

Product Introduction:

A properly machined mounting hole is vital to the optimal operation of a melt pressure sensor. Poorly machined holes can result in damage that causes unreliable output or even failure of melt pressure sensors.

The machine tool kit contains the necessary drill bits and taps needed to machine standard transducer mounting holes, including a special pilot drill required to machine the 45 degree seat. All tools included in this kit are made of premium grade, high strength tool steel.

Note:

Care should be taken in the use of proper speeds and feeds, lubricants, and a method to assure continual alignment of each progressing tool.

Suggested Procedure:

Step 1: Drill a hole with a 9/32" drill

Step 2: Ream the hole with the 5/16" reamer

Step 3: Review the mounting hole drawing and calculate the depth required for the .451/.458" hole to leave .225" minimum length of the 5/16" (.312") diameter hole. Using the special 29/64" pilot drill, drill to the depth calculated above, leaving a little excess to be removed in Step 7.

Step 4: Drill with the 17/32" drill, if necessary, so as to leave approximately 1" of the 29/64" diameter hole length.

Step 5: Tap with the 1/2-20 plug tap without striking the chamfered seating surface that was produced by the pilot drill bit.

Step 6: Tap to the final depth with the 1/2-20 UNF bottoming tap.

Step 7: Examine the seating surface of the mounting hole. If it has been marked by the tapping operation, touch it up with the pilot drill bit.

Ordering Guide:

<u>Model</u>	<u>Description</u>
MACHINEKIT-1/2-20	1/2-20 UNF-2B mounting hole machine tool kit
MACHINEKIT-M18	M18 x 1.5 mounting hole machine tool kit

1/2-20 UNF Machine Tool Kit



M18 x 1.5 Machine Tool Kit Components



