



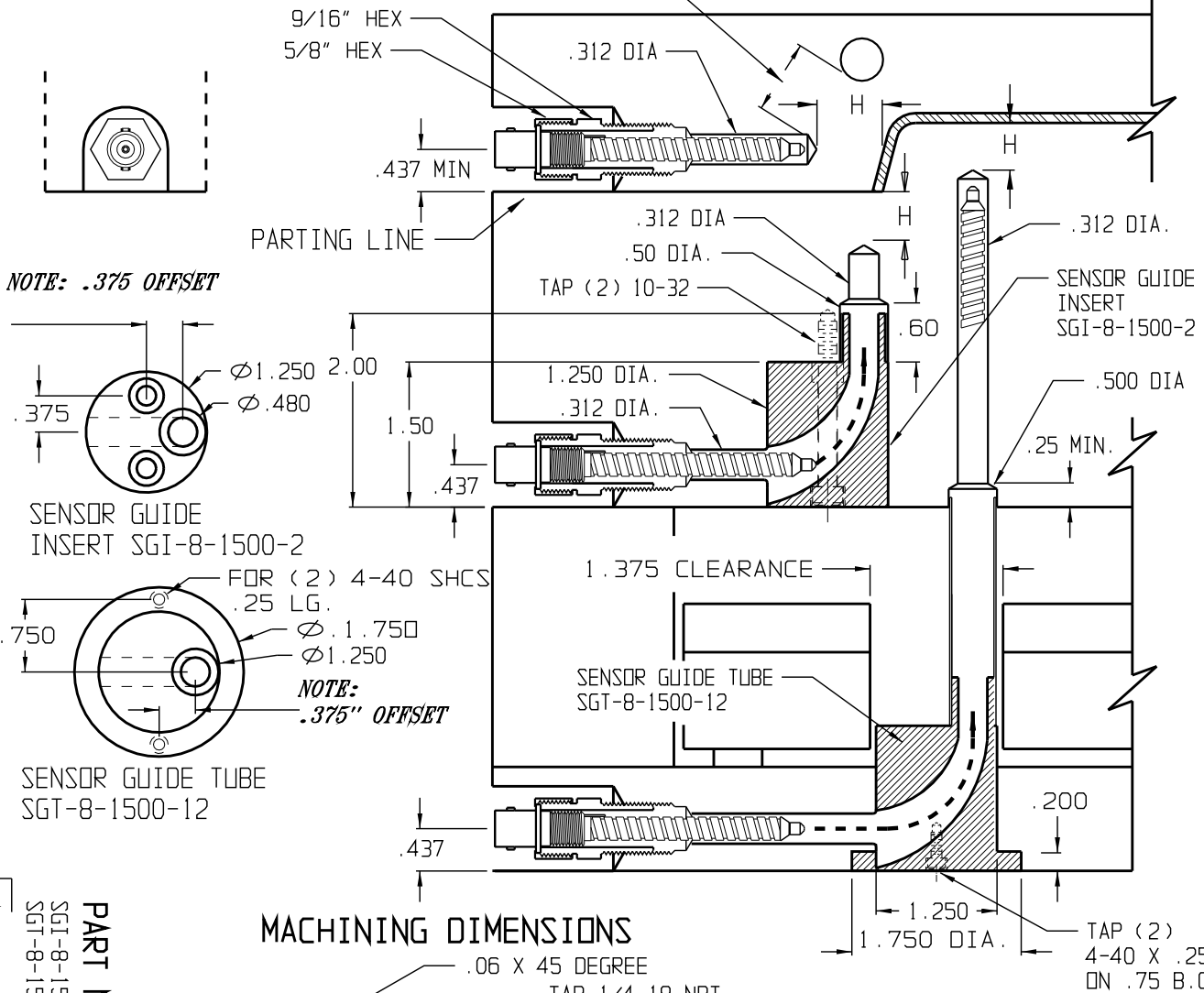
PRODUCTS INC.
WATERTOWN WI

INSTRUCTION SHEET MM-1630-A

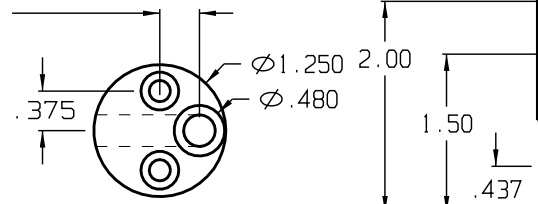
FOR SENSORS:

PART NO.
SGI-8-1500-2 SENSOR GUIDE INSERT
SGT-8-1500-12 SENSOR GUIDE TUBE
ASP-1-8-20-12 (1/4" DIA. 12" LONG)
ASP-1-8-20-24 (1/4" DIA. 24" LONG)
ASP-1-8-20-36 (1/4" DIA. 36" LONG)

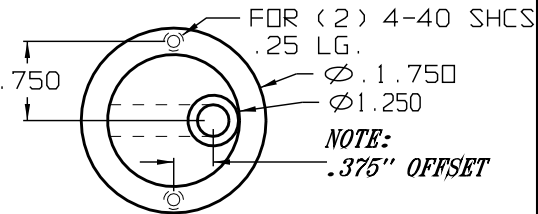
PLACE SENSOR APPROX.
1" FROM COOLING CHANNEL



NOTE: .375 OFFSET

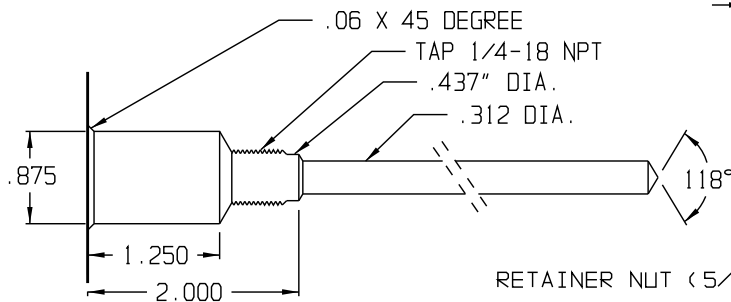


SENSOR GUIDE INSERT SGI-8-1500-2

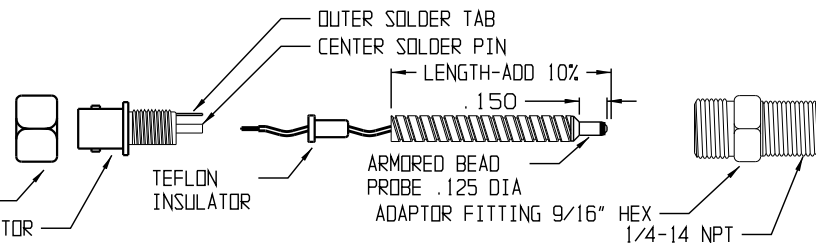


SENSOR GUIDE TUBE SGT-8-1500-12

MACHINING DIMENSIONS



RETAINER NUT (5/8" HEX)
BNC CONNECTOR



PROBE DISTANCE H

FAST CYCLE-HIGH COOLING MOLDS
15 SEC CYCLE OR LESS "H" DIM. = .100"
SET TO PROGRAM 1

GENERAL MOLDING 15 SEC AND UP
"H" DIM = .500 SET TO PROGRAM 3

INSTALLATION

- 1 VERIFY POCKET AND HOLE DIMENSIONS REMOVE BURRS AND SHARP CORNERS
- 2 MOUNT SENSOR GUIDE INSERT AND PROBE ADAPTOR FITTINGS
- 3 MAKE SURE HOLE IS CLEAN AND FREE OF CHIPS
- 4 INSERT SENSOR, MAKE SURE IT IS PROPERLY SEATED AT TIP
- 5 CUT OFF ARMORED CABLE APPROX. 10% LONGER TO COMPRESS SENSOR AVOID DAMAGE TO CENTER (RED) WIRE CUT OFF RED WIRE APPROX. .375" LONGER THAN CABLE
- 6 STRING RED CENTER WIRE THRU TEFLON INSULATOR SLEEVE SOLDER RED WIRE TO CENTER POST
- 7 ASSEMBLE BNC CONNECTOR AND ARMORED CABLE SOLDER OUTER TAB TO ARMORED CABLE (USE ACID FLUX SOLDER PROVIDED WITH PROBE) CLEAN WITH WATER AND BLOW DRY
- 8 BEFORE INSERTING PROBE APPLY HEATTRANSFER COMPOUND. TO TEST PROBE CONNECT OHM METER TO CENTER TAB AND OUTSIDE CASE RES. SHOULD READ 20K OHM AT 77 DEGREE F. RES. WILL DECREASE WITH TEMP. RISE

FOR DETAIL INFO ON 1/4" SENSOR GUIDES SEE DWG. MM-1884/1885
1/4" "T" ARMORED SPRING PROBE AND SENSOR GUIDE INSTALLATION