

Transducer Mounting Hole Machining Tool Kit

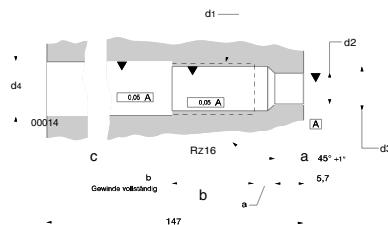
Description

The transducer mounting hole machining tool kit contains all of the necessary drills and taps to prepare a transducer mounting hole. The kit contains the special pilot drill required to machine the 45 degree seal. All tools included in this kit are made of premium grade, high strength tool steel. Care should be taken in use of proper speeds and feeds, lubricants and a method to assure continual alignment of each progressing tool.

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

Contents

- Pilot drill - d_3
- Drill - d_2
- Reamer - d_2
- GH5 tap - d_1
- GH5 Bottoming tap - d_1
- Drill - d_4



d_1	d_2	d_3	d_4	a	b	c
1/2"-20UNF-2B	7,92 ^{+0,05}	11,5 ^{+0,1}	13	5,7	4	19
M18 x 1,5	10,1 ^{+0,05}	16,3 ^{+0,2}	20	6,15	4	25



Suggested procedure

- | | |
|--|--|
| <p>Step 1 Drill a hole with the drill for d_2.</p> <p>Step 2 Ream the hole with the reamer for d_2.</p> <p>Step 3 Consult the mounting hole drawing and calculate the depth required for the hole d_3 to leave „A“, minimum length of the diameter hole d_2. Using the special pilot drill d_3, drill to the dept calculate above, perhaps leaving a little excess to be removed in step 7.</p> <p>Step 4 Drill with the drill for d_4, if necessary, so as to leave approximately C of the d_3 diameter hole length.</p> | <p>Step 5 Tap with the plug tap (tap with tapered lean) as deep as possible without striking the chamfered sealing surface that was produced by the pilot drill.</p> <p>Step 6 Tap to the final depth with the bottoming tap.</p> <p>Step 7 Examine the sealing surface of the mounting hole. If it has been marked by the tapping operation, touch it up with the pilot drill.</p> |
|--|--|

Order specifications

DYNISCO Machining Tool Kit XX

Thread
1/2 = 1/2" 20 UNF 2A
M18 = M18 x 1.5