

DYNISCO P/N 200100

Transducer Mounting Hole Cleaning Tool Kit

Description

The cleaning tool kit was designed by Dynisco for use in removing excess plastic from 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 .312" tip diameter hole, the 45 degree seating surface, and the .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 also available.



Important

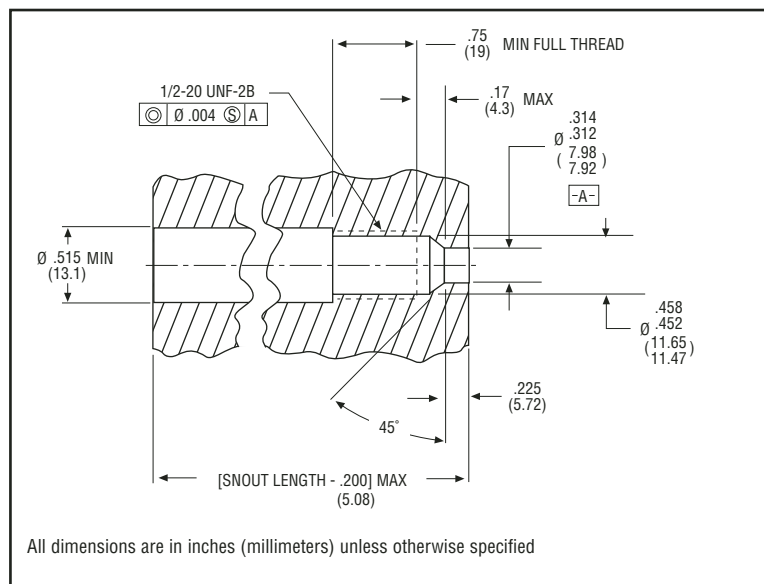
The cleaning tool must be used when the polymer is in a semi - molten state. Care must be taken not to exceed a torque rating of 100 inch - pounds during scraping so as not to damage the cutting edges of the tool. These cutting edges are manufactured from hardened tool steel and will not wear if reasonable 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.

Suggested Procedure

- Step 1** Clean threads of hole with four - fluted bottoming tap until threads are clean.
- Step 2** Thread the guide sleeve/cleaning drill into the hole. Finger tight is sufficient. In a clockwise motion, push and turn 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 tool and scrape again. Continue this operation until tool is clean when removed.
- Step 3** Apply Dykem blueing on gauge plug surfaces below 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 degree sealing chamfer. If blueing is removed from other surfaces, then mounting hole is not clean or has not been machined properly.

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Ordering Guide

Part Number	Weight
200100	5.5 lbs.

Note: With this kit the .312" tip diameter hole, the 45 degree seating surface and the .451" hole can be cleaned. A gauging plug is included to verify that the hole has been correctly machined and cleaned. All tools are contained in a convenient carrying case. Specify P/N200102 for an M10 cleaning tool kit or P/N200101 for an M18 kit.

Ordering Guide (Replacement Parts)

Part Number	Description
200904	Cleaning Drill
200906	Cleaning Drill Guide
200907	Handle
200908	Gauge Plug
200905	Bottoming Tap
200909	Allen Hex Wrench
200910	Dykem Blue

- Gauge plug included with cleaning tool kit. Refer to P/N900908 to order additional plugs.
- Gauge plug for PT435A, PT467E, and PT465XL ordered separately, refer to P/N435901.

Delivery

All configurations express delivery.