

INTRODUCTION

Dynisco designed the cleaning tool kit for use in removing excess plastic from 1/2-20 UNF mounting holes for pressure and temperature transducers. Installation of transducers into improperly cleaned or sized holes is one of the major causes of damage to these instruments. With this kit, the 0.312" tip diameter hole, 45° seating surface, and the 0.451" hole can be cleaned. The kit includes a gauging plug, which is used to verify that the hole has been correctly machined and cleaned. M10 and M18 cleaning kits are also available.



FIG. 1 Cleaning Tool Kit Contents

CLEANING PROCEDURE

The cleaning tool must be used when the polymer is in a semi-molten state. Care must be taken not to exceed a torque rating of 100 inch-pounds during the scraping so as to not damage the cutting edges of the tool. These cutting edges are manufactured from hardened tool steel and will not wear if reasonable care is exercised. It is strongly recommended that a high temperature lubricant be applied to the tap and the threads of the guide sleeve and gauge plug to prevent seizing.

STEP 1.

Clean the threads of the hole with four-fluted bottoming tap until the threads are cleaned.

STEP 2.

Thread the guide sleeve/cleaning drill into the hole. Finger tight is sufficient. In a clockwise motion, push and turn the cleaning drill so that the residue is scraped from critical surfaces. Do not rock tool back and forth. Remove tool and clean off residue. Reinsert the tool and scrape again. Continue this operation until tool is clean when removed.

STEP 3.

Apply Dykem blueing agent on the gauge plug surfaces below the thread. Insert the gauge plug into the hole and rotate until surface binding is encountered. Remove and inspect. Blueing should only be scraped off 45° sealing chamfer. If blueing is removed from other surfaces, then the mounting hole is not clean or has not been machined properly.

ORDERING INFORMATION

With this kit the 0.312" tip diameter hole, the 45° seating surface and the 0.451" hole can be cleaned. A gauging plug is included to verify that the holes have been correctly machined and cleaned. All tools are contained in a convenient carrying case.

Part Number	Transducer Stem Size
200100	1/2-20 UNF
200102	M10
200101	M18

REPLACEMENT ORDERING INFORMATION

Part Number	Description
200904	Cleaning Drill
200906	Cleaning Drill Guide
200907	Handle
200908	Gauge Plug
200905	Bottoming Tap

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

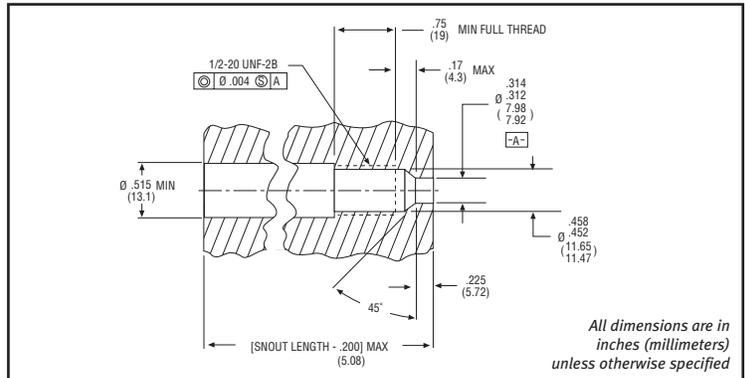


FIG. 2 Dimensional Diagram

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.