

DYNISCO P/N 200925

Transducer Mounting Hole Machining Tool Kit

Description

The Transducer Mounting Hole Machining Tool Kit contains all of the necessary drills and taps to prepare a standard 1/2 - 20 UNF transducer mounting hole. The kit contains the 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. Care should be taken in the use of proper speeds and feeds, lubricants, and a method to assure continual alignment of each progressing tool. Consult Dynisco for additional or more specific information. M10 and M18 kits also available.



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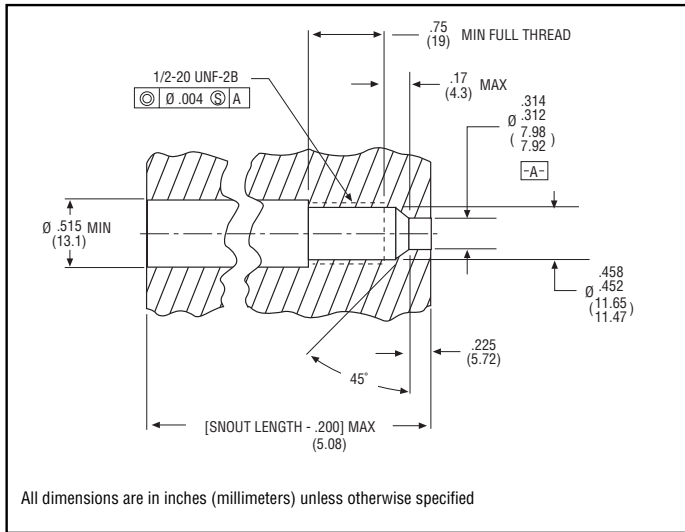
Suggested Procedure

- Step 1** Drill a hole with the 9/32" drill.
- Step 2** Ream the hole with the 5/16" reamer.
- Step 3** Consult 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, perhaps 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 (tap with tapered lean) as deep as possible without striking the chamfered seating surface that was produced by the pilot drill.
- 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.

It is generally good practice to check the mounting hole before installing the transducer. One procedure is to coat a gauge plug (P/N 200908) with Dykem machine blueing on surfaces below the thread. Insert the gauge plug into the mounting hole and rotate the plug until surface binding is encountered. Remove and inspect. Blueing should only be scraped off of the 45 degree sealing chamfer. If blueing has been removed from other surfaces, the mounting hole has not been machined properly.

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Transducer Mounting Hole Machining Tool Kit



Note: For models PT467 and PT435 please refer to mounting hole detail shown on page 216.

Ordering Guide

Part Number	Weight
200925	1.5 lbs.

Note: The Transducer Mounting Hole Machining Kit contains all the necessary drills and taps to prepare a standard 1/2 - 20 UNF - 2B transducer mounting hole. All tools are contained in a convenient carrying case. Specify P/N901949 for an M10 cleaning tool kit or P/N200101 for an M18 kit.

Ordering Guide (Replacement Parts)

Part Number	Description
200924	29/64 Pilot Drill
200926	9/32 Drill (.281)
200927	5/16 reamer (.3125)
200928	1/2-20 UNF GH5 Tap
200929	1/2-20 UNF GH5 Bottoming Tap
200930	17/32 Drill (.531)

Delivery

All configurations express delivery.

INTRODUCTION

The transducer Mounting Hole Machining Tool Kit contains all the necessary drills and taps to prepare a standard 1/2-20 UNF transducer mounting hole. The kit contains the special pilot drill required to machine the 45° seat. All tools included in this kit are made of premium grade strength tool steel. Care should be taken in the use of proper speeds and feeds, lubricants, and a method to assure continual alignment of each progressing tool. Consult Dynisco for additional information. M10 and M18 machining kits are also available.



FIG. 1 Cleaning Tool Kit Contents

MACHINING PROCEDURE

STEP 1.

Drill a hole with the 9/32" drill.

STEP 2.

Ream the hole with the 5/16" reamer.

STEP 3.

Consult the mounting hole drawing and calculate the depth required for the 0.451"/0.458" hole to leave 0.225" minimum length of the 5/16" (0.312") diameter hole.

STEP 4.

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

STEP 5.

Tap the 1/2-20 plug tap (tap with tapered lean) as deep as possible without striking the chamfered seating surface that was produced by the pilot drill.

STEP 6.

Tap 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.

It is generally good practice to check the mounting hole before installing the transducer. One procedure is to coat a gauge plug (P/N 200908) with Dykem blueing agent on the surfaces below the thread. Insert the gauge plug into the mounting hole and rotate the plug until surface binding is encountered. Remove and inspect. The blueing agent should be scraped off the 45° sealing chamfer. If blueing has been removed from other surfaces, the mounting hole has not been machined properly.

ORDERING INFORMATION

Part Number	Transducer Stem Size
200925	1/2-20 UNF
901949	M10
200205	M18

REPLACEMENT ORDERING INFORMATION

Part Number	Description
200924	29/94" Pilot Drill
200926	9/32" Drill (0.281)
200927	5/16" Reamer (0.3125)
200928	1/2-20 UNF GH5
200929	1/2-20 UNF GH5 Bottoming Tap
200930	17/32" Drill

Note: Gauge plug for PT435A, PT467E, and PT465XL ordered separately. Refer to P/N 435901

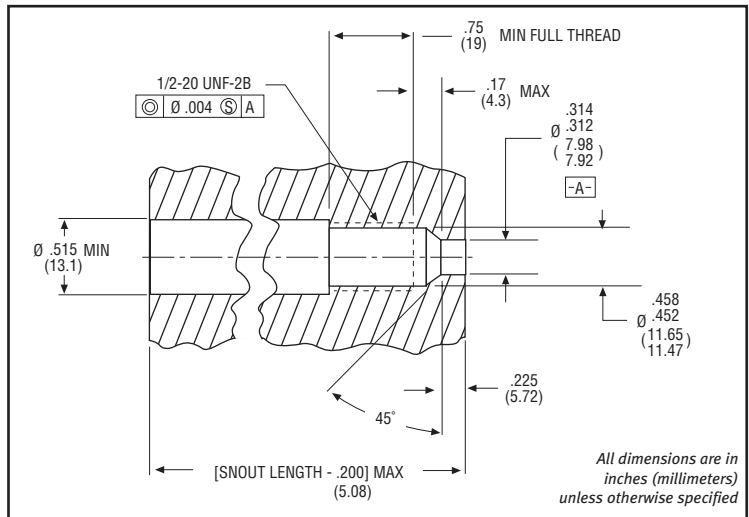


FIG. 2 Dimensional Diagram

REPAIR

Questions concerning warranty, repair cost, delivery, and requests for a RA# should be directed to the Dynisco Repair Department, 508-541-9400 or email: repair@dynisco.com. Please call for a return authorization number (RA#) before returning any product.

Dynisco, LLC
 Repair Department RA#
 38 Forge Parkway, Franklin, MA 02038

TECHNICAL ASSISTANCE

Please call 800-221-2201 or 508-541-9400 or fax 508-541-9436.

WARRANTY

Go to www.dynisco.com and click on "Warranty" at the bottom of any page for complete details.

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