½” Button Installation

Step One

Mill Sensor Pocket
(use included Drawing, Sensor Pocket Problems Page and End Mill)

Step Two

Check Sensor Pocket
(use ½” Button Gauge Plug and Block)

Step Three

Install Sensor
(Refer to Sensor Installation Problems Page)

Step Four

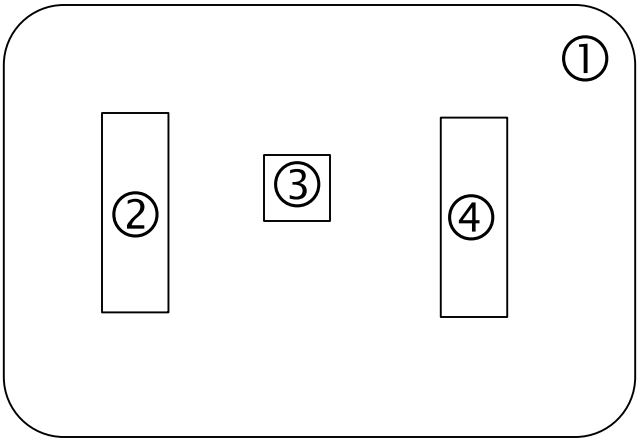
Check Installed Sensor
With the RJG Sensor eValuator

Rev. 8.0

½” Button Installation/Check Kit

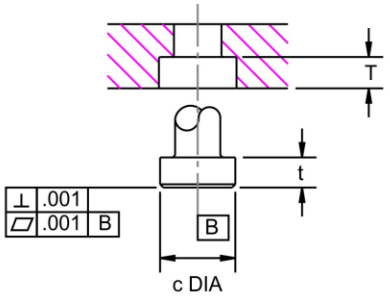
Reorder Information

	Part Number	Description
①	PA-BSPK-CAS	Carrying Case
②	MA-0127-BLK	½” Button Test Block
③	MA-0127-PLG	½” Button Gauge Plug
④	89-0127-TL1	Carbide End Mill

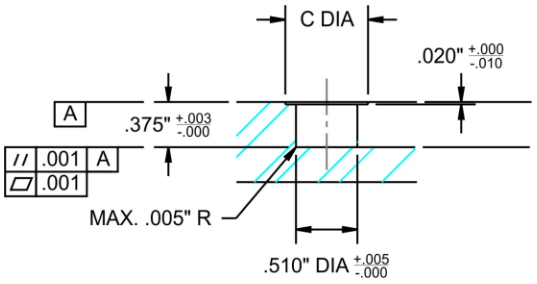


Pocket Milling Instructions

Step One:
Rough mill sensor pocket to -.010" from finish size and rough mill cable slot to print



Step Two:
Add .020" DP x DIA +1/8" C'Bore (spot face) to pocket noted ***** at right



Step Three:
Finish mill sensor pocket with 5/16" DIA Dead Sharp 4-fluted end mill by circular interpolation to size. Note MAX internal corner radius.

RJG Part Number:

89-0127-TL1

Notes:

T = (t + .010") +.01" -.00" Ejector Pin Head Clearance

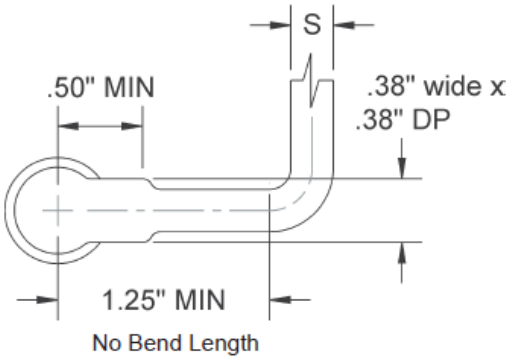
C = (c + .125") +.02" -.02" Counter Bore Clearance

S = .25" Wide Slot for Lead Wire

Step Four:
Check with RJG ½" gauge plug

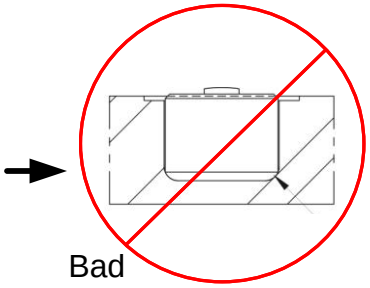
RJG Part Number:

MA-0127-PLG



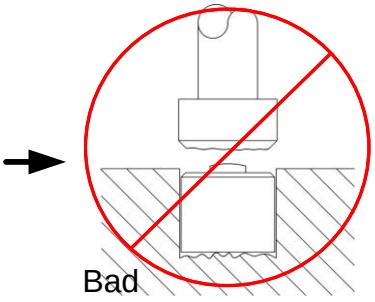
Sensor Pocket Problems to be avoided

Design sensor pocket to the specifications in the manual. Specify no radius on the bottom to prevent side-loading



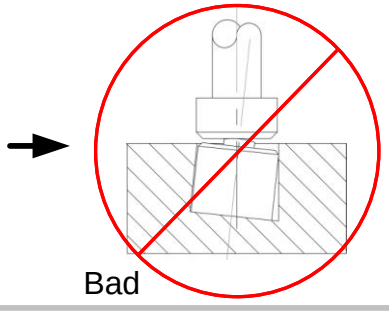
Bad

The metal that transmits pressure to the sensor from a ejector pin must be a smooth surface. The mold surface must also have a surface finish of 32 or better



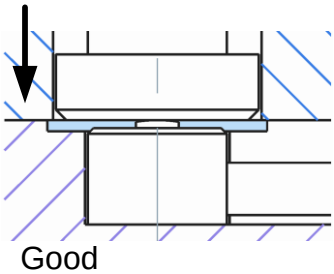
Bad

Ejector pin head must be perpendicular to the pin shaft

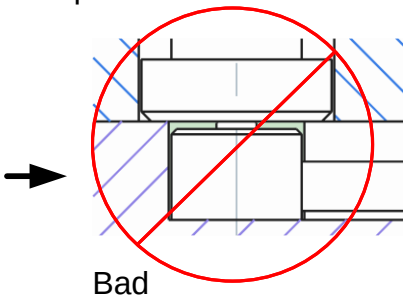


Bad

If the ejector pin head is larger than the sensor head, additional clearance room must be provided



Good

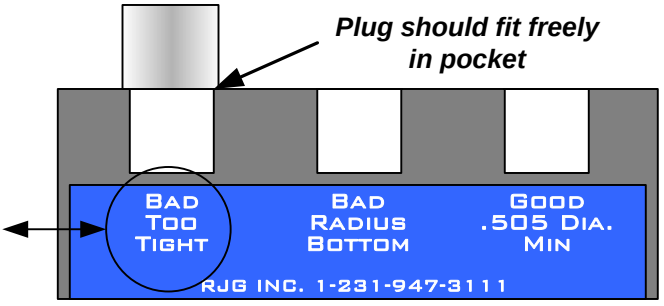


Bad

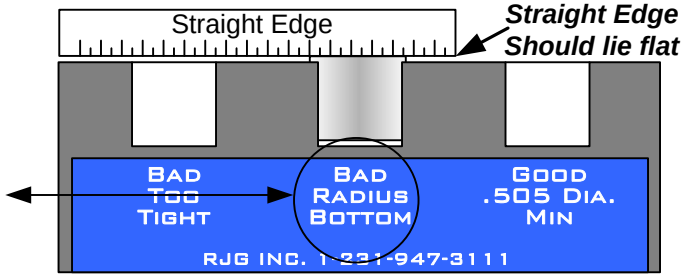
Using the ½" Button Gauge Plug

The ½" Button Gauge Plug allows the tool room to check new sensor pockets for some of the most common and most damaging sensor pocket problems. The Block is included to demonstrate operation of the gauge plug.

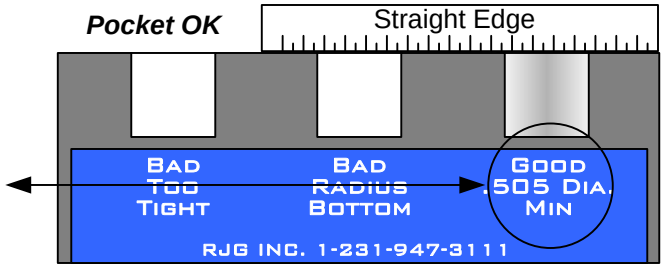
Bad: Too Tight
This pocket demonstrates a pocket diameter that is too small. Such a pocket can cause damage to a sensor under pressure.



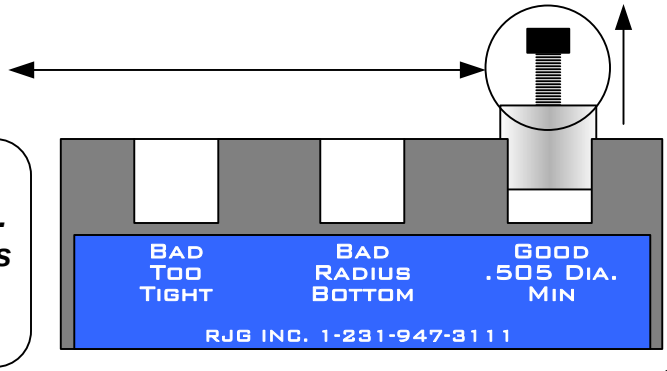
Bad: Radius Bottom
This pocket demonstrates a pocket that has radius in the corner. Such a pocket can cause the sensor to protrude above the plate. This will cause sensor errors and/or the destruction of the sensor when the mold is reassembled.



Good: .505" Dia. Min
This pocket demonstrates a correct pocket. The plug inserts freely and does not protrude above plate



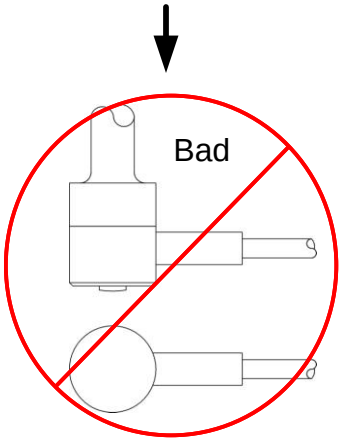
Plug Removal
Use the included screw to remove the plug from the plate.

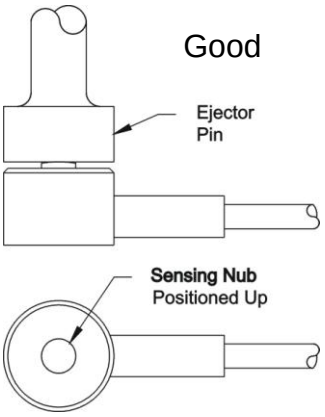


Attention!
Tolerances are tight. Keep all components dry and free of particulate.

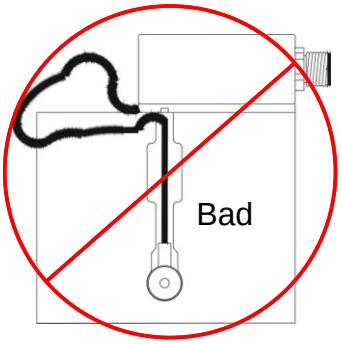
Installation Problems to be avoided

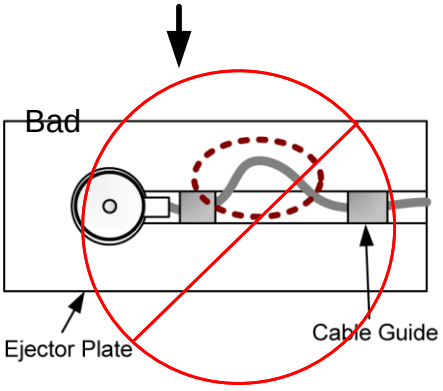
Nub must touch the ejector pin
(do not install upside down)





Bury the sensor wire. It should go straight into the mold from the bottom of the Lynx case (on RJG Standard sensors). This will prevent sensor cable damage. Do not allow the sensor cable to fall outside the mold.

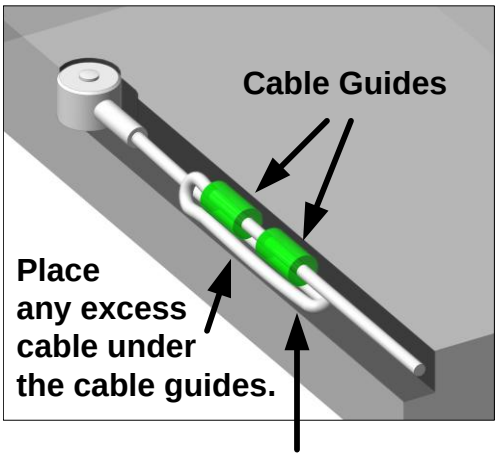




Sensor Cable Retention Tools

Self Locking Cable Guide Installation*

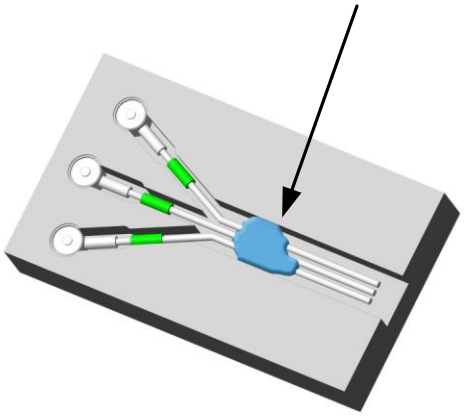
- Put the sensor's cable through the cable guide, then insert the guide & cable into the channel.
- Install as many cable guides as necessary in order to secure the cable in the channel.
- Guide can be removed by gently pulling up on the sensor's cable.

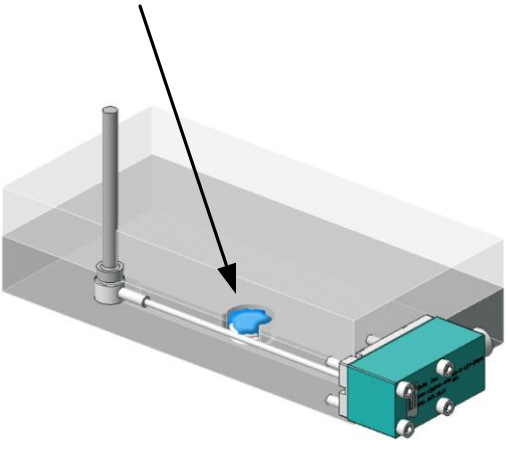


**Note: This is not for blue piezoelectric cables. Bending piezo cables in this manner can damage them*

Cable Retention Putty

Use Cable Retention Putty to retain sensor wires when the use of the cable guides supplied with our sensors will not work for your application. Example: Multiple wires per channel.





Sensor eValuator with Sensor eValuator Android App

The RJG Sensor eValuator with the Sensor eValuator App allows a sensor to be attached, and the following tests run right in your plant: Lynx Communication Test, Zero Offset Tests and Broken Wire/Failed Gage for Strain Gage; Lynx Communication Test and Drift Test for Piezo and Basic Force Test for both types.

Contact RJG for more information

231 947-3111
www.rjginc.com