

# SUGGESTED SENSOR SELECTION

## SENSOR LOCATION:

FOR BEST PERFORMANCE OBSERVE THE FOLLOWING MOUNTING DISTANCE FROM PART SURFACE

FOR FAST CYCLE MOLDS (16 SEC OR LESS)  
PLACE SENSOR .100" FROM PART SURFACE

FOR GENERAL MOLDING  
PLACE SENSOR .500" FROM PART SURFACE

## SENSOR CHOICE:

- 1<sup>st</sup> CHOICE: .100" FROM PART SURFACE
- 2<sup>nd</sup> CHOICE: .100" FROM RUNNER SURFACE
- 3<sup>rd</sup> CHOICE: .100" FROM SPRUE SURFACE
- 4<sup>th</sup> CHOICE: INTERNAL WET PROBE
- 5<sup>th</sup> CHOICE: EXTERNAL WET PROBE
- 6<sup>th</sup> CHOICE: MAGNETIC DISC PROBE

## INSTALLATION:

1. SELECT BEST SENSOR LOCATION  
MACHINE SENSOR DETAILS  
SEE DETAILS ON BACK PAGE  
OR ON SENSOR INSTALLATION SHEET
2. CLEAN OUT CHIPS (2 TIMES AND INSPECT)  
ADJUST SENSOR TO MAKE CONTACT  
ON BOTTOM OF HOLE
3. INSTALL EACH SENSOR PER INST. INSTR.
4. USE ALUMINUM HEAT TRANSFER COMPOUND  
ON SENSOR TIP (FURNISHED WITH SENSOR)
5. INSTALL PER INST. INSTR.

## TESTING:

1. CONNECT OHM METER TO TERMINAL # 1  
(LARGE TERMINAL) AND GROUND  
RESISTANCE SHOULD READ 20 K OHM  
AT 77 DEGR. F - RESISTANCE WILL  
INCREASE WITH TEMP. DECREASE
2. A TEMPERATURE SWING WITH EACH MOLDING CYCLE  
(OBSERVED ON DIGITAL READ OUT)  
INDICATES A SUFFICIENT SIGNAL  
FOR MOLDMONITOR OPERATION

