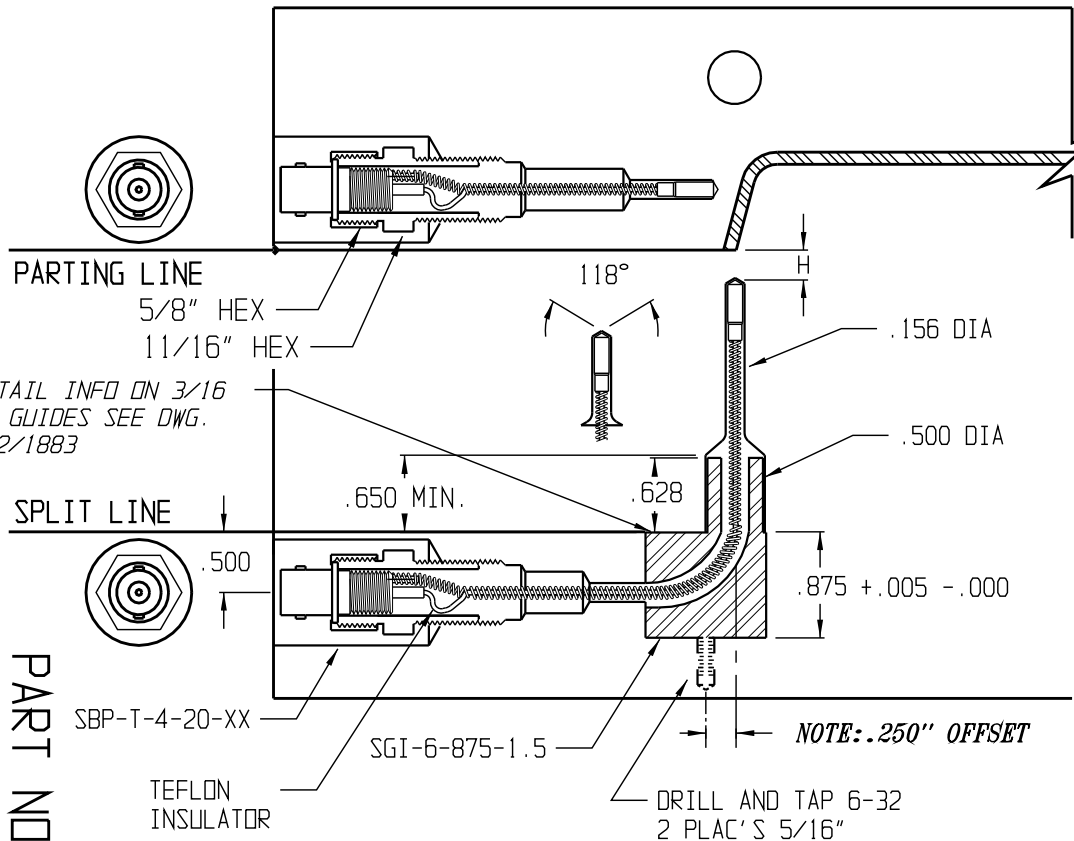


PRODUCTS INC.
WATERTOWN WI

FOR DETAIL INFO ON 3/16
SENSOR GUIDES SEE DWG.
MM-1882/1883

FOR SENSORS: SBP-T-4-20-24 (1/8" DIA 24" LONG)
FOR SENSOR GUIDE INSERT: SGI-4-875-1.5
FOR SENSORS: SBP-T-4-20-12 (1/8" DIA 12" LONG)

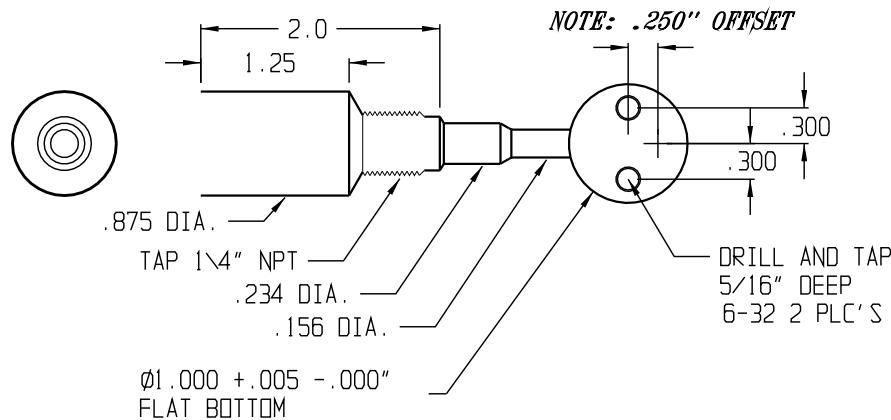
PART NO.



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

MACHINING DIMENSIONS



INSTALLATION

- 1 VERIFY POCKET AND HOLE DIMENSIONS. REMOVE BURRS AND SHARP CORNERS --- CHECK DIMENSIONS.
- 2 SCREW IN ADAPTOR SLEEVE
- 3 INSERT SENSOR. MAKE SURE IT IS PROPERLY SEATED AT TIP CHECK WITH PRUSSIAN BLUE
- 4 CUT OFF SPRING APPROX. 10% LONGER TO COMPRESS SENSOR. AVOID DAMAGE TO CENTER (SIGNAL) WIRE
- 5 EXIT WIRE THRU SIDE OF SPRING APPROX. 10 TURNS FROM END. CUT AND STRIP WIRE
- 6 SLIP INSULATOR SLEEVE ON WIRE AND SOLDER TO CENTER TAB
- 7 SOLDER SPRING TO OUTSIDE TERMINAL WITH ACID SOLDER CLEAN WITH WATER TO NEUTRALIZE THE ACID FLUX TO PREVENT CORROSION OF TERMINALS
- 8 APPLY HEAT TRANSFER COMPOUND TO PROBE TIP AND INSTALL
- 9 TO TEST PROBE CONNECT OHM METER TO CENTER AND OUTER CASE RESISTANCE SHOULD READ 20K OHM AT 77 DEG. F RESISTANCE READING WILL BE LESS AT HIGHER TEMPERATURE

FOR CAD INF ON 1/8" (HEX) SENSOR GUIDES - SEE MM-1722

1/8" "H" SPRING BEAD PROBE AND SENSOR GUIDE INSTALLATION

MM-1710-A-1/8" SPRING-PROBE-HEX