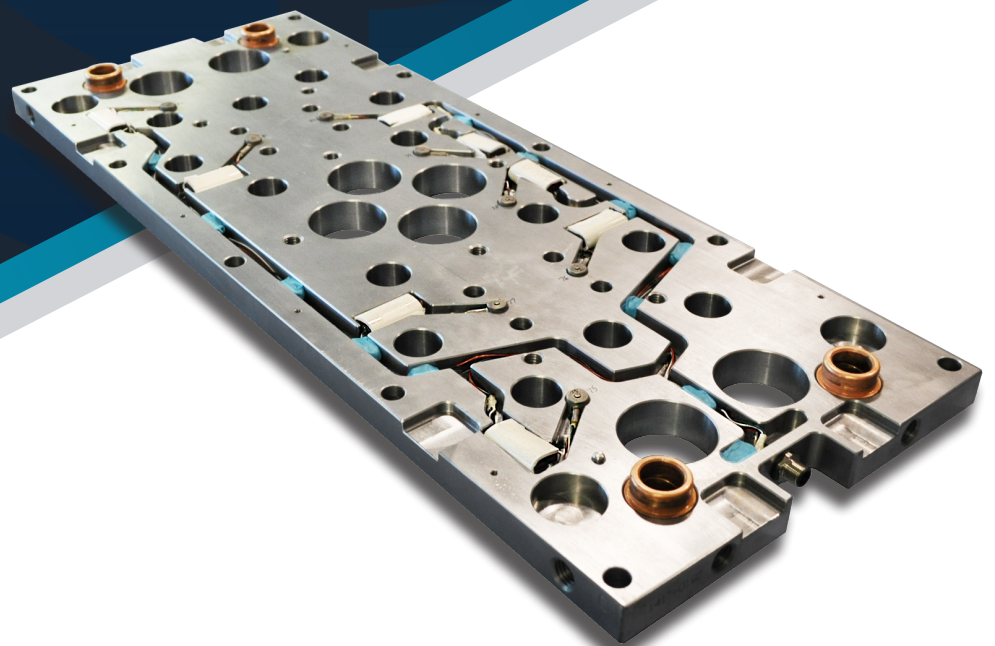


PRODUCT MANUAL

LYNX™ EMBEDDED SENSORS

**LES-B-127-50, LES-B-127-125,
LES-B-127-500, & LES-B-127-2000**



PRODUCT MANUAL

LYNX™ EMBEDDED SENSORS

LES-B-127-50, LES-B-127-125, LES-B-127-500, & LES-B-127-2000

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PRODUCT MANUAL

LYNX™ EMBEDDED SENSORS

LES-B-127-50, LES-B-127-125, LES-B-127-500, & LES-B-127-2000

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PRODUCT MANUAL

LYNX™ EMBEDDED SENSORS

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PRODUCT MANUAL

LYNX™ EMBEDDED SENSORS

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INTRODUCTION

Read, understand, and comply with all following instructions. This guide must be kept available for reference at all times.

DISCLAIMER




Inasmuch as RJG, Inc. has no control over the use to which others may put this material, it does not guarantee that the same results as those described herein will be obtained. Nor does RJG, Inc. guarantee the effectiveness or safety of any possible or suggested design for articles of manufacture as illustrated herein by any photographs, technical drawings, and the like. Each user of the material or design or both should make his own tests to determine the suitability of the material or any material for the design as well as the suitability of the material, process, and/or design for his own particular use. Statements concerning possible or suggested uses of the material or designs described herein are not to be construed as constituting a license under any RJG, Inc. patent covering such use or as recommendations for use of such material or designs in the infringement of any patent.

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ALERTS

The following three alert types are used as needed to further clarify or highlight information presented in the manual:

-  **DEFINITION** *A definition or clarification of a term or terms used in the text.*
-  **NOTES** *A note provides additional information about a discussion topic.*
-  **CAUTION** *A caution is used to make the operator aware of conditions that can cause damage to equipment and/or injury to personnel.*

ABBREVIATIONS

DIA	diameter
MIN	minimum
MAX	maximum
R.	radius

PRODUCT DESCRIPTION

The LES-B-127-50/125/500/2000 line of sensors from RJG, Inc. are multi-channel, digital strain gage, 0.50" (12,7 mm) button-style cavity pressure sensors that can withstand forces up to 50 lb. (0.22 kN), 125 lb. (0.56 kN), 500 lb. (2.22 kN), or 2,000 lb. (8.9 kN) and temperatures up to 250 °F (120 °C—standard sensors) or 425 °F (220 °C—high-temperature sensors).

The Lynx™ LES-B-127-50/125/500/2000 sensor electronics and heads are embedded into the mold, eliminating outside cabling. Designed exclusively for use with the RJG eDART® or Copilot® Systems, all sensors are fully functional and properly named with a single cable connection from the mold to the eDART or CoPilot process control and monitoring systems.

One Lynx connector connects up to 16 sensors and to one system Lynx port (up to 32 sensors per system—additional sensors will require additional systems); if more than 32 sensors are required please contact RJG Customer Support for additional information.



APPLICATIONS

MULTI-CHANNEL SENSORS

Button-style cavity pressure sensors are suitable for injection molding applications in which the following conditions are met:

- Sensor will be installed behind an ejector, blade, or core pin.
- Applied plastic pressure is high enough to prevent poor sensor resolution, but low enough to prevent sensor damage.
- Only one point of contact (single pin) to the sensor.

Sensor will be kept below 250 °F (120 °C) for standard models or 425 °F (220 °C) for high-temperature models (LES-B-127-XXXX-H) in the mold; sensor electronics, regardless of model, will be kept below 140 °F (60 °C).

CAUTION *LES-B-127-XXXX model sensors MUST be used only within the recommended temperature ranges; failure to comply will result in the damage or destruction of equipment.*

SENSOR AND EJECTOR PIN SIZE

SELECTION CHARTS

The last number in the product model code signifies the full-scale rating in pounds of each sensor model; for example, the LES-B-127-125 is a 125-pound sensor, full-scale, while the LES-B-127-2000 is a 2,000-pound sensor. Locate the pin size that will be used and match it to the location on the part (near the end of fill or near the gate). The recommended sensor is the intersection of the row and column.

RJG® recommends that expected peak force is less than or equal to 75% of the sensor model's full scale. The expected peak force can be determined by multiplying the expected peak plastic pressure at the sensor's pin location by the project surface area of the pin on the cavity wall—this is recommended for each sensor location in an instrumented tool. The expected peak plastic pressure can be found from simulation or similar processes, or estimated from the material tonnage on the material safety data sheet (MSDS).

The charts below are only a guide. In order to assure correct sensor selection for an application, please contact RJG.

1. Imperial Units

NORMAL PRESSURE		HIGH PRESSURE
Pin Size	Sensor Model	Sensor Model
3/64	LES-B-127-50	LES-B-127-50
1/16	LES-B-127-50	LES-B-127-50
5/64	LES-B-127-50	LES-B-127-125
3/32	LES-B-127-125	LES-B-127-125
7/64	LES-B-127-125	LES-B-127-125
1/8	LES-B-127-125	LES-B-127-500
9/64	LES-B-127-500	LES-B-127-500
5/32	LES-B-127-500	LES-B-127-500
3/16	LES-B-127-500	LES-B-127-500
7/32	LES-B-127-500	LES-B-127-500
1/4	LES-B-127-500	LES-B-127-2000
9/32	LES-B-127-2000	LES-B-127-2000
5/16	LES-B-127-2000	LES-B-127-2000
11/32	LES-B-127-2000	LES-B-127-2000
3/8	LES-B-127-2000	LES-B-127-2000
13/32	LES-B-127-2000	LES-B-127-2000
7/16	LES-B-127-2000	LES-B-127-2000
1/2	LES-B-127-2000	-
9/16	-	-
5/8	-	-

SENSOR AND EJECTOR PIN SIZE (continued)

2. Metric Units

Pin Size	NORMAL PRESSURE	HIGH PRESSURE
	Sensor Model	Sensor Model
1.0 mm	LES-B-127-50	LES-B-127-50
1.5 mm	LES-B-127-50	LES-B-127-50
2.0 mm	LES-B-127-50	LES-B-127-125
2.5 mm	LES-B-127-125	LES-B-127-125
3.0 mm	LES-B-127-125	LES-B-127-125
3.5 mm	LES-B-127-125	LES-B-127-125
4.0 mm	LES-B-127-125	LES-B-127-125
4.5 mm	LES-B-127-500	LES-B-127-500
5.0 mm	LES-B-127-500	LES-B-127-500
5.5 mm	LES-B-127-500	LES-B-127-500
6.0 mm	LES-B-127-500	LES-B-127-500
6.5 mm	LES-B-127-500	LES-B-127-2000
7.0 mm	LES-B-127-2000	LES-B-127-2000
7.5 mm	LES-B-127-2000	LES-B-127-2000
8.0 mm	LES-B-127-2000	LES-B-127-2000
8.5 mm	LES-B-127-2000	LES-B-127-2000
9.0 mm	LES-B-127-2000	LES-B-127-2000
9.5 mm	LES-B-127-2000	LES-B-127-2000
10.0 mm	LES-B-127-2000	LES-B-127-2000
11.0 mm	LES-B-127-2000	LES-B-127-2000
12.0 mm	LES-B-127-2000	LES-B-127-2000
13.0 mm	LES-B-127-2000	-
14.0 mm	-	-
15.0 mm	-	-
16.0 mm	-	-

OPERATION

BUTTON-STYLE/UNDER-PIN

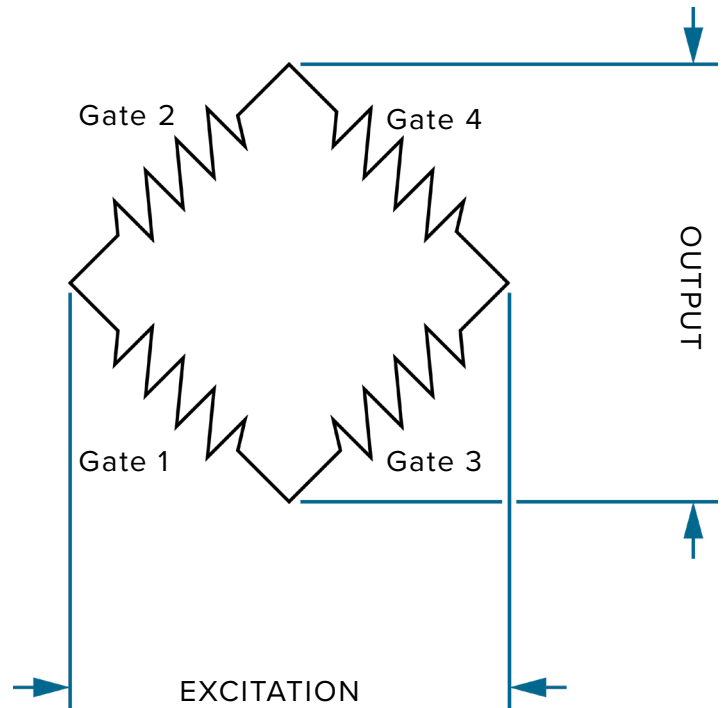
The Lynx single-channel, button-style strain gage sensor is placed in a mold behind an ejector pin. As plastic is injected into the cavity, the pressure of the plastic applies force to the ejector pin; the plastic pressure force is transferred to the strain gage sensor.

STRAIN GAGE SENSORS

The strain gage sensing element inside the sensor body converts the applied force to an electrical signal that can read using the eDART system or CoPilot system software. The sensing element uses a Wheatstone bridge configuration (four strain gage elements positioned in a circuit) to convert small amounts of sensor deformation into a measurable voltage through the change in resistance of the strain gage sensing elements. The sensor sends out a low-level voltage signal which is proportional to the amount of force applied by the pressure placed on the pin and transferred to the sensor.

The voltage measurement is carried through the sensor cable, to the Lynx sensor electronics case mounted inside the mold. The voltage signal is converted by the sensor's electronics to a high-accuracy digital output that directly correlates with pressure from within the cavity.

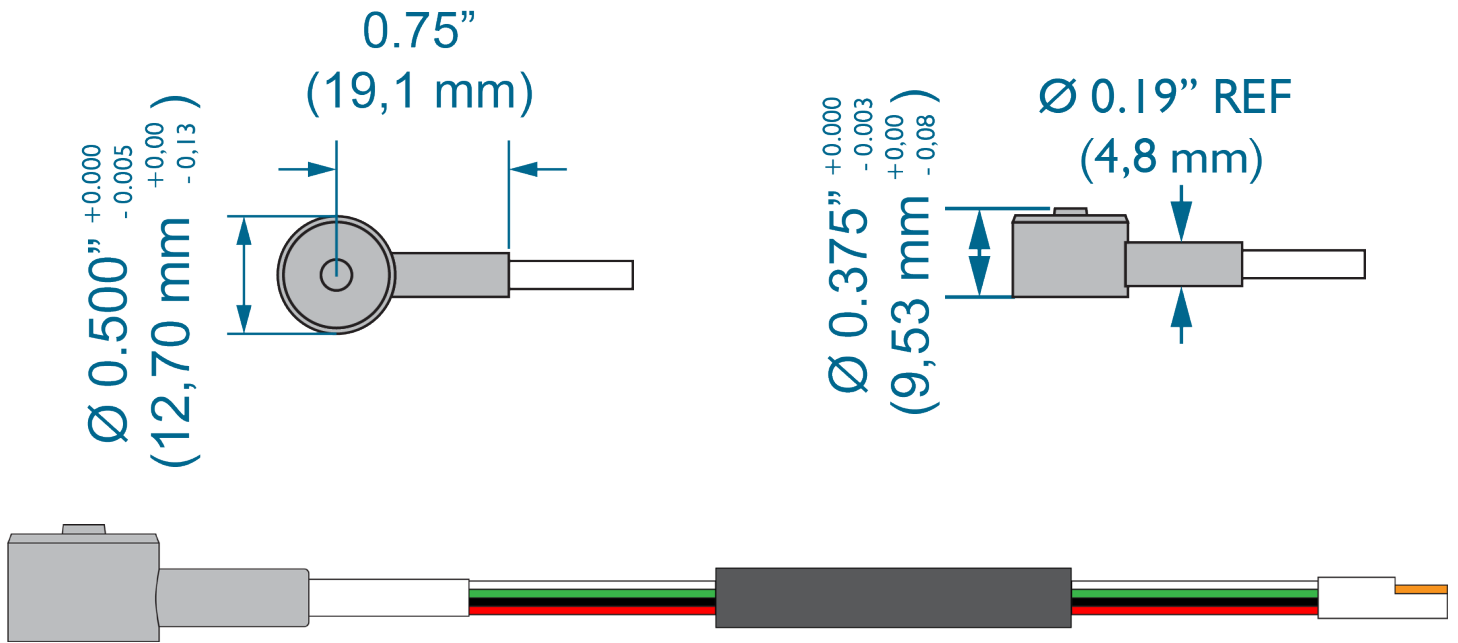
STRAIN GAGE OPERATING PRINCIPLE



The sensor are connected to the RJG, Inc. eDART System, which records and displays the sensor's measurement for use in process monitoring and control. In addition, the sensor electronics communicates the sensor model, serial number, full scale load, and calibration data automatically to the eDART or CoPilot system, providing the highest level of sensor accuracy while minimizing the need for user-entered data when configuring the sensor in the eDART or CoPilot systems.

DIMENSIONS

SENSOR



CABLE LENGTHS

Cable lengths are determined at time of order; each LES-B-127-50/125/500/2000 is custom-fit for application. The minimum sensor cable length available, measured from the center of the sensor head, is 1.50" (38,1 mm). Contact RJG Customer Support for more information.

LYNX CONNECTOR AND PG9 THREAD

The Lynx connector is keyed at 45° to provided the proper orientation of cable connection, particularly for the 90° Lynx cables.



LYNX CONNECTOR Pg9 THREAD

PG Nominal Size Call-out	Pg9	Minor Ø Male Thd. d1 [mm]	13.86
Major Ø d=D [mm]	15.2	Thread Height H1 [mm]	0.67
Pitch p [mm]	1.411	Tap Drill Ø [mm]	14
Threads per Inch tpi	18	Radius [mm]	0.15
Pitch Ø d2=D2 [mm]	14.53		

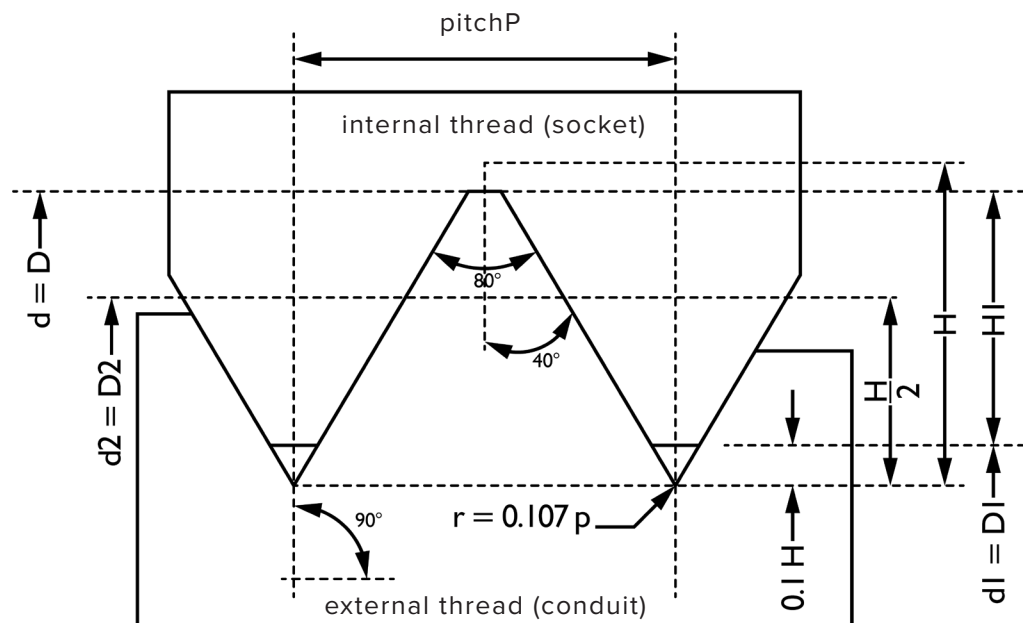
Data in mm

$$p = 25.4/\text{tpi}$$

$$r = 0.107 p$$

$$H = 0.595875 p$$

$$H1 = 0.8 \quad h = 0.4767 p$$



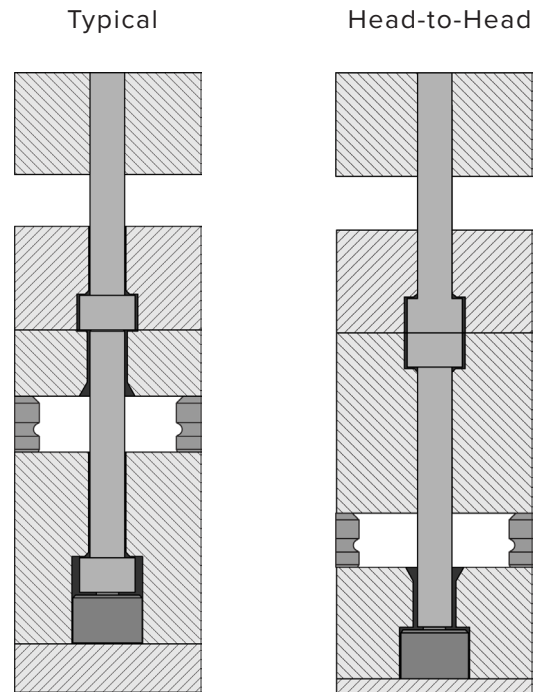
INSTALLATION

Sensors may be placed in the clamp plate behind transfer pins, or in the ejector plate behind ejector pins. Installation location—in the clamp plate or ejector plate—depends upon mold real estate and customer preference.

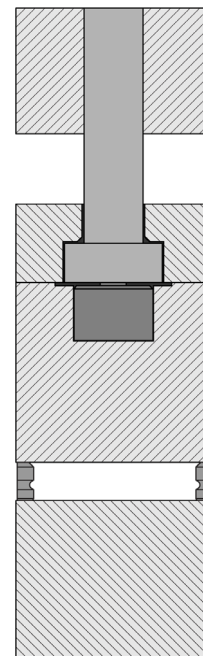
Transfer pins protect the sensor from damaging shock loads that are applied when the ejector plate moves forward and backward; the sensor's cable is also protected from pinching since it is not necessary to disassemble the clamp and backing plates during normal usage or preventative maintenance.

Ejector pins provide a simple, straightforward method of installation in which sensors may be installed; ejector pin installation requires less machining and less equipment to achieve.

CLAMP PLATE INSTALLATIONS



EJECTOR PLATE INSTALLATION



INSTALLATION OVERVIEW

CLAMP PLATE (TYPICAL) INSTALLATION

Apply the clamp plate (typical) installation to instances where the ejector and transfer pins are less than 0.28" (7,0 mm) in diameter.

The sensor connector plate is mounted on the mold. Pockets and a channel is machined into the mold for the sensor connector, cable, and sensor head. The sensor head is placed under the transfer pin above the cover plate in the clamp plate. The transfer pin is retained below the ejector pin in the clamp plate. The ejector pin is retained in the ejector retainer plate and reaches through to the B-Plate or cavity insert (refer to figure at top right).

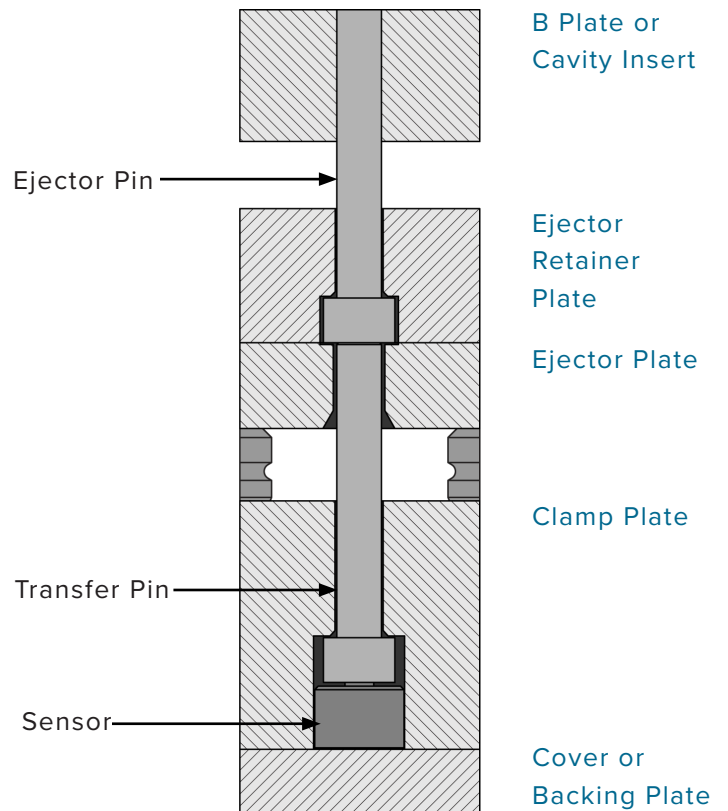
A minimum of 0.50" (12,0 mm) or one-third of the transfer pins length, whichever is greater, must be fitted to a H7/g6 tolerance within the clamp plate to ensure proper pin alignment and to prevent possible bending. If 0.50" (12,0 mm)/one-third minimum cannot be achieved, apply the head-to-head clamp plate installation concept (refer to figure at top right).

CLAMP PLATE (HEAD-TO-HEAD) INSTALLATION

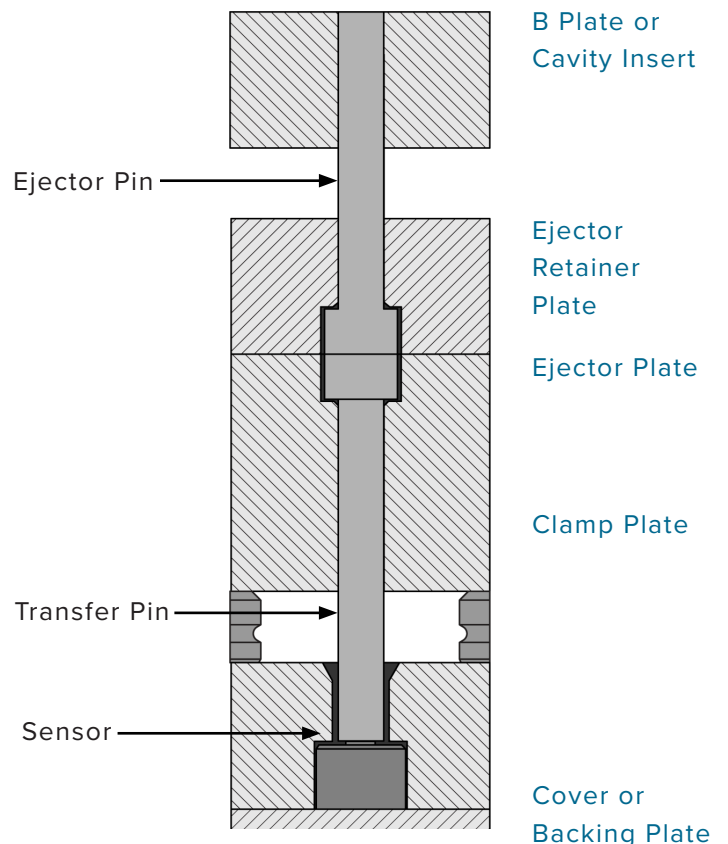
Apply the clamp plate (head-to-head) installation to instances where the ejector and transfer pins are greater than 0.28" (7,0 mm) in diameter, or those in which a minimum of 0.50" (12,0 mm)/one-third of the transfer pin cannot be contained above the transfer pin head in the clamp plate.

The sensor connector plate is mounted on the mold. Pockets and a channel is machined into the mold for the sensor connector, cable, and sensor head. The sensor head is placed under the transfer pin above the cover plate in the clamp plate. The transfer pin is retained below the ejector pin in the ejector plate, while the ejector pin is retained in the ejector retainer plate, with both heads resting against each other. The ejector pin reaches through to the B-Plate or cavity insert (refer to figure at bottom right).

CLAMP PLATE (TYPICAL) INSTALLATION



CLAMP PLATE (HEAD-TO-HEAD) INSTALLATION



INSTALLATION OVERVIEW *(continued)*

EJECTOR PLATE INSTALLATION

The sensor connector plate is mounted on the mold. Pockets and a channel is machined into the mold for the sensor connector, cable, and sensor head. The sensor head is placed under the ejector pin in the ejector plate. The ejector pin is retained in the ejector retainer plate and reaches through to the B-Plate or cavity insert (refer to figure at right).

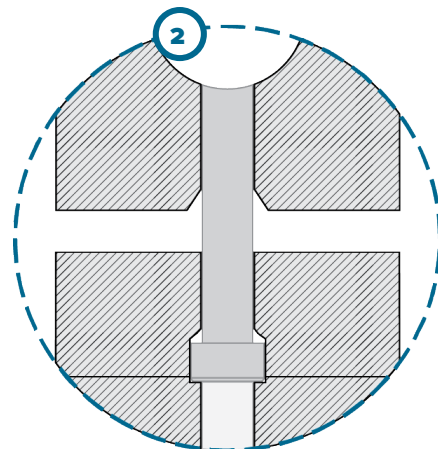
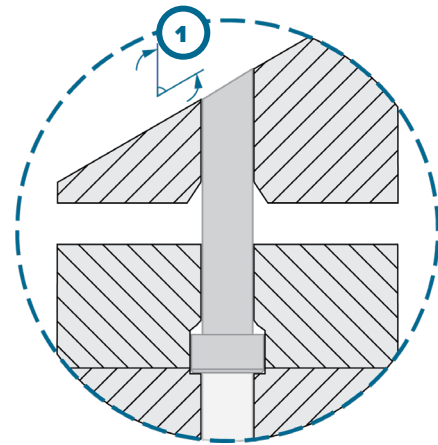
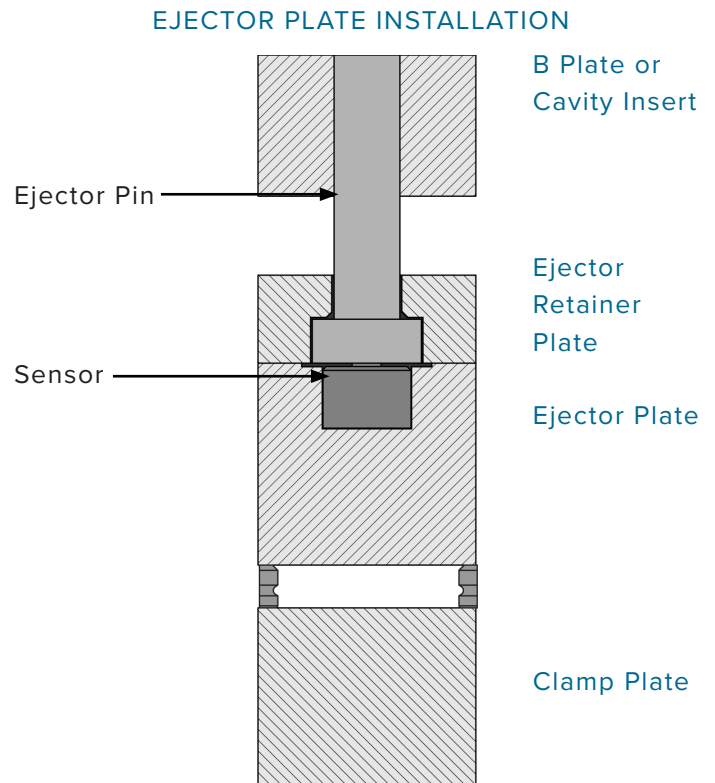
ANGLED EJECTOR PINS

Ejector pins that are located on angled surfaces of a part can utilize sensors depending on the angle of the pin. The maximum pin angle that can be used with sensors is 30° (1 *at right*). Beyond 30°, force is lost to friction as the pin is pushed sideways against the mold steel instead of directly back onto the sensor, which in turn can create errors in sensor readings. If the angle is greater than 30°, contact RJG customer support for assistance in verifying suitability for use with an RJG sensor (refer to “Customer Support” on page 54).

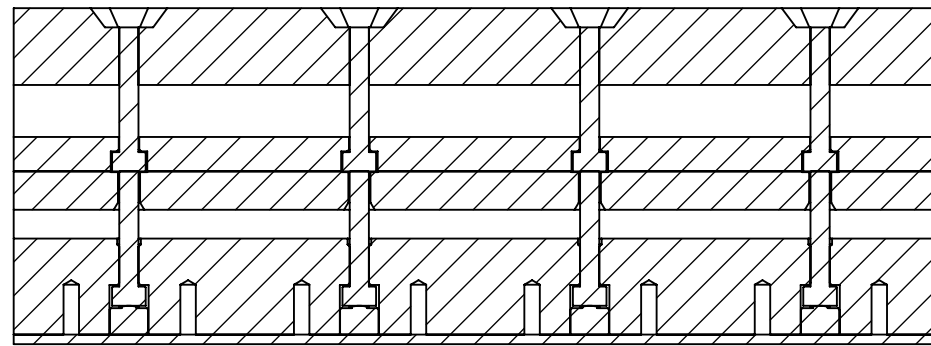
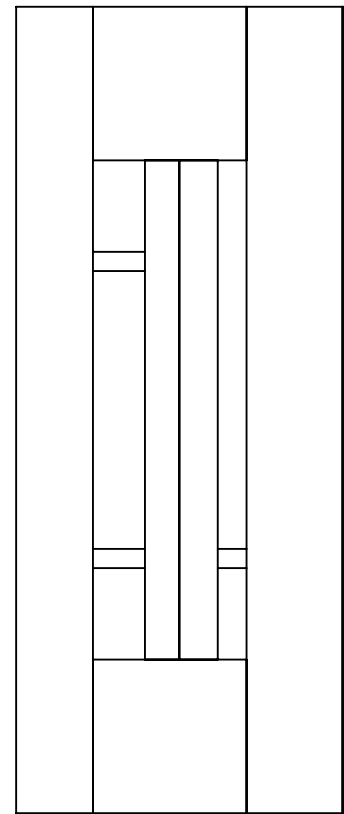
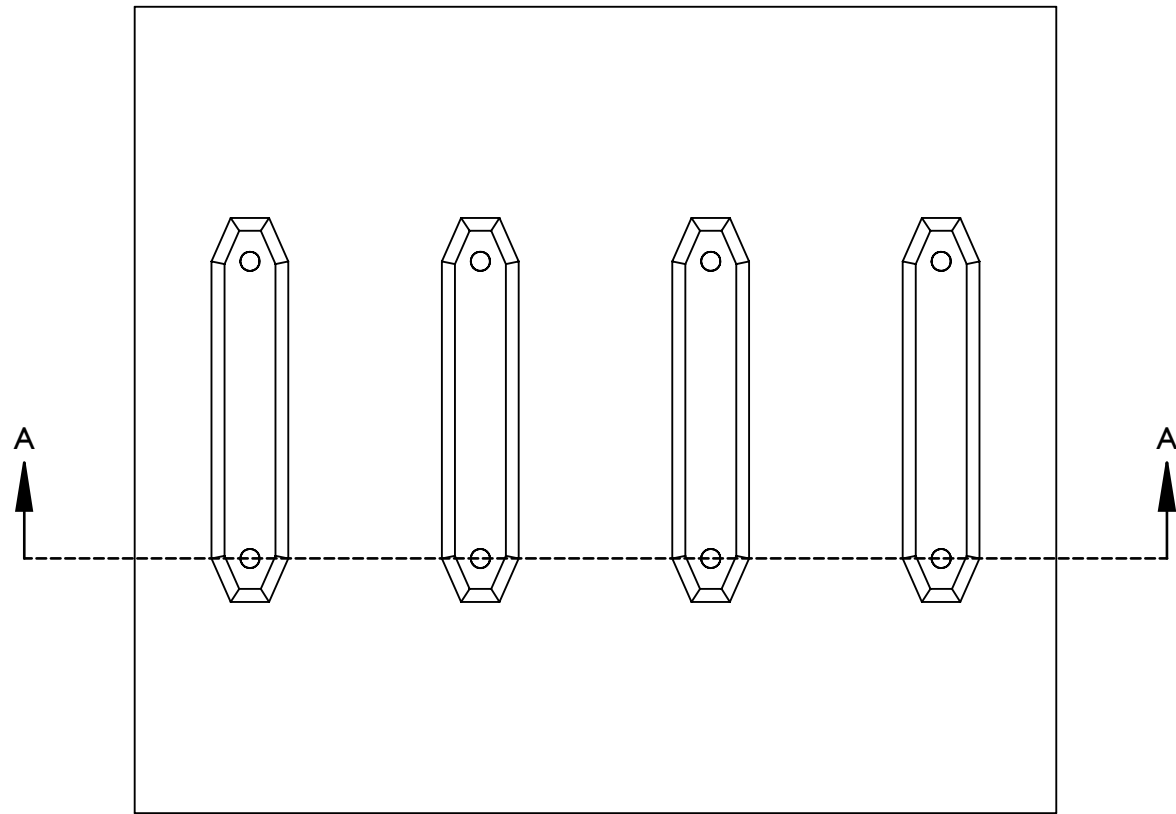
CONTOURED EJECTOR PINS

Ejector pins that are located on contoured surfaces of a part can be used on either concave and convex surfaces (2 *at right*) provided the shape of the contour is symmetric, as this cancels out any sideways forces generated by cavity pressure pushing on the pin.

Do not use an asymmetrically-contoured ejector pin if the net contour is greater than a comparable pin with a 30° angle. If a contour is unique or asymmetrical, contact RJG customer support for assistance in verifying suitability for use with an RJG sensor (refer to “Customer Support” on page 54).

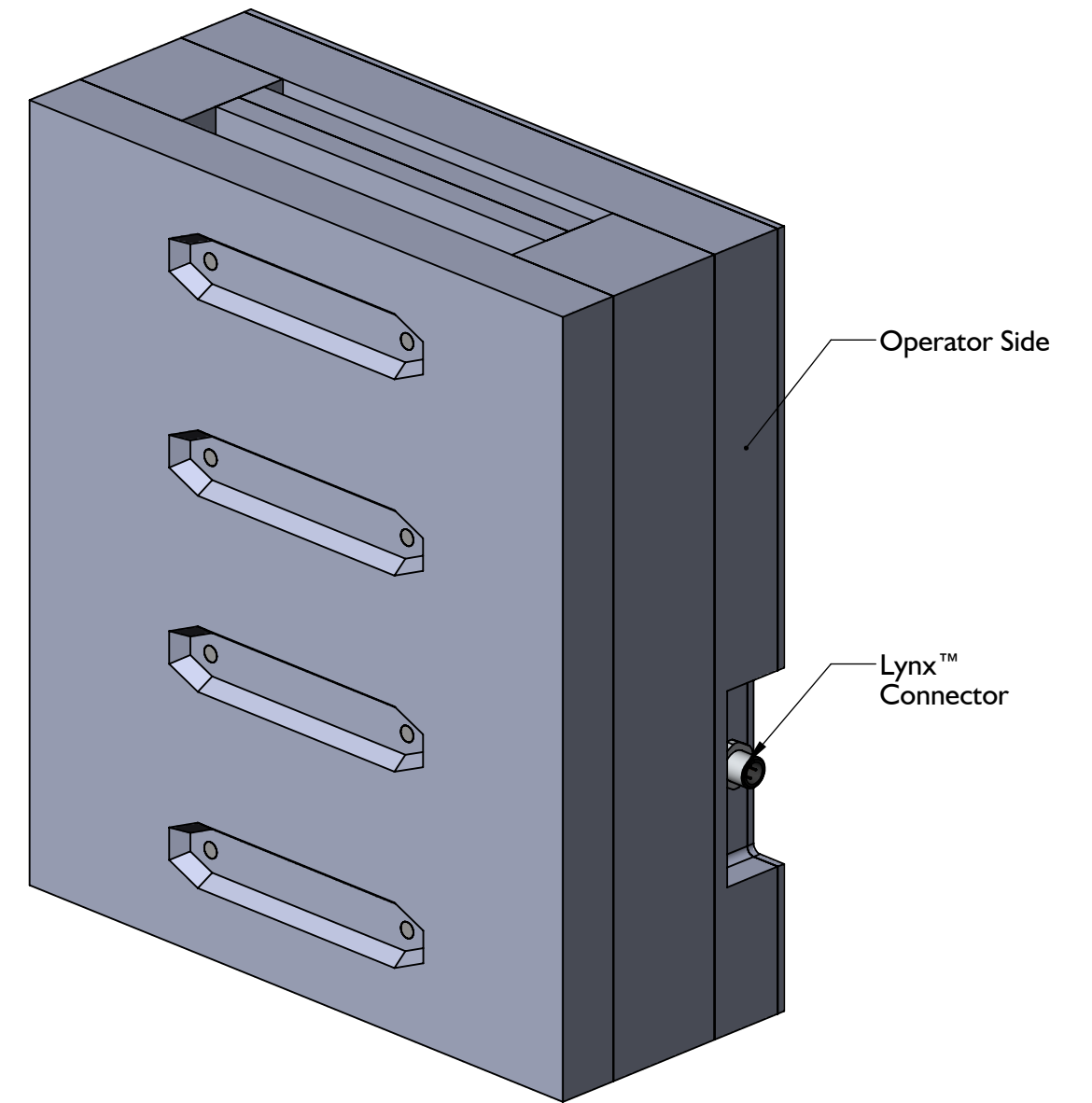


INSTALLATION SPECIFICATIONS
CLAMP PLATE (TYPICAL) INSTALLATION

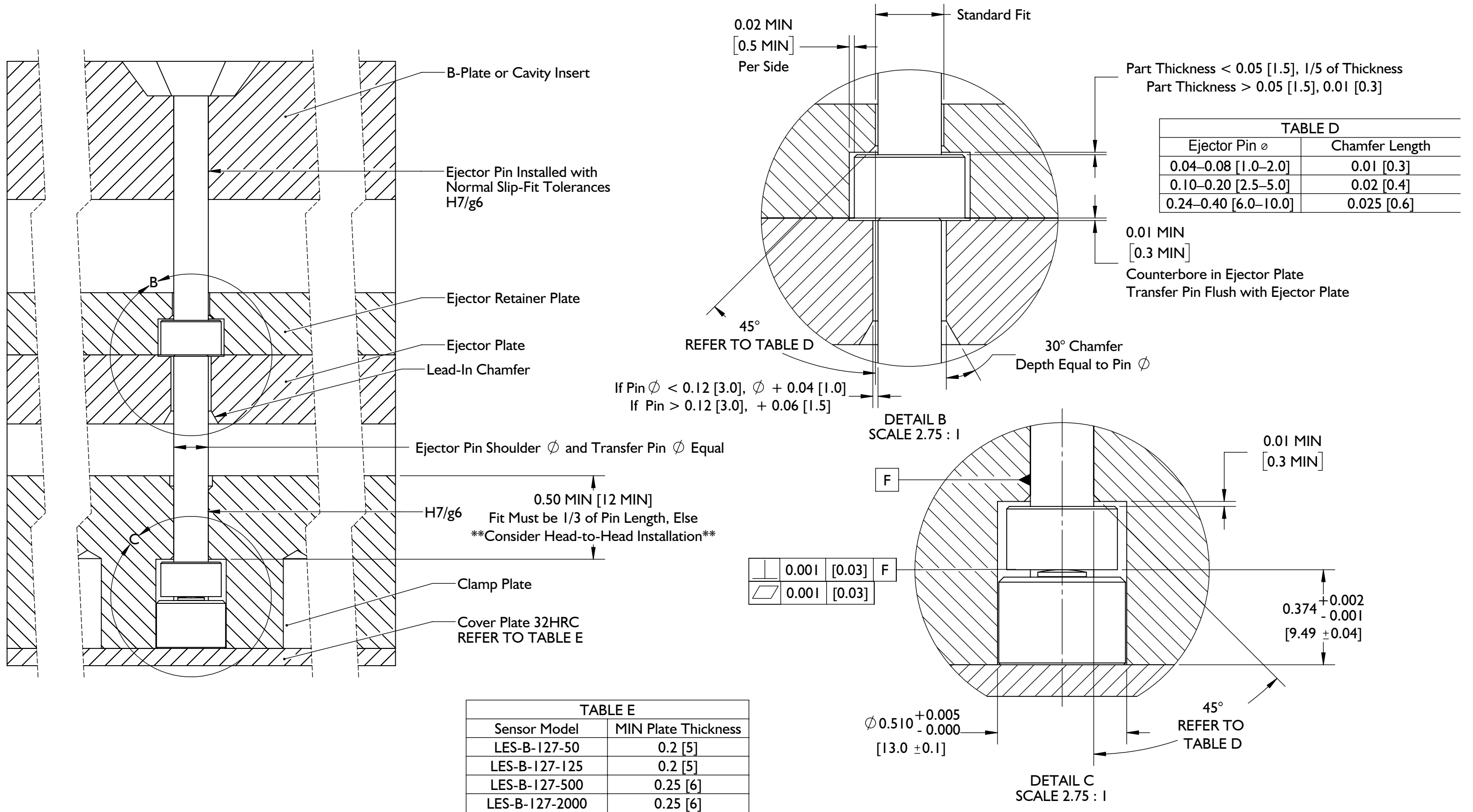


SECTION A-A
SCALE 1 : 2.5

NOTES:



INSTALLATION SPECIFICATIONS (continued)
CLAMP PLATE (TYPICAL) INSTALLATION



INSTALLATION SPECIFICATIONS (continued)

1. Sensor Head Pocket

Sensor and transfer pin head pockets are machined into the clamp plate. The sensor pockets must be centered under the selected ejector pin measuring 0.510" +0.005/-0.0 (13,00 mm ±0,10 [1 at right]) DIA, and 0.374" +0.002/-0.001 (9,49 mm ±0,01 [2 at right]) deep.

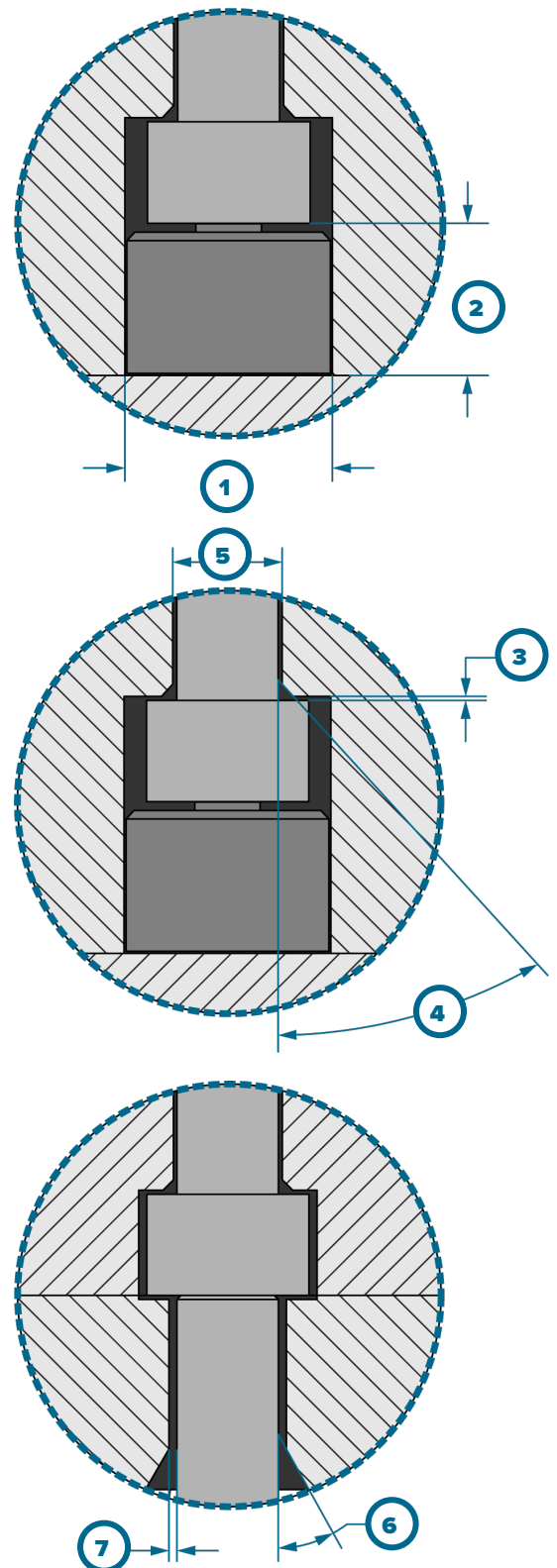
2. Transfer Pin Head Pocket

Choose an ejector and transfer pin appropriate for the application (refer to "Sensor and Ejector Pin Size" on page 2). Ejector and transfer pin must be concentric within 0.030" (0,76 mm) or 10% of ejector pin diameter—whichever is smaller. Ejector and transfer pin diameter 0.25" (7,0 mm) MAX, and must be equal in diameter.

Transfer pin head pockets must be centered under the selected ejector pin measuring the transfer pin head height plus a clearance of 0.01" (0,3 mm [3 at right]) MIN. Chamfer the transfer pin head pocket at 45° [4 at right] to the lead-in of clamp plate, and fit the pin with an H7/g6 fit [5 i at right] for at least 0.50" (12,0 mm) MIN.

Chamfer the lead-in at 30° [6 at right] to the ejector plate for a depth which equals the transfer pin DIA, and provide clearance for the transfer pin in the ejector plate equal to pin DIA plus 0.04" (1,0 mm) if pin DIA is < 0.12" (3,0 mm), or 0.06" (1,5 mm) if pin DIA is > 0.12" (3,0 mm). Transfer pin must be 0.01" (0,3 mm) longer than nominal for initial fit, then adjusted to obtain the correct height.

CLAMP PLATE (TYPICAL) INSTALLATION



NOTES

There must be 0.50" (12,0 mm) MIN clamp plate thickness above the transfer pin head to transfer pin clearanced exit, equaling 1/3 of the pin length; if 1/3 pin length not possible in clamp plate thickness, use head-to-head concept on page 10.

1	0.510" +0.005/-0.0 (13,0 mm ±0,10) DIA
2	0.374" +0.002/-0.001 (9,49 mm ±0,01)
3	0.01" (0,3 mm) MIN
4	45° Chamfer
5	H7/g6 for 0.50" (12,0 mm) MIN i
6	30° Chamfer, Depth=Pin DIA
7	If Pin DIA < 0.12" (3,0 mm), + 0.04" (1,0 mm); If Pin DIA > 0.12" (3,0 mm), + 0.06" (1,5 mm)

INSTALLATION SPECIFICATIONS (continued)

3. Ejector Pin Head Pocket

Machine a pocket for the ejector pin head in the ejector retainer plate that is equal to the ejector pin head DIA plus 0.02" (0,5 mm [1 at right]) MIN per side.

Allow clearance above the ejector pin head. If the part thickness is < 0.05" (1,5 mm), the clearance should equal 20% of the part thickness. If the part thickness is > 0.05" (1,5 mm), the clearance should equal 0.01" (0,3 mm [2 i at right]).

NOTES *Ejector pin head clearance not to exceed 20% (1/5th) of part thickness at point of pin/part convergence.*

Chamfer the lead-in edge 45° (3 at right)—refer to the following table for chamfer length.

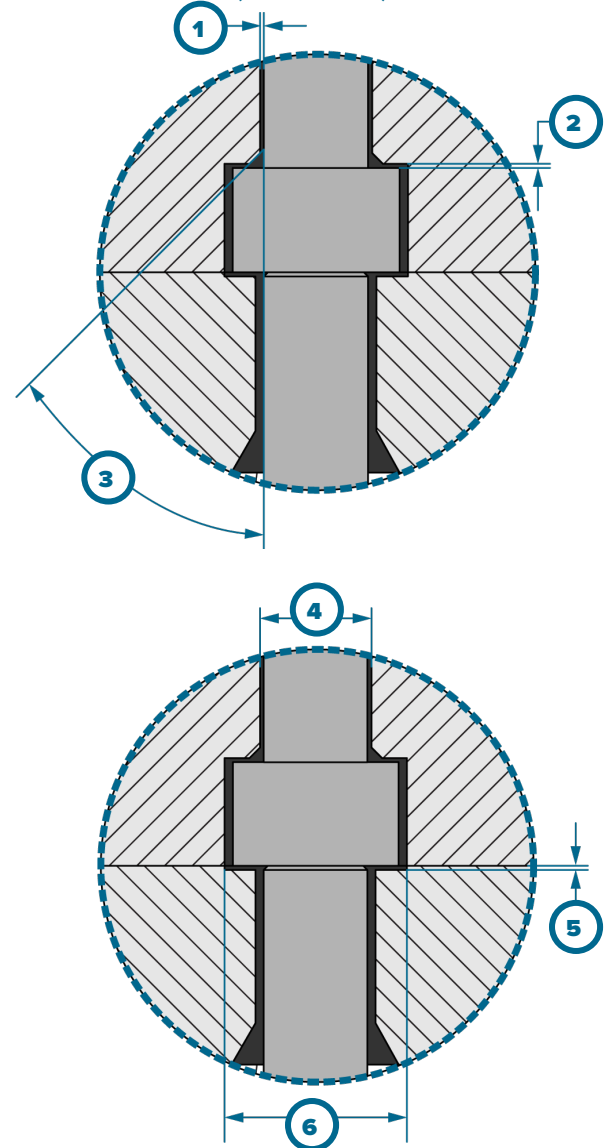
CHAMFER LENGTH

Ejector Pin DIA	Chamfer Length
0.04–0.08 (1,0–2,0 mm)	0.01 (0,3 mm)
0.10–0.20 (2,5–5,0 mm)	0.02 (0,4 mm)
0.24–0.40 (6,0–10,0 mm)	0.025 (0,6 mm)

Fit the ejector pin with an H7/g6 standard fit (4 at right).

Counterbore the ejector pin head pocket into the ejector plate 0.01" (0,3 mm [5 at right]) MIN deep, by ejector pin head DIA + 0.04" (1,0 mm [6 at right]).

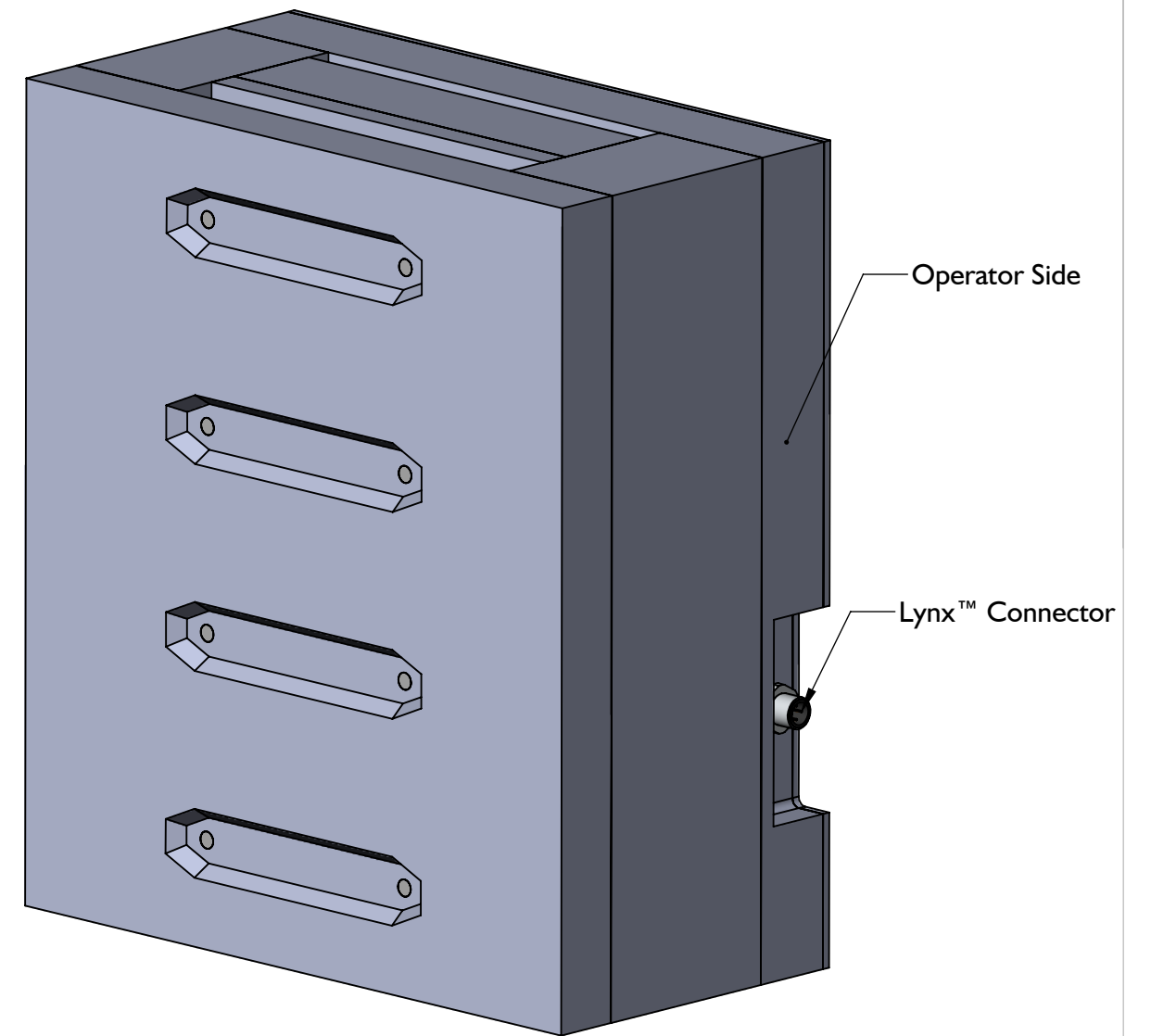
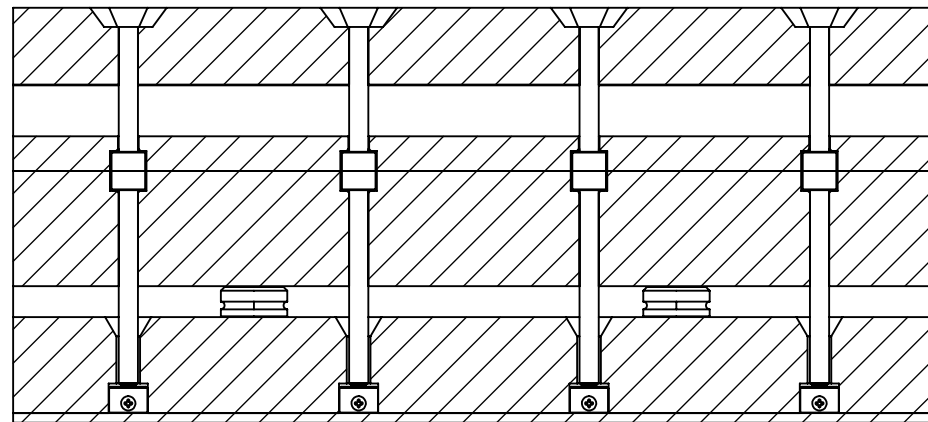
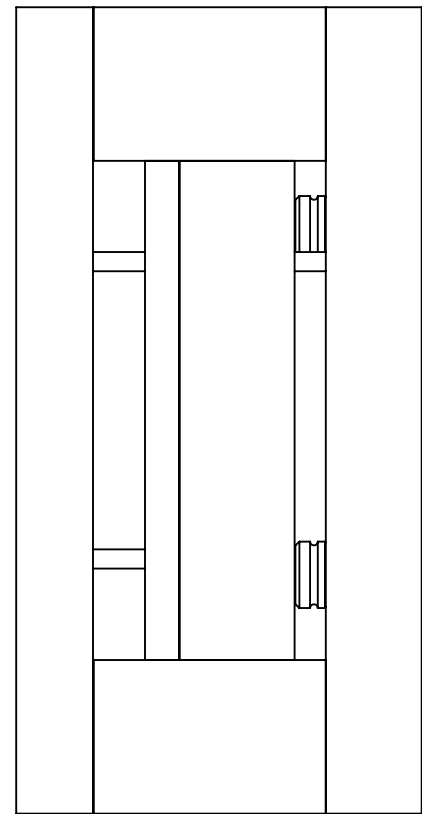
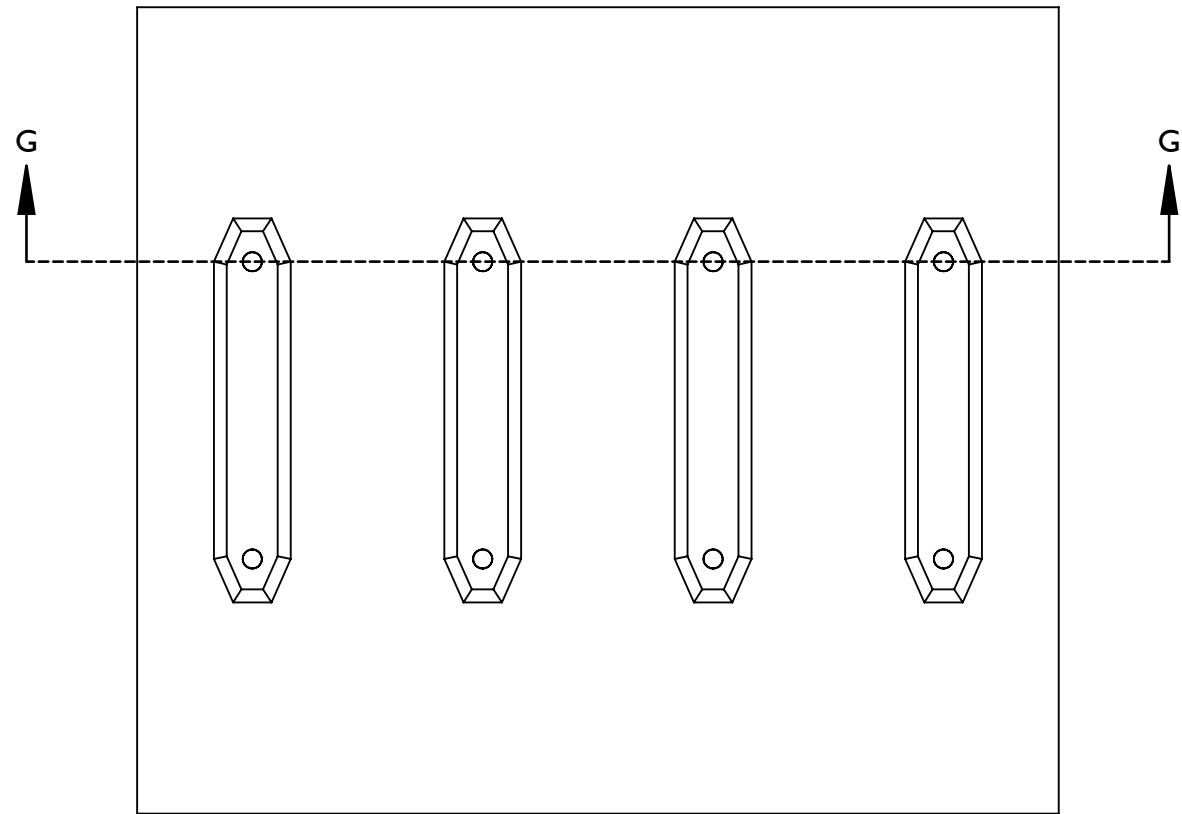
CLAMP PLATE (TYPICAL) INSTALLATION



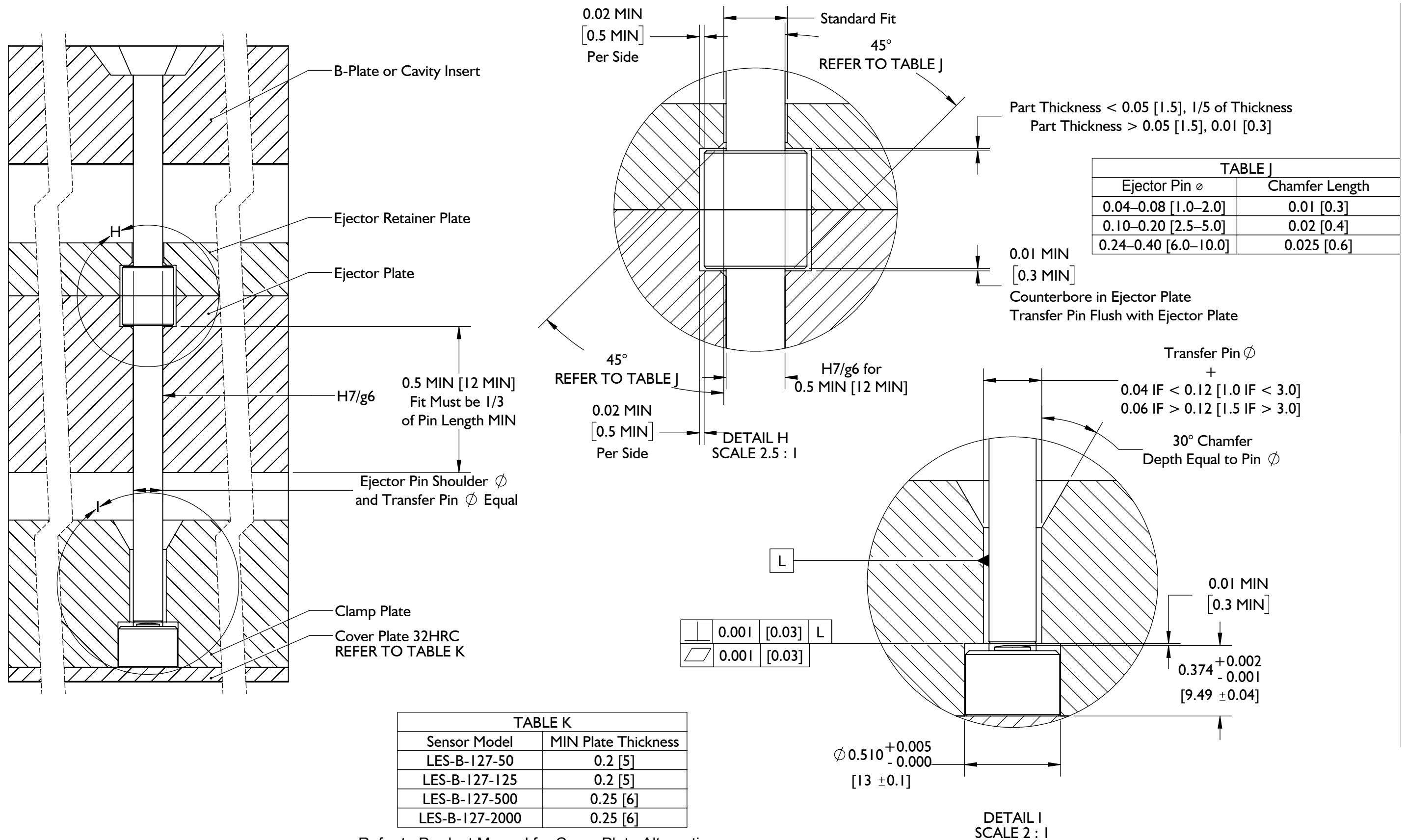
CAUTION *Transfer pin applications require guided ejection; failure to comply may result in damage to or destruction of components.*

1	0.02" (0,5 mm) MIN per side
2	20% part thickness if < 0.05" (1,5 mm), 0.01" (0,3 mm) if part thickness > 0.05" (1,5 mm) i
3	45° Chamfer, refer to table for chamfer length
4	H7/g6 standard fit
5	0.01" (0,3 mm) MIN
6	ejector pin head DIA + 0.04" (1,0 mm)

INSTALLATION SPECIFICATIONS (continued)
CLAMP PLATE (HEAD-TO-HEAD) INSTALLATION



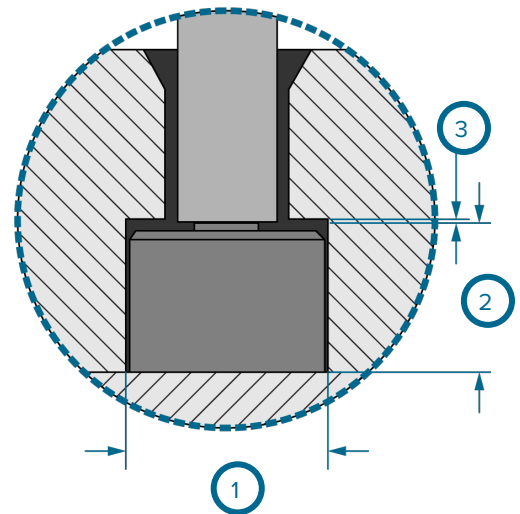
INSTALLATION SPECIFICATIONS (continued)
CLAMP PLATE (HEAD-TO-HEAD) INSTALLATION



Refer to Product Manual for Cover Plate Alternatives

1. Sensor Head Pocket

Sensor head pockets are machined into the clamp plate. The sensor pockets must be centered under the selected ejector pin measuring 0.510" +0.005/-0.0 (13,0 mm ±0,10 [1 at right]) DIA, and 0.374" +0.002/-0.001 (9,49 mm ±0,04 [2 at right]) deep, with an added clearance of 0.01" (0,3 mm [3 at right]) MIN above the sensor head.

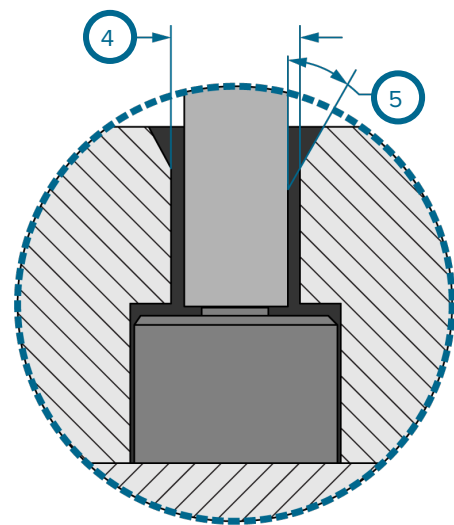


2. Transfer Pin Shaft Pocket

Choose an ejector and transfer pin appropriate for the application (refer to “Sensor and Ejector Pin Size” on page 2). Ejector and transfer pin must be concentric within 0.030" (0,76 mm) or 10% of ejector pin diameter—whichever is smaller. Ejector and transfer pin must be equal in diameter.

Transfer pin pockets must be centered under the selected ejector pin.

Machine a pocket for the transfer pin shaft from the sensor head pocket through the clamp plate equaling the transfer pin DIA plus 0.04" (1,0 mm) if pin DIA is < 0.12" (3,0 mm) DIA, or 0.06" (1,5 mm) if pin DIA is > 0.12" (3,0 mm [4 at right]).



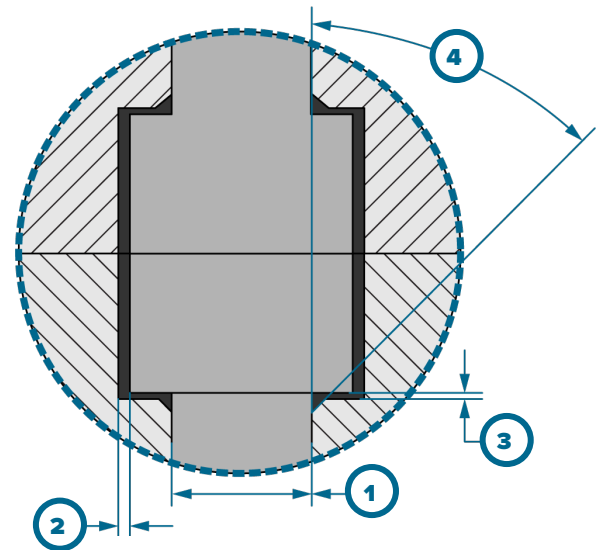
Chamfer the transfer pin head pocket at 30° (5 at right) for a depth equal to the pin diameter at exit of clamp plate.

1	0.510" +0.005/-0.0 (13,0 mm ±0,10) DIA
2	0.374" +0.002/-0.001 (9,49 mm ±0,04)
3	0.01" (0,3 mm) MIN
4	transfer pin DIA + 0.04" (1,0 mm) if < 0.12" (3,0 mm), OR + 0.06" (1,5 mm) if > 0.12" (3,0 mm)
5	30° Chamfer, Depth = Pin DIA

3. Transfer Pin Shaft and Head Pocket

Machine a pocket for the transfer pin shaft in the ejector plate with an H7/g6 fit for 0.5" (12 mm [1 at right]) MIN.

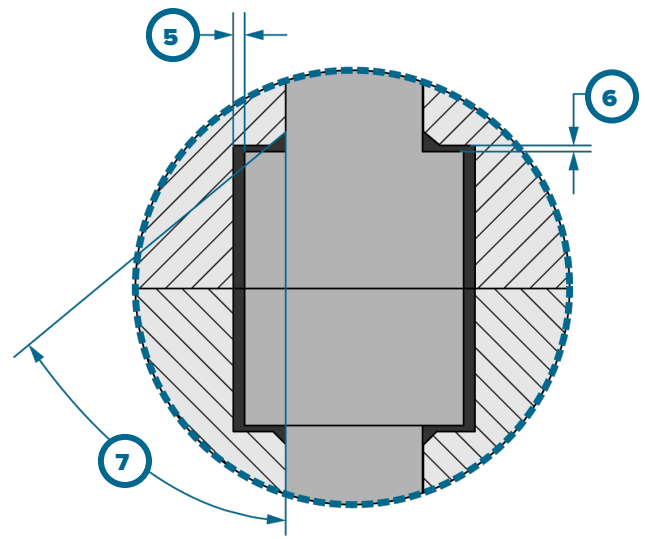
Machine a pocket for the transfer pin head in the ejector plate that is equal to the transfer pin head DIA plus 0.02" (0,5 mm [2 at right]) MIN per side. Allow 0.01" (0,3 mm [3 at right]) MIN clearance below pin head. Chamfer the transfer pin head pocket at 45° (4 at right).



4. Ejector Pin Head Pocket

Machine a pocket for the ejector pin head in the ejector retainer plate that is equal to the ejector pin head DIA plus 0.02" (0,5 mm [5 at right]) MIN per side.

Allow clearance above the ejector pin head. If the part thickness is < 0.05" (1,5 mm), the clearance should equal 20% of the part thickness. If the part thickness is > 0.05" (1,5 mm), the clearance should equal 0.01" (0,3 mm [6 i at right]).



NOTES Ejector pin head clearance not to exceed 20% (1/5th) of part thickness at point of pin/part convergence.

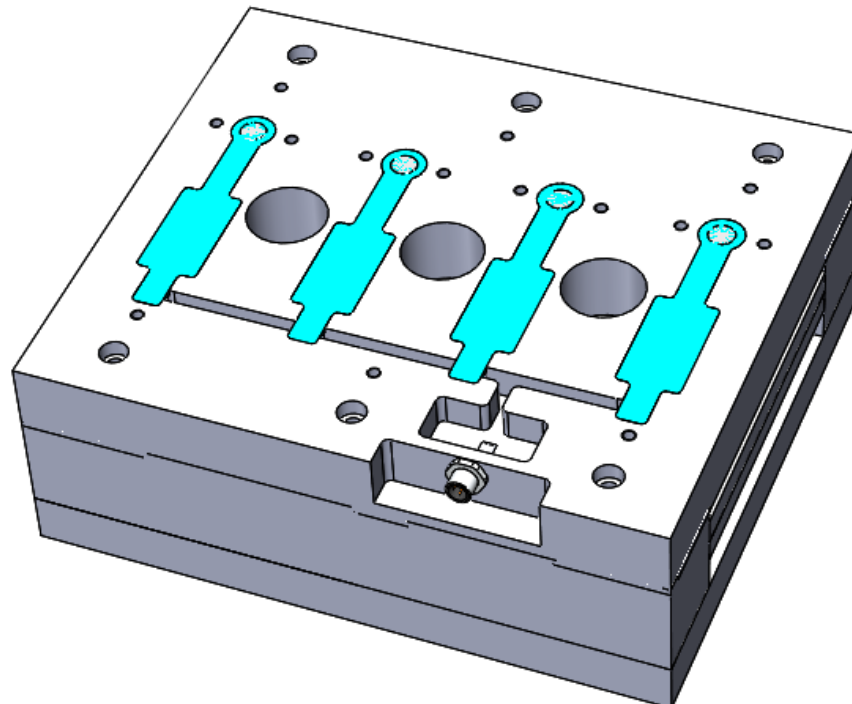
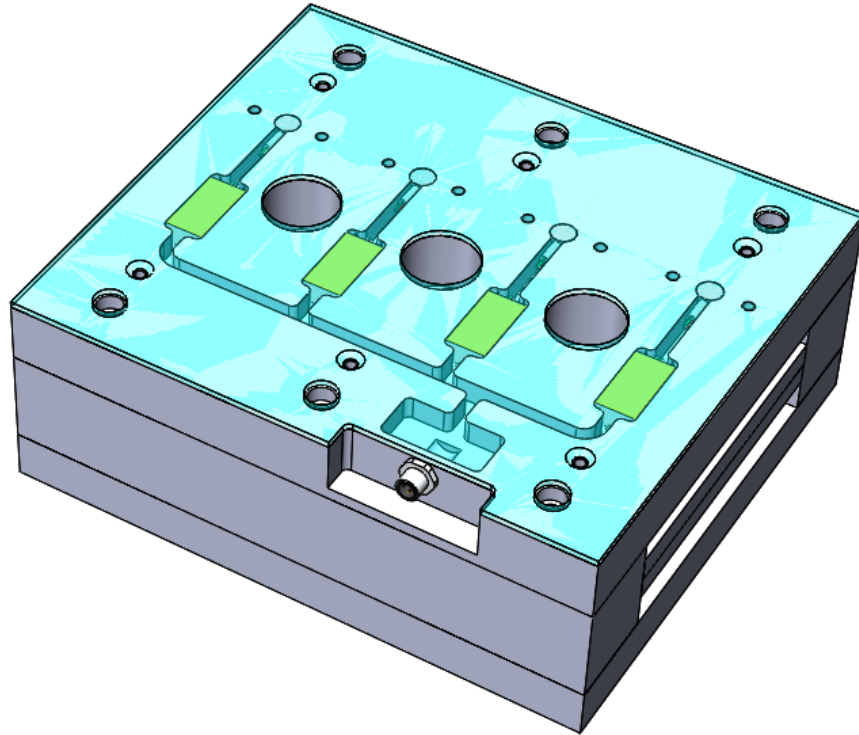
Chamfer the lead-in edge 45° (7 at right).

CAUTION Transfer pin applications require guided ejection; failure to comply may result in damage to or destruction of components.

1	H7/g6 for 0.5" (12 mm) MIN
2	0.02" (0,5 mm) MIN per side
3	0.01" (0,3 mm) MIN
4	45° Chamfer, refer to TABLE J on page 15
5	0.02" (0,5 mm) MIN per side
6	20% part thickness if < 0.05" (1,5 mm), 0.01" (0,3 mm) if part thickness > 0.05" (1,5 mm) i
7	45° Chamfer, refer to TABLE J on page 15

COVER PLATE—CLAMP PLATE

The cover plate must be made of SAE 1080 steel (AFNOR XC70/XC80), 32HRC. The cover plate may be an additional, whole plate added to the stack and secured with screws (*below, top*), or an integrated plate made to embed into the clamp plate and secured with screws (*below, bottom*).



INSTALLATION SPECIFICATIONS (continued)

CLAMP PLATE INSTALLATIONS

1. Cover Plate Thickness

The minimum cover plate thickness (1 at right), regardless of sensor retaining plate method, corresponds to the sensor force range model, as shown in the table below.

COVER PLATE THICKNESS MIN

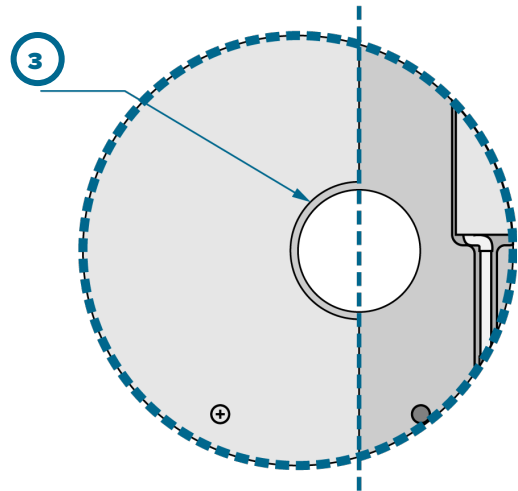
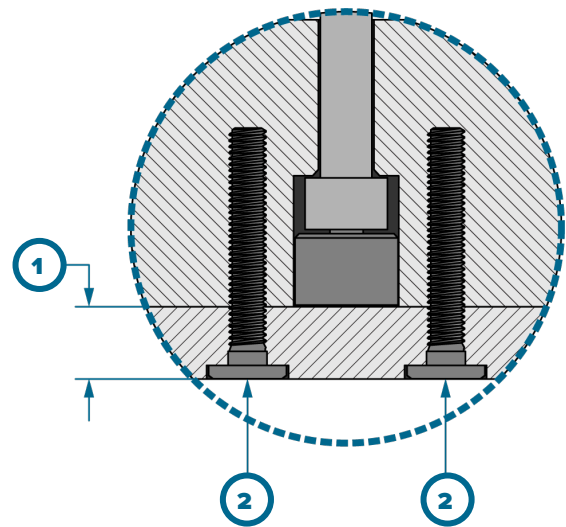
Sensor Model	Plate Thickness MIN	Fastener
LS-B-127-50	0.2" (5,0 mm)	8-36 (M4)
LS-B-127-125	0.2" (5,0 mm)	8-36 (M4)
LS-B-127-500	0.25" (6,0 mm)	10-32 (M5)
LS-B-127-2000	0.25" (6,0 mm)	10-32 (M5)

Countersink screw heads and install (2 at right) in the cover plate on each side of the sensor diameter to avoid any bending of the cover; incorporate and install other screws as necessary to secure cover. RJG recommends the use of 8-36 or 10-32 (M4 or M5).

NOTES Countersink screw heads for cover plate fasteners to prevent head protrusion from plate.

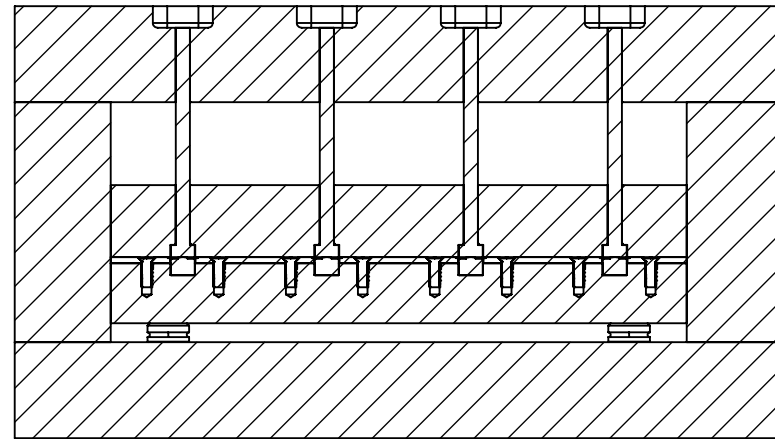
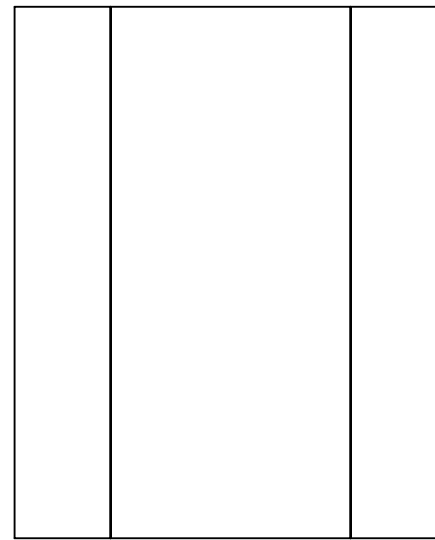
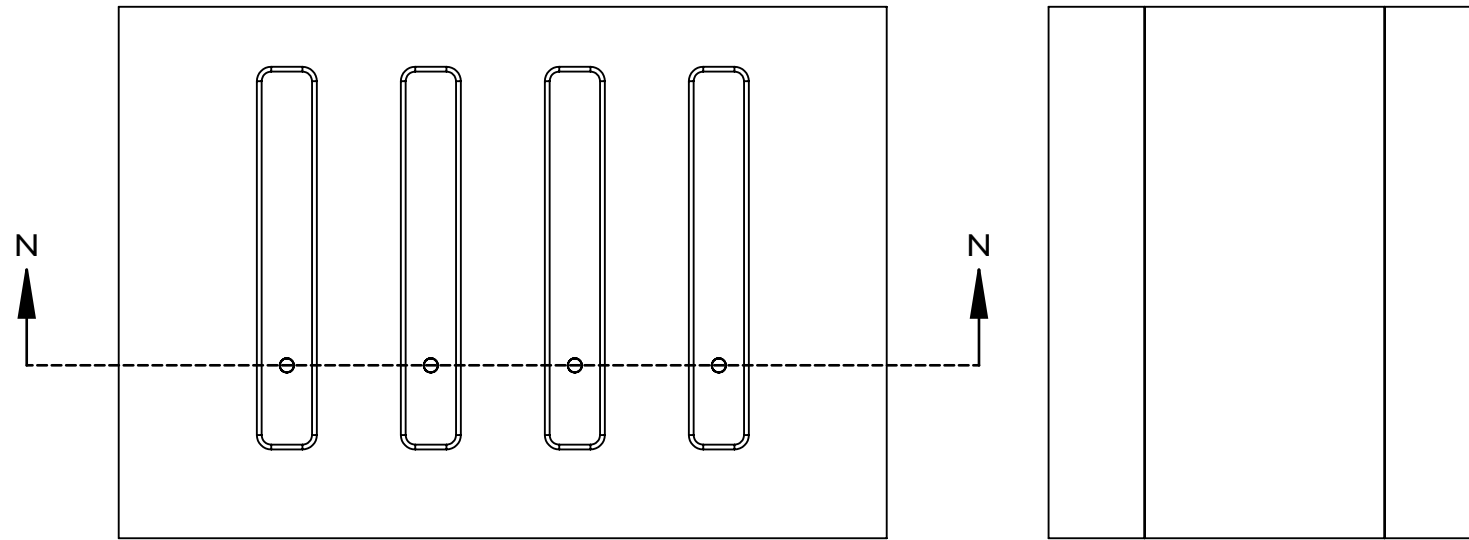
2. Clearance for Support Pillars and Components

Provide clearance in the cover plate for support pillars and other components equal to DIA + 0.50" (12,0 mm [3 at right]). Clamp plate cover design is determined by customer. Contact RJG customer support (see page 54 for contact information) for questions.

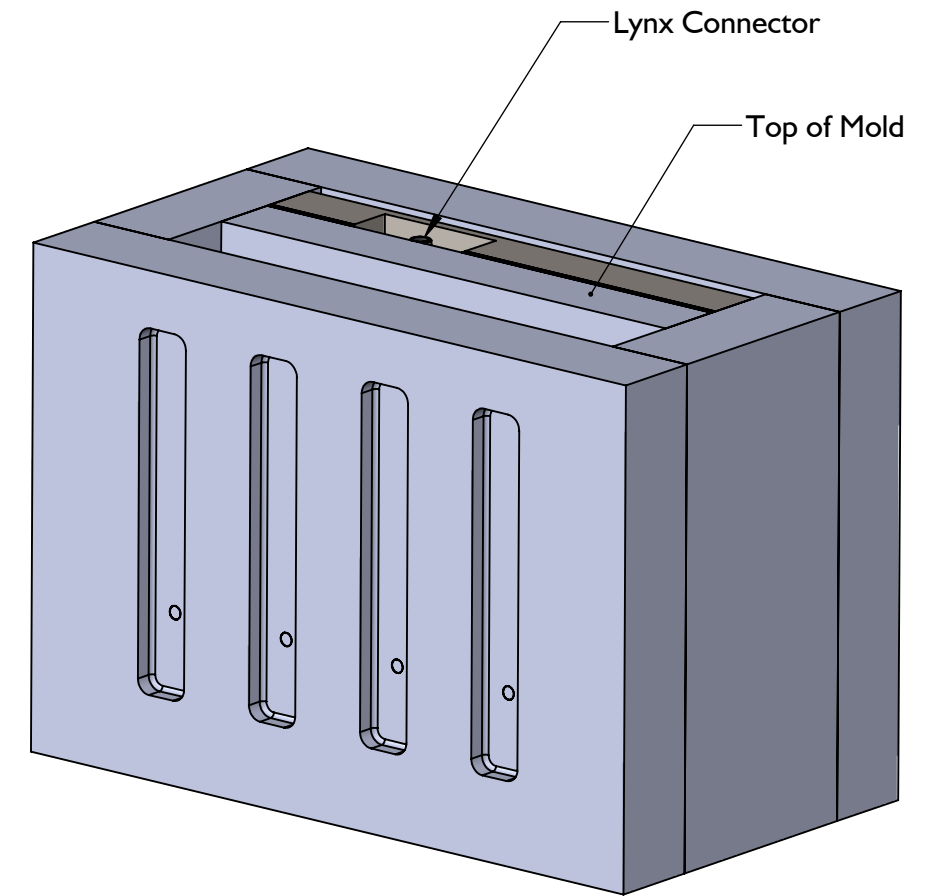


- 1 Cover Plate Thickness, MIN (refer to table)
- 2 Cover Plate Screws 8-36 or 10-32 (M4 or M5)
- 3 Clearance = DIA + 0.50" (12,0 mm)

EJECTOR PLATE INSTALLATION

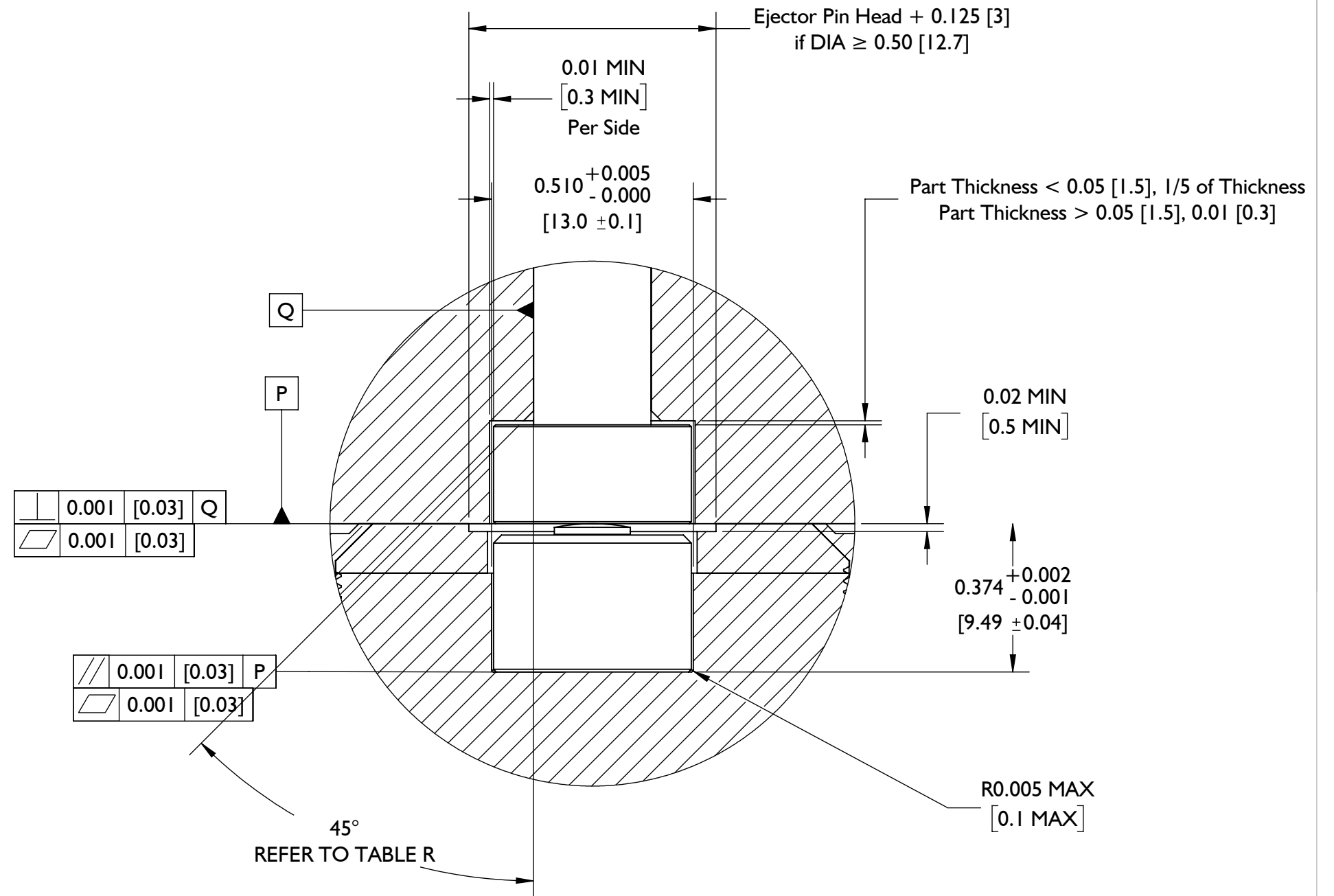
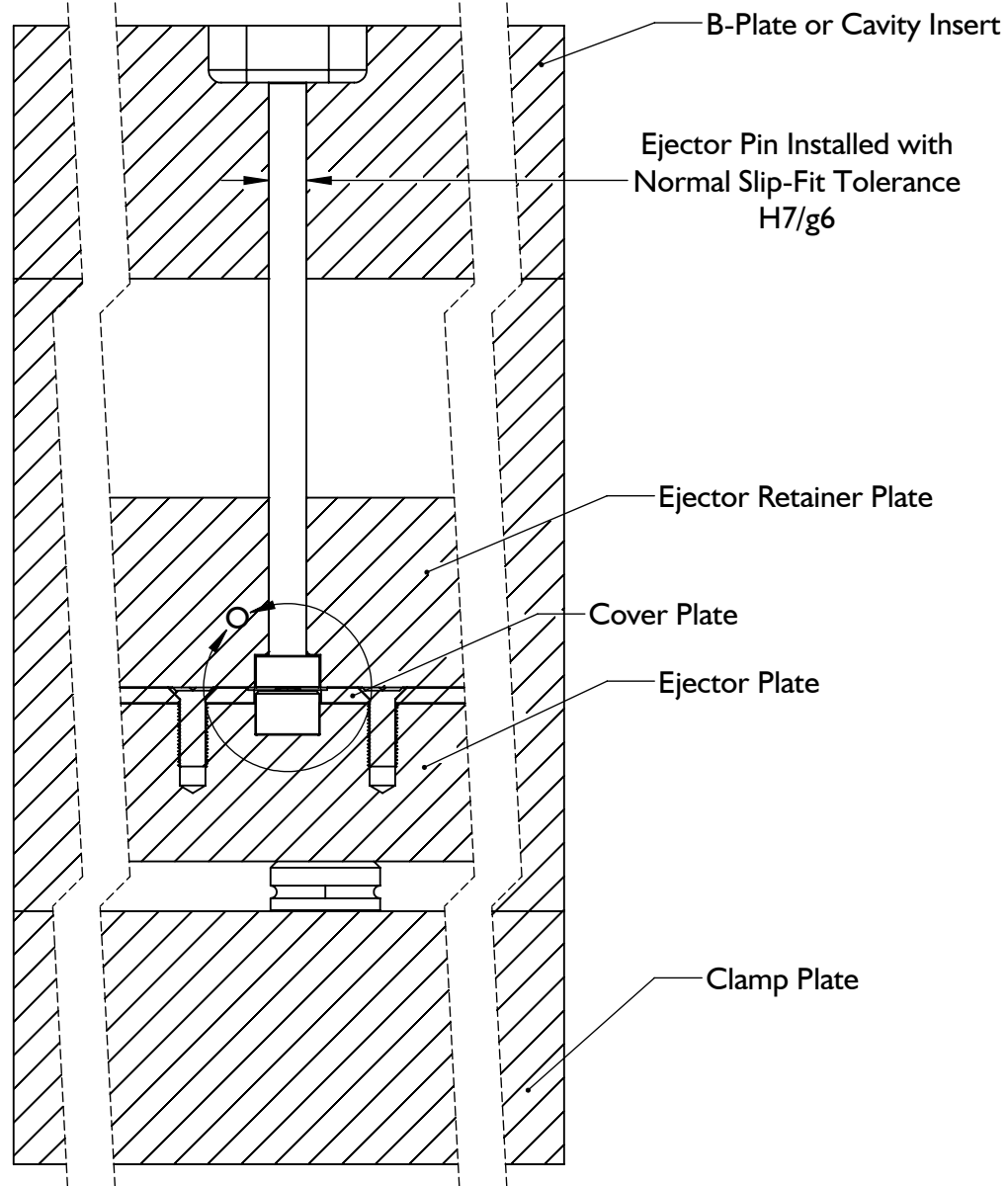


SECTION N-N



INSTALLATION SPECIFICATIONS (continued)

EJECTOR PLATE INSTALLATION



	0.001	[0.03]	Q
	0.001	[0.03]	

	0.001	[0.03]	P
	0.001	[0.03]	

Ejector Pin \varnothing	Chamfer Length
0.04–0.08 [1.0–2.0]	0.01 [0.3]
0.10–0.20 [2.5–5.0]	0.02 [0.4]
0.24–0.40 [6.0–10.0]	0.025 [0.6]

DETAIL O
SCALE 3 : 1

INSTALLATION SPECIFICATIONS (continued)

1. Sensor Pocket Machining

Sensor pockets are machined into the cover and ejector plates. The pockets must be centered under the selected ejector pin measuring 0.510" +0.005/-0.0 (13,0 mm +/- 0,10 [1 at right]) DIA, and 0.375" +0.003/-0.0 (9,49 mm +/- 0,01 [2 at right]) deep. In the cover plate, the pocket must equal the ejector pin DIA plus 0.10" (2,54 mm) if the DIA is greater than 0.50" (12,7 mm [3 at right]).

- Use a 5/16" "dead sharp" end mill to achieve correct radius—sensor pocket corner radius MAX R 0.005" (0,10 mm [4 at right]).

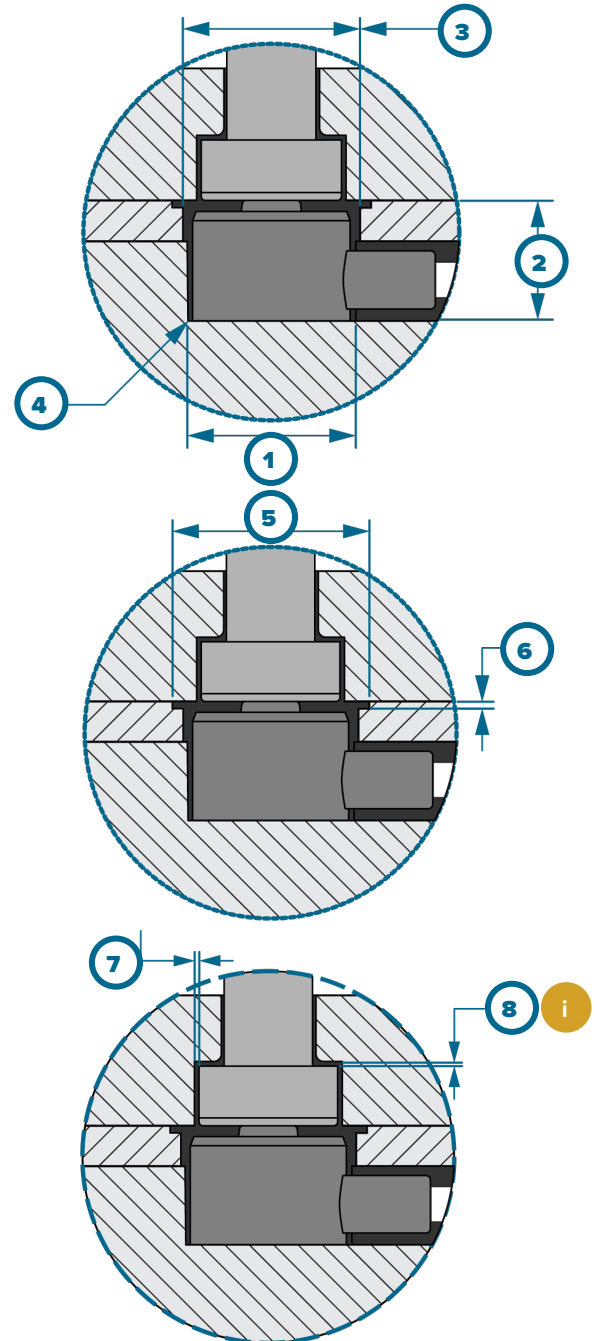
Additionally, if the ejector pin head DIA is greater than 0.50" (12,7 mm), machine a counterbore into the cover and ejector plates equal to the ejector pin DIA plus 0.125" (3 mm) MIN by 0.02" (0,5 mm) MIN deep to allow the head of the ejector pin to clear the plate and rest only on the sensor when under pressure (5 & 6 at right).

2. Ejector Pin Pocket

Choose an ejector pin appropriate for the application (refer to "Sensor and Ejector Pin Size" on page 2). Machine a pocket for the ejector pin head in the ejector retainer plate that is equal to the ejector pin head DIA plus 0.01" (0,3 mm [7 at right]) MIN per side by ejector pin height plus 0.01" (0,3 mm [8 i at right]) MIN to eliminate potential preload on the sensor when installed.

Hole basis for ejector pins is ISO standard clearance fit H7g6—H7g6 is a sliding fit suitable for precision location fits.

EJECTOR PLATE INSTALLATION



NOTES

Ejector pin head clearance not to exceed 20% (1/5th) of part thickness at point of pin/part convergence

1 \varnothing 0.510" +0.005/-0.0 (12,95 mm \pm 0,10)

2 0.374" +0.002/-0.001 (9,49 mm \pm 0,01)

3 Ejector Pin DIA + 0.10" (2,54 mm) if Ejector Pin DIA > 0.50" (12,7 mm)

4 0.005" (0,10 mm) MAX R.

5 Pin Head DIA + 0.125" (3 mm), IF DIA \geq 0.50" (12,7 mm)

6 0.02" (0,5 mm) MIN

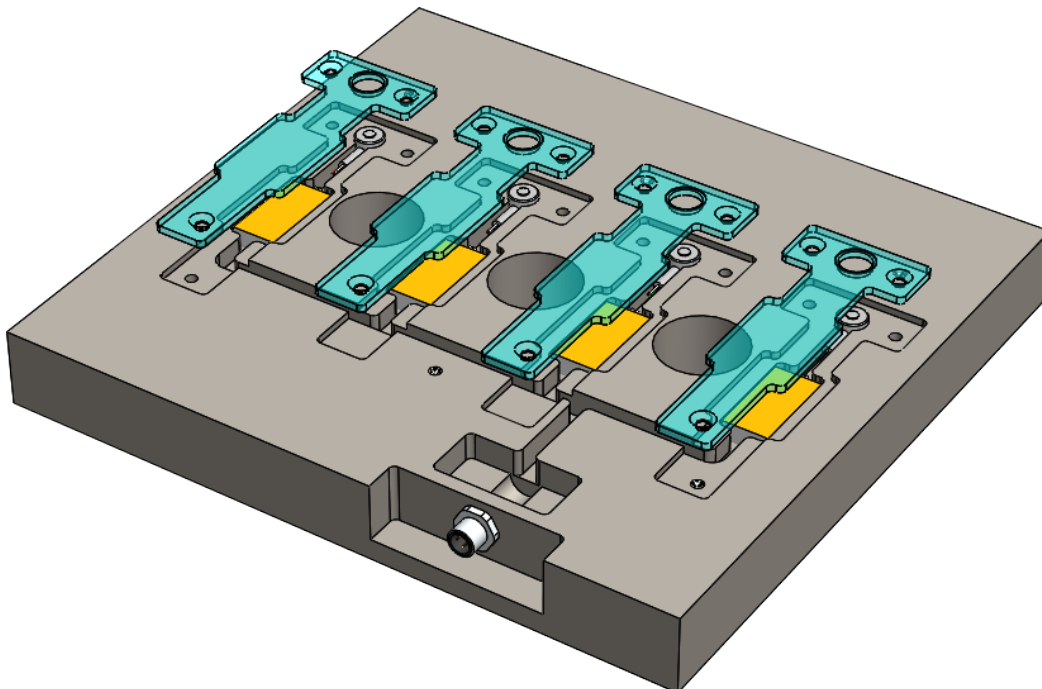
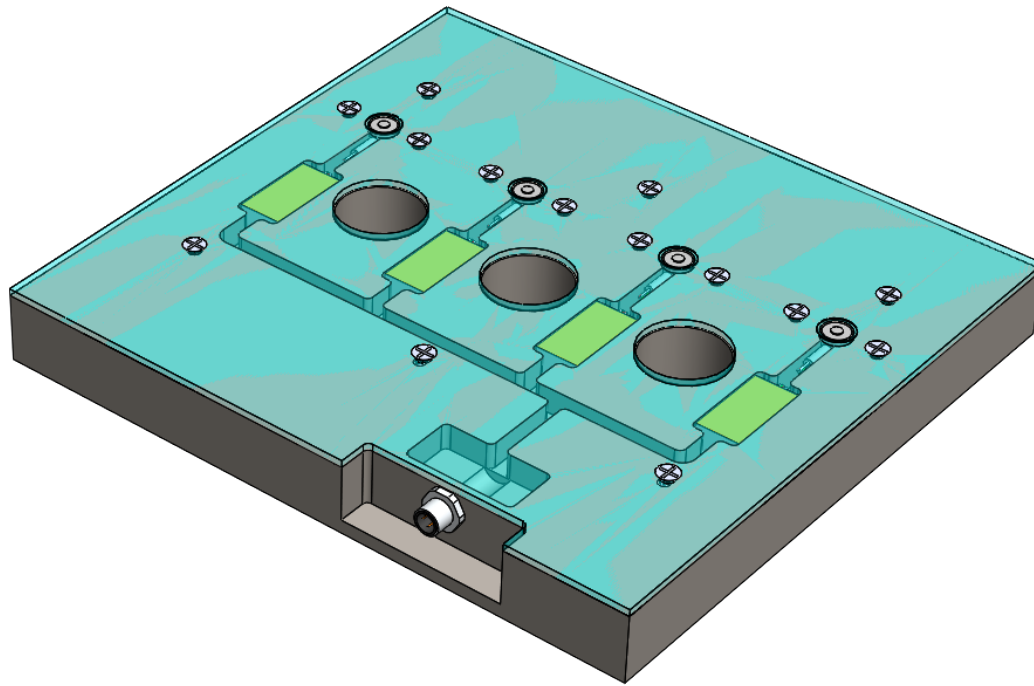
7 0.01" (0,3 mm) MIN per side

8 20% part thickness if \leq 0.05" (1,5 mm), 0.01" (0,3 mm) if part thickness > 0.05" (1,5 mm) i

INSTALLATION SPECIFICATIONS *(continued)*

COVER PLATE—EJECTOR PLATE

The cover plate must be made of SAE 1080 steel (AFNOR XC70/XC80), 32HRC. The cover plate may be an additional, whole plate added to the stack and secured with screws (*below, top*), or an integrated plate made to embed into the ejector plate and secured with screws (*below, bottom*).



INSTALLATION SPECIFICATIONS (continued)

EJECTOR PLATE INSTALLATION

1. Cover Plate Thickness

The minimum cover plate thickness (1 at right), regardless of sensor retaining plate method, corresponds to the sensor force range model, as shown in the table below.

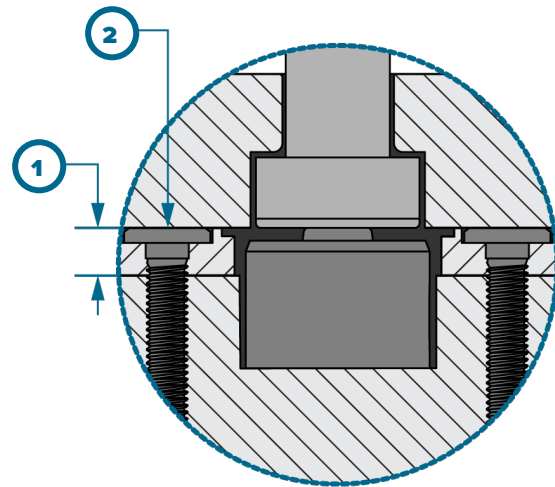
COVER PLATE THICKNESS MIN

Sensor Model	Plate Thickness MIN	Fastener
LS-B-127-50	0.2" (5,0 mm)	8-36 (M4)
LS-B-127-125	0.2" (5,0 mm)	8-36 (M4)
LS-B-127-500	0.25" (6,0 mm)	10-32 (M5)
LS-B-127-2000	0.25" (6,0 mm)	10-32 (M5)

Countersink screw heads and install (2 at right) in the cover plate on each side of the sensor diameter to avoid any bending of the cover; incorporate and install other screws as necessary to secure cover. RJG recommends the use of 8-36 or 10-32 (M4 or M5).

NOTES *Countersink screw heads for cover plate fasteners to prevent head protrusion from plate.*

- 1 Cover Plate Thickness, MIN (refer to table)
- 2 Cover Plate Screws 8-36 or 10-32 (M4 or M5)



INSTALLATION SPECIFICATIONS (continued)

LYNX CONNECTOR

1. Excess Cable Pocket

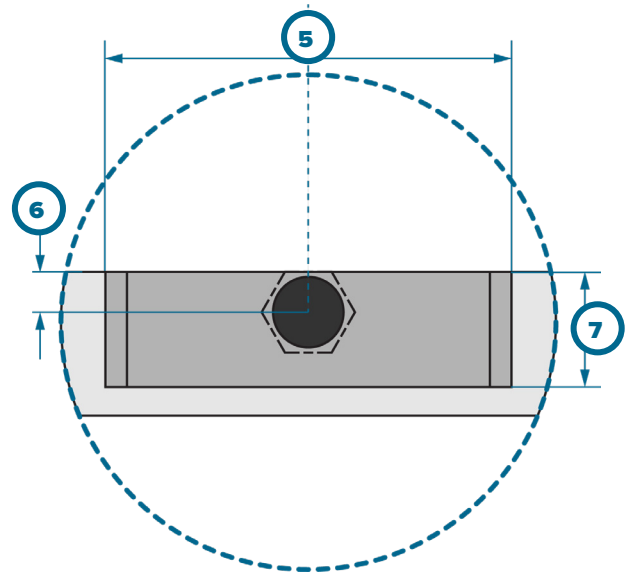
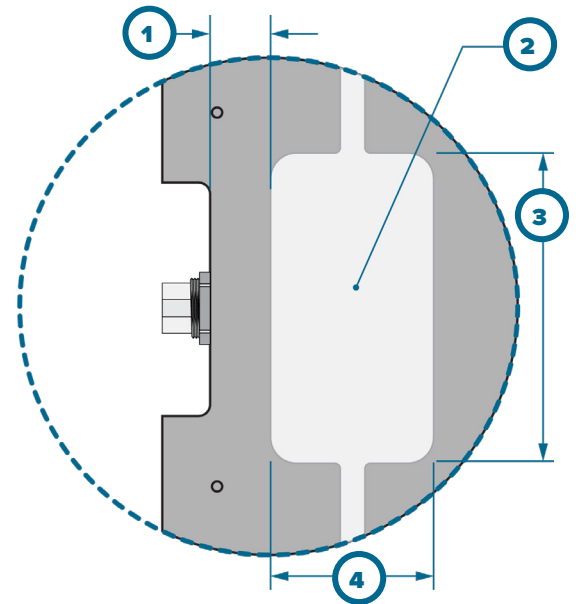
- Machine a pocket to store excess cable and connectors at the Lynx connector 0.50" MIN wide (13,0 mm MIN [4 at right]) by 2.00" MIN long (50,0 mm MIN [3 at right]) by 0.47" MIN deep (12,0 mm MIN [2 at right]).

2. Connector Thread Engagement

- The Lynx connector requires 0.25" (6,0 mm) MIN thread engagement (1 at right).
- Use a Pg9 thread (refer to "Lynx Connector and Pg9 Thread" on page 6)

3. Connector Location

- Machine the 14 mm PG-9 thread Lynx connector installation location into the clamp plate; 1.50" (19 mm [5 at right]) from center to sides, 0.35" (8,9 mm [6 at right]) MIN from top, and 1.00" (25 mm [7 at right]) deep.



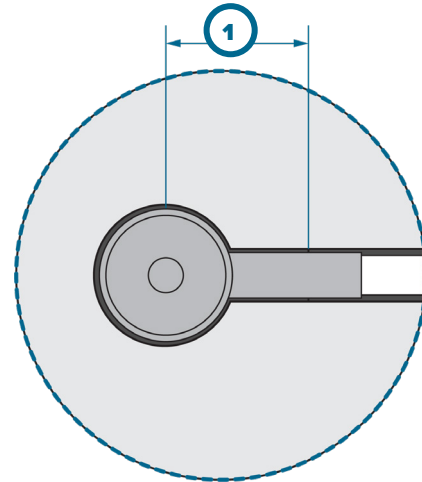
1	0.25" (6,0 mm) MIN
2	0.50" (13,0 mm) MIN
3	2.00" (50,0 mm) MIN
4	0.47" (12,0 mm) MIN
5	1.50" (38 mm)
6	0.35" (8,9 mm) MIN
7	1.00" (25 mm)

INSTALLATION SPECIFICATIONS (continued)

SENSOR CABLES

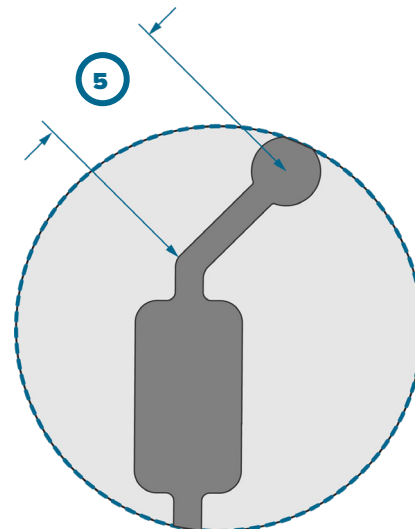
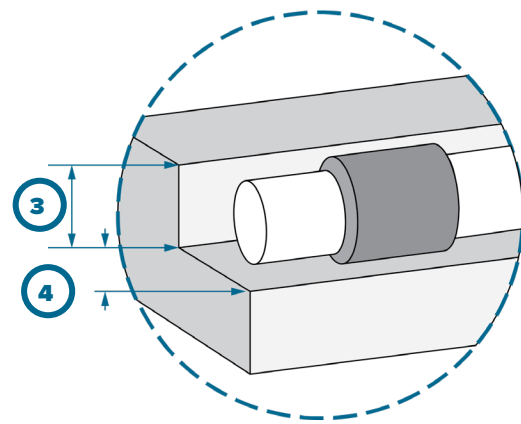
1. Sensor Cable Channel

- Machine a cable channel pocket depth of 0.375" (9,53 mm [**2** *not shown*]) for 0.50" (12,7 mm [**1** *at right*]) from center of sensor head.
- Machine remaining cable channels width of 0.25" (6,0 mm [**4** *at right*]) and depth of 0.466" (12 mm [**3** *at right*]).



2. Sensor Cable Bend

- The sensor cable must not be bent within 1.00" (25 mm [**5** *at right*]) MIN of sensor head center, or within 1.6" (40 mm) MIN if pin DIA is less than 3/32" (2,5 mm).



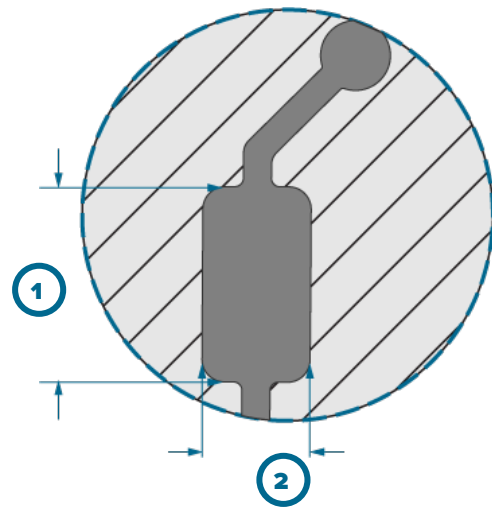
1	0.50" (12,7 mm)
2	0.375" (9,53 mm) <i>not shown</i>
3	0.466" (12 mm)
4	0.25" (6,0 mm)
5	1.00" (25 mm), or 1.6" (40 mm) for Pin $\varnothing < 3/32"$ (2,5 mm)

INSTALLATION SPECIFICATIONS *(continued)*

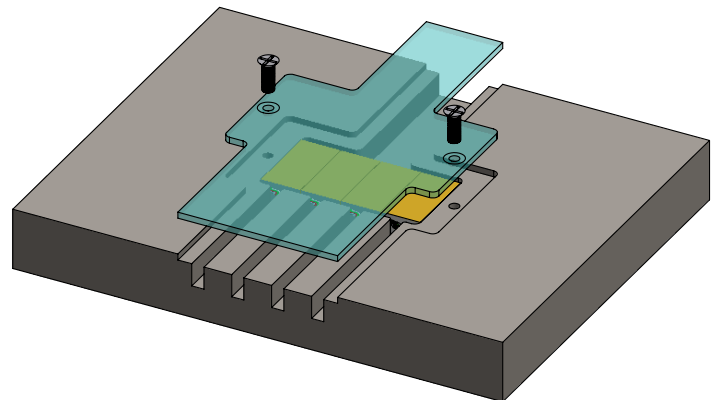
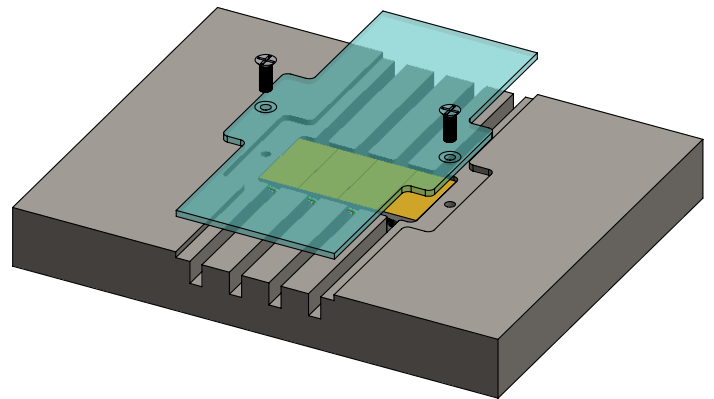
SENSOR ELECTRONICS

1. Sensor Electronics Pocket

- Machine a pocket to store sensor electronics 1.81" (46,0 mm [**1** *at right*]) in length, 0.815" (21 mm [**2** *at right*]) in width, and 0.466" (12 mm [**3** *not shown*]) deep.
- Electronics pockets may also be centralized within the clamp or ejector plates, as shown at right; reference the above specified dimensions per sensor/ electronics package.



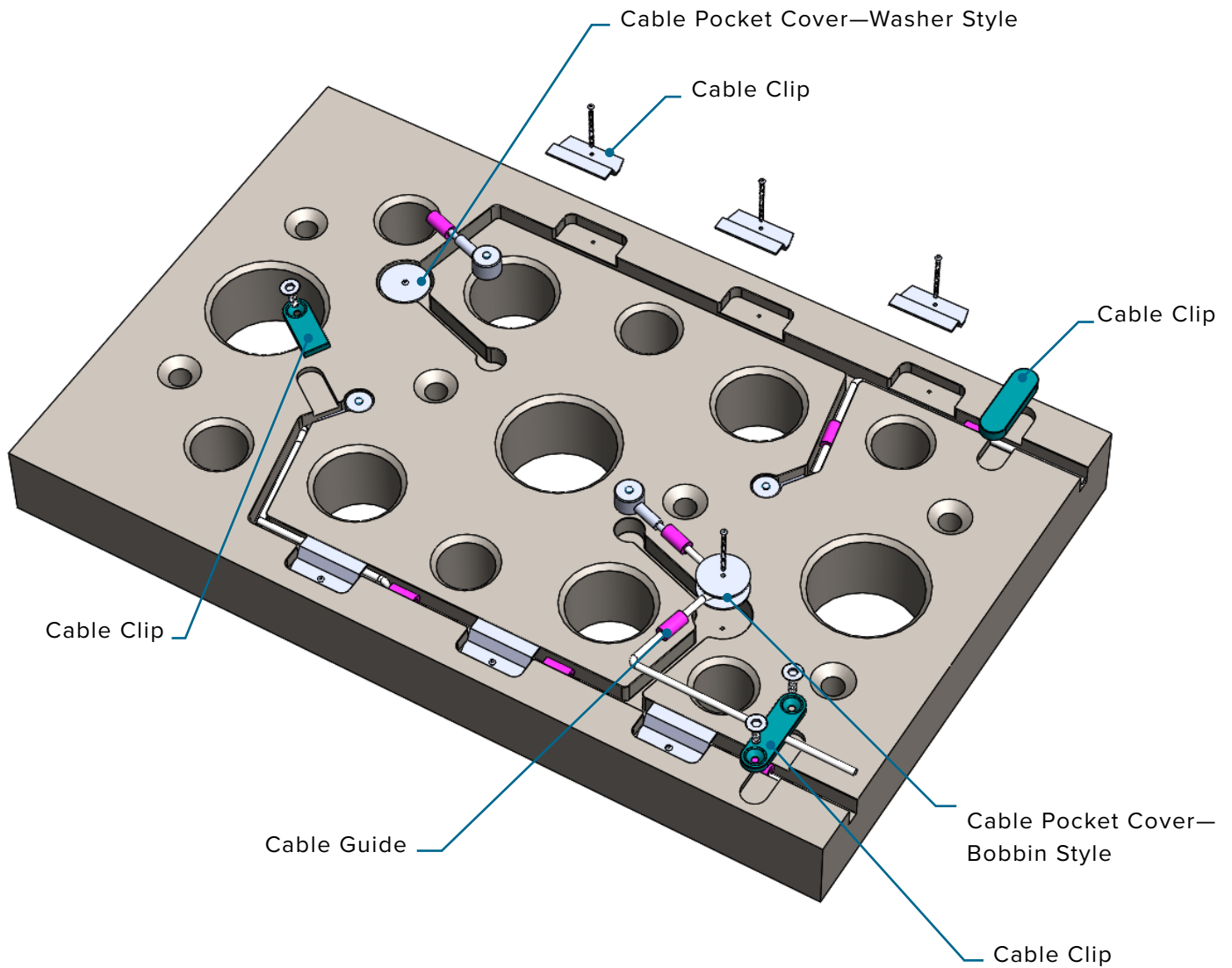
1	1.81" (46,0 mm)
2	0.815" (21 mm)
3	0.466" (12 mm) <i>not shown</i>



INSTALLATION SPECIFICATIONS (continued)

SENSOR CABLE RETENTION

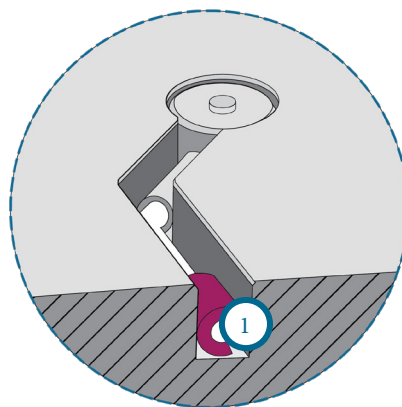
Sensor cable retention strategies must be considered during the mold design phase. Cables are often not the exact size needed, or do not easily remain in the cable channels during assembly and must be retained using one or more of the following methods.



INSTALLATION SPECIFICATIONS *(continued)*

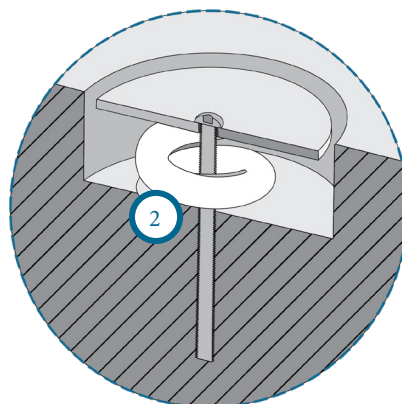
1. Cable Guides

Use self-locking cable guides (**1** at right) in cable channels to retain the sensor cable. Cable guides are silicone rubber tubes with a slot in them to accommodate the sensor cable; the cable guides fit snugly within the cable channel dimensions provided.



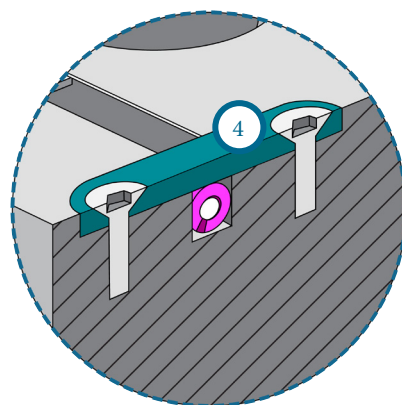
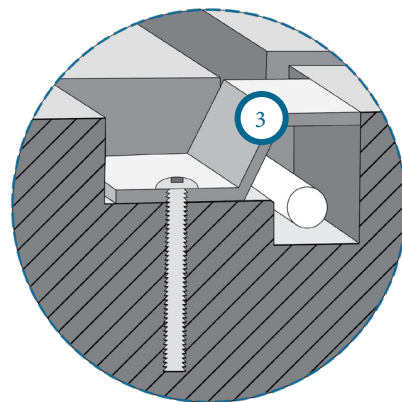
2. Cable Pocket Covers

If excess cable pockets are present, it may be useful to provide a cover (**2** at right) for the cable pocket with which to retain extra cable. Though RJG does not currently provide a solution specifically for this application, plastic or metal discs with a centrally-located hole, retained by a single bolt through the center, can be used to easily retain cable within the pocket. Alternatively, a bobbin-style device can be used similarly to retain cable within a pocket.



3. Cable Clips

Cables may also be retained in channels using cable clips (**3 & 4** at right); RJG does not currently provide this solution. Clips can be formed from sheet or plate metal and retained by machine screws, or purchased from a molding components supplier. The clips can supplement or replace the use of silicone rubber cable guides, enabling an easier assembly of the tool.



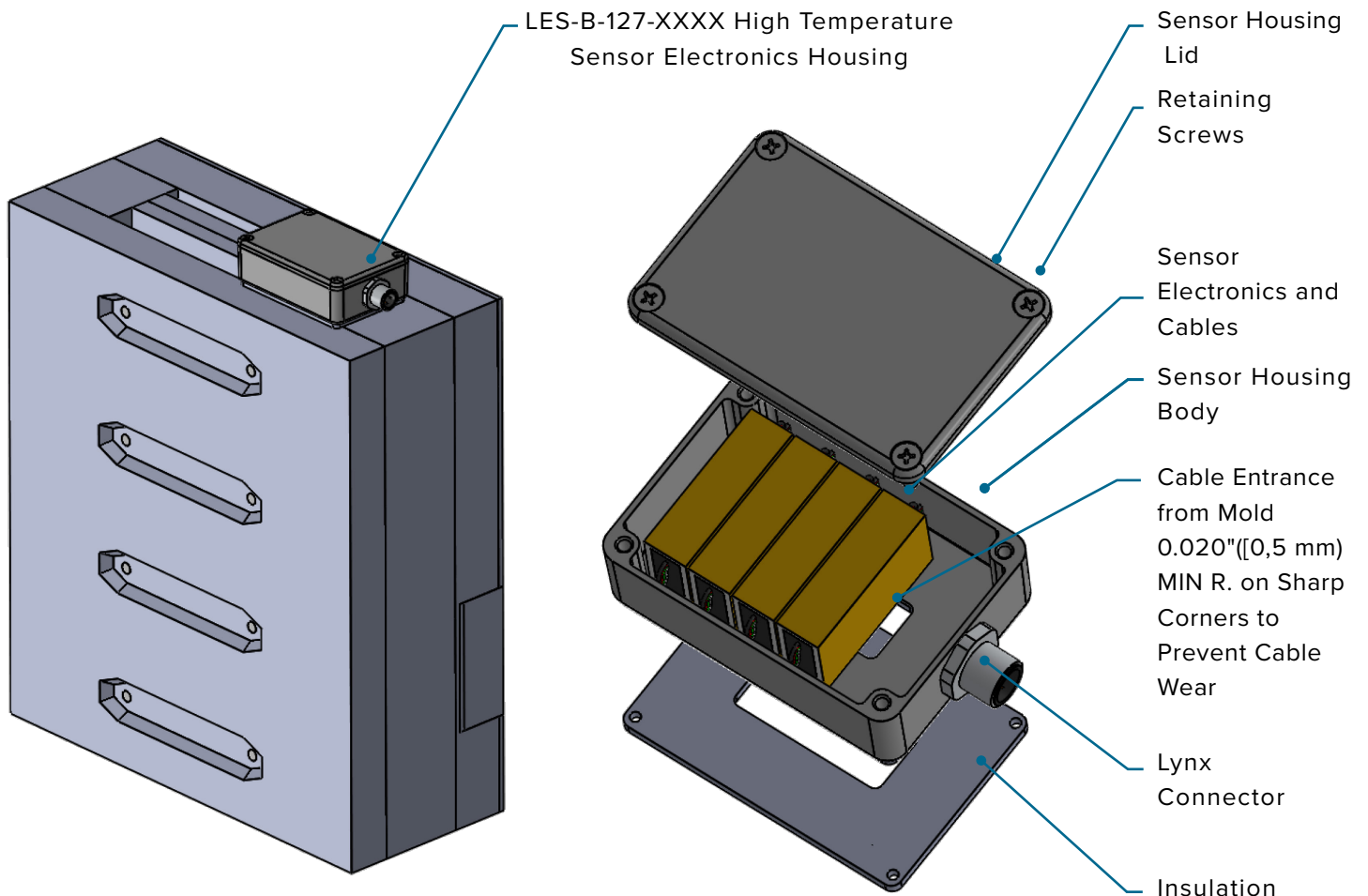
INSTALLATION SPECIFICATIONS (continued)

HIGH-TEMPERATURE INSTALLATION

The sensor electronics must be kept below 140 °F (60 °C). In order to meet the temperature conditions for the sensor electronics, a sensor electronics housing can be mounting on the outside of the mold—provided that there is adequate space on the mold and clearance for all components. The following depicts such an installation. For assistance in designing an appropriate installation to prevent heat damage to the sensor electronics, contact RJG customer support (“Customer Support” on page 54).

**LES-B-127-XXXX HIGH TEMPERATURE SENSOR
ELECTRONICS HOUSING RECOMMENDED
DIMENSIONS**

	Length	Width	Depth
4 Sensors	4.5" (115 mm)	2.6" (65 mm)	1.2" (30 mm)
8 Sensors	4.5" (115 mm)	2.6" (65 mm)	2.2" (55 mm)
Housing Supplied By Customer			



NON-STANDARD INSTALLATIONS

STATIC (NON-MOVING) EJECTOR PINS

While cavity pressure sensor installation with moving, or “working” ejector pins is recommended, in some situations a non-moving or “static” pin must be utilized. In most cases, static pins are installed directly into the cavity plate, or into a cavity insert. In some cases, static pins will extend through multiple plates, such as applications that extend back to the clamp plate. Read and follow all instructions, and refer to the provided figures to properly install sensors with static ejector pins.

1. Static Ejector Pins Overview

Static ejector pins are non-moving pins which sit on top of button-style sensors to transfer plastic pressure in the cavity to the sensor in a mold plate. Unlike moving ejector pins which self-clean during each ejection cycle, static pins can allow build-up of material around the pin over time. Static pins should have an O-ring on the end of the pin to prevent contamination build-up that contributes to measurement errors, allowing the sensors to read accurately over time.

Successful static pin installation provides lower sensor and installation costs; easier sensor maintenance; flexibility in sensor and pin sizing; and freedom in sensor location.

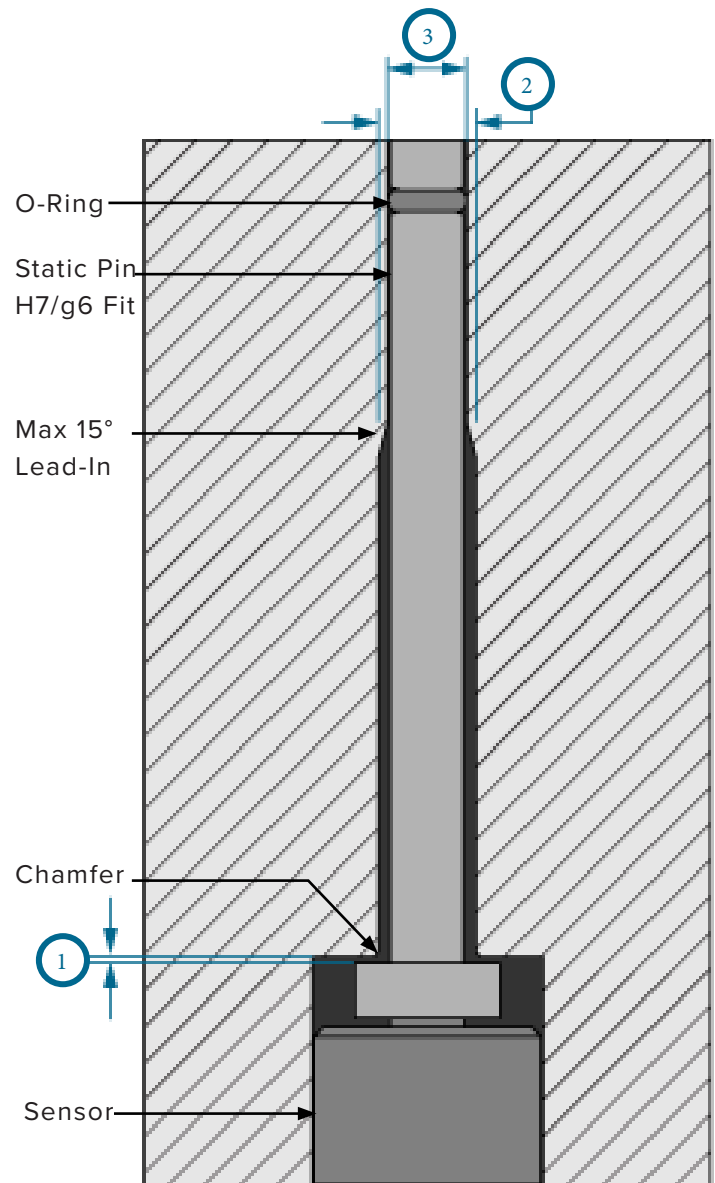
2. Ejector Pin Bore and Lead-In

Provide space in the sensor pocket for the sensor and static pin allowing for clearance above the pin head equal to 1/5th of the part thickness at pin location (1 at right) if part thickness is less than or equal to 0.06” (1,5 mm), or 0.012” (0,3 mm [1 at right]) if the part thickness at pin location is greater than 0.06” (1,5 mm).

From the sensor and pin head pocket, provide a clearance of the pin diameter plus 0.06” (1,5 mm [2 at right]).

Step down the bore to a standard ejector

STATIC PIN INSTALLATION



CAUTION These guidelines are for pins 3/32” (2,5 mm) diameter or larger. Please contact RJG Customer Support for installation of static pins smaller than 3/32” (2,5 mm) in diameter

pin bore of H7/g6 (3 above) (in which the ejector pin is able to freely move) before the cavity to provide a sealing surface for the O-ring at the end of the static pin. Chamfer the transition between the sensor and pin head pocket and the pin bore, and also the transition between the pin bore and standard fitment at the end of the pin (no more than 30°/15° per side).

NON-STANDARD INSTALLATIONS (continued)

3. O-ring Sizing

O-ring sizes are designated by inside diameter (ID [1 at right]) and cross section (CS [2 at right]), usually in inches. A 0.072 X 0.036 O-ring would have an ID of 0.072" and a CS of 0.036".

The O-ring is installed in the ejector pin's groove. The groove is measured by diameter (3 at right) and width (4 at right). The diameter is cut to ensure O-ring stretch of 0–10%. The depth is cut to ensure O-ring compression of 20–35%. Ensure the pin end before O-Ring groove is 0.030" (0,76 mm [5 at right]) MIN for steelsafe. Contact RJG® for assistance in sizing and tolerancing O-rings and installation requirements. Refer to the table below for RJG recommended, in-stock O-rings.

4. O-Ring Installation

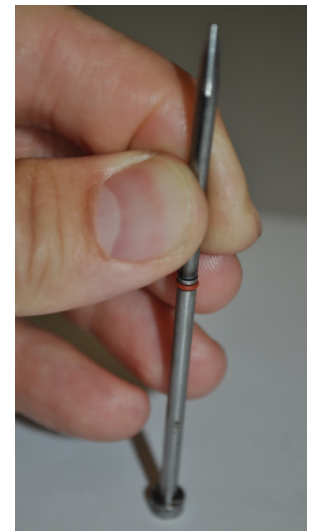
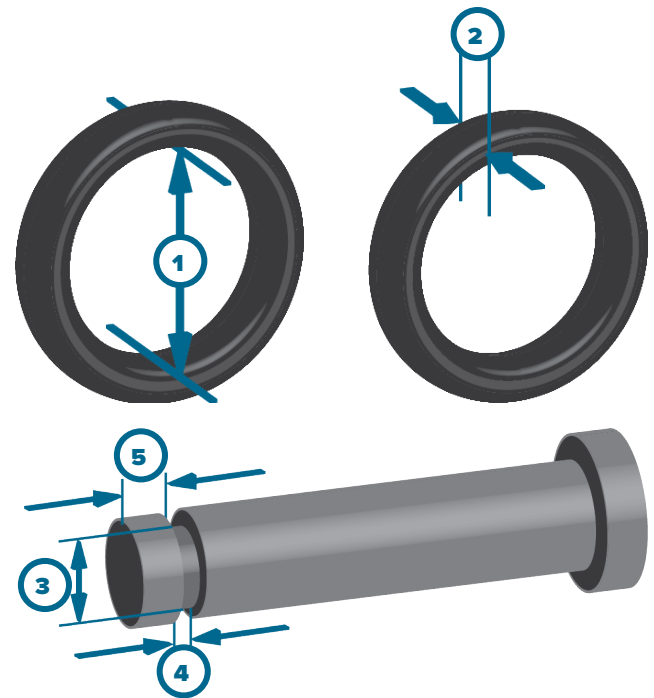
Improper O-ring installation can cause tears if it is pulled over the sharp ejector pin edge. Use an installation tool constructed of the same diameter as the ejector pin, with a tapered end.

The end can be ground, usually by a grinding wheel, and buffed by a wire wheel to remove any burrs. Slide the O-ring onto the tapered end of the installation tool, and then slide onto the end of the static pin. (Refer to figures at right.)

5. Pin and O-Ring Bore Installation

Use an O-ring lubricant to help prevent damage when inserting the pin into the bore. Many silicone-based lubricants can damage silicone O-rings. RJG, Inc. recommends P-80 THIX lubricant from International Products Corporation (<http://www.ipcol.com/shopexd.asp?id=31>). Rotate the pin as it is being inserted to ease installation and limit potential O-ring damage.

STATIC (NON-MOVING) EJECTOR PINS

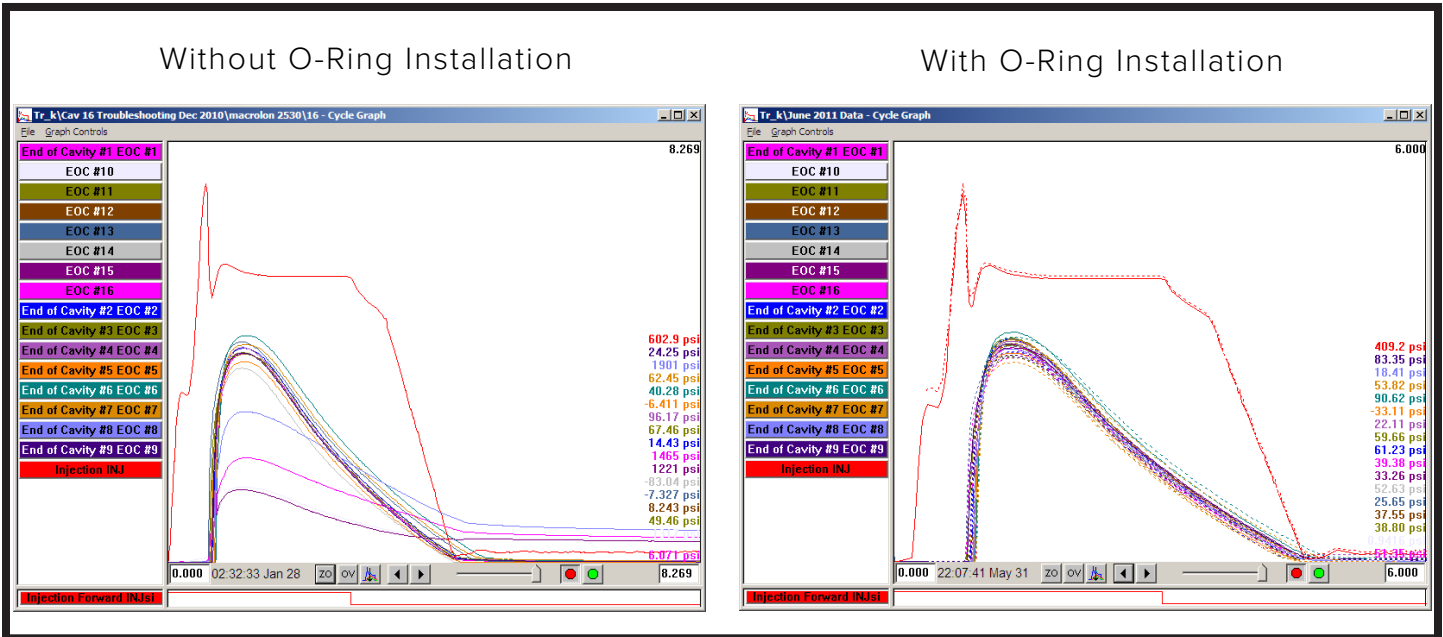


Nominal Pin Size	Material	O-RING		Units	GROOVE SPEC.				BORE SPEC.	
		Size (Metric)	RJG Part #		Width (4, above)	Width Tol (+/-)	Groove DIA (3, above)	DIA Tol (+/-)	Bore DIA	Bore Tol (+ Tol, -0)
4,0 mm	Silicone	2,7 x 0,65	85-6157-000	inches	0.038	0.003	0.1137	0.0019	0.1575	0.0005
2,5 mm		1,4 x 0,6	85-6159-000		0.032	0.003	0.0667	0.0010	0.0984	0.0005
4,0 mm		2,7 x 0,65	85-6157-000	mm	1,00	0,08	2,888	0,048	4,0	0,012
2,5 mm		1,4 x 0,6	85-6159-000		0,80	0,08	1,695	0,025	2,5	0,012

NON-STANDARD INSTALLATIONS (continued)

6. Sensor Readings

Data from the same mold is pictured below (typical results—not guaranteed).



Above Left: Three sensors are reading too low due to contamination—without O-rings installed.

Above Right: The template and solid lines after four months of continuous production; the sensors continue to read consistently with O-rings installed.

Proper installation will provide a long service life of O-rings inside the mold. Only in the event of the following two instances will O-rings require replacement:

7. Flashing

If material flashes around the pin, it is necessary to pull the pin and remove the flashed material during regular preventative maintenance cycles. The O-ring must be replaced.

8. O-Ring Damage

When a pin is removed for inspection and/or cleaning during mold maintenance, inspect the O-ring for damage. Repeated installation and removal can cause nicks, cuts, or other damage to O-rings. Damaged O-rings must be replaced.

MULTIPLE EJECTOR PINS

Ejector pins are often grouped in small areas that do not allow for traditional cavity pressure sensor installation. Read and follow all instructions, and refer to the provided figures to properly install sensors with multiple ejector pins.

1. Multiple Ejector Pin and Sensor Placement

When multiple ejector pins are located too closely together to permit cavity pressure sensor placement under a single pin, a cover plate can be utilized to allow a selected pin to contact the sensor and prevent other pins from interfering.

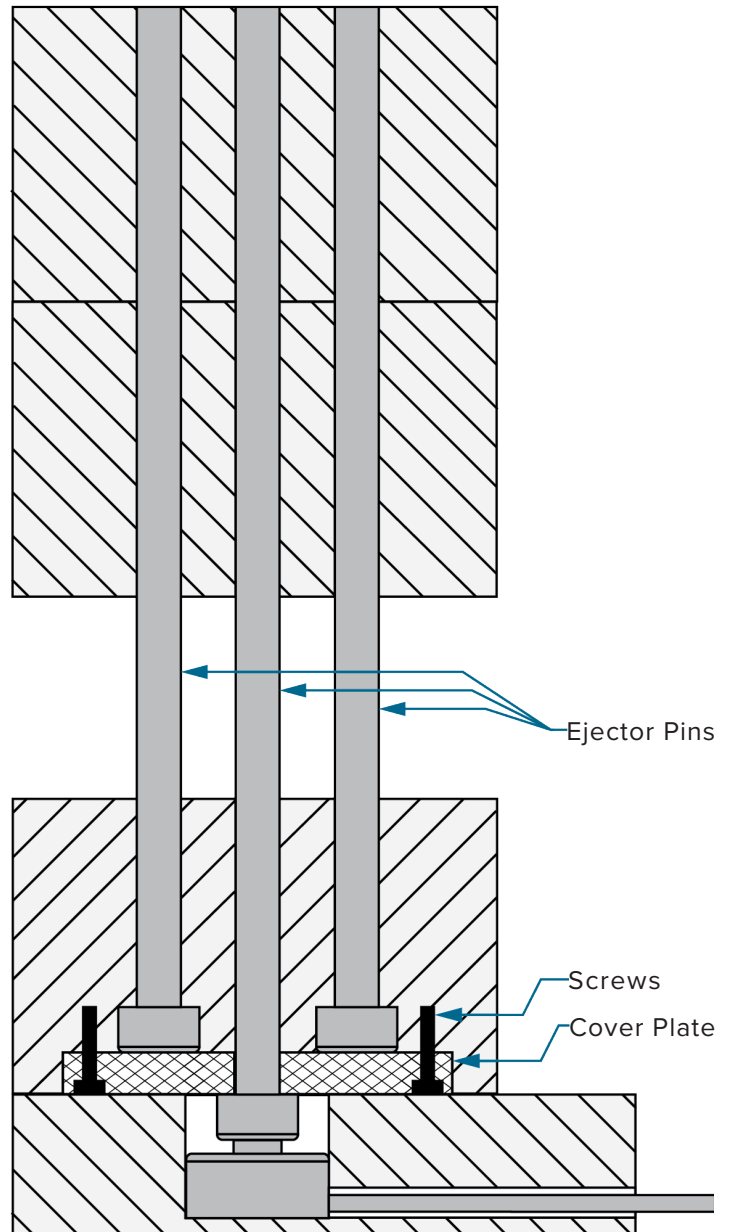
The ejector pin retainer plate is modified to fit the cover plate so that it is recessed and flush with the ejector plate, and covers the area of the sensor body and unused ejector pins. The cover plate is mounted with four screws.

The cover plate mounting screws must be flush with the ejector plate and must not be in contact with the ejector pins, since constant pressure on the screws will cause them to fail.

2. Ejector Pin and Counter-Bore Clearance

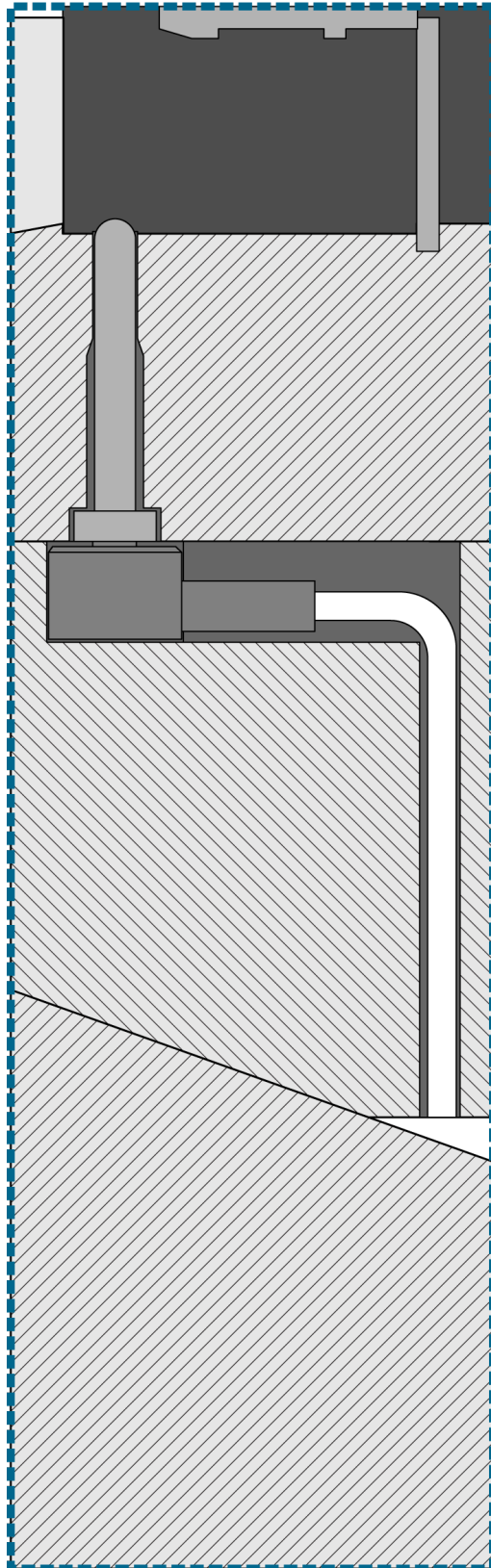
Always use standard ejector pin clearances when installing cavity pressure sensors under ejector pins to prevent damage or destruction of the pins, sensors, and mold. Proper ejector pin head and counter-bore clearance will allow the static pin to move freely in the ejector pin bore.

PIN, SENSOR, & PLATE INSTALLATION

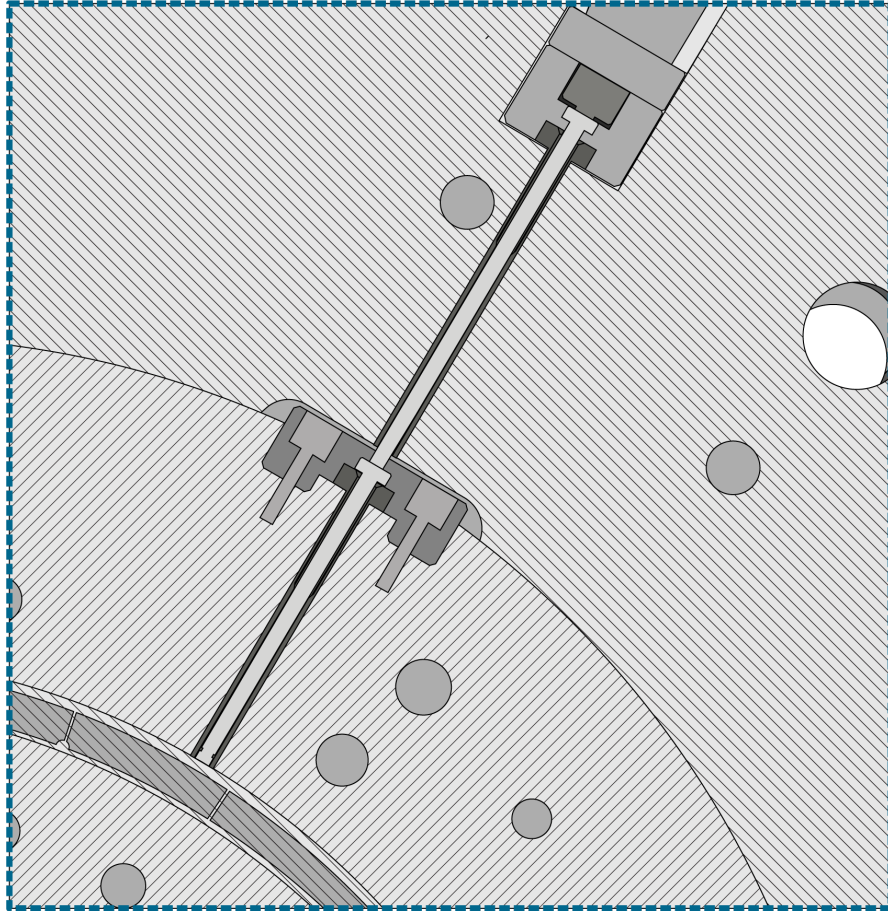
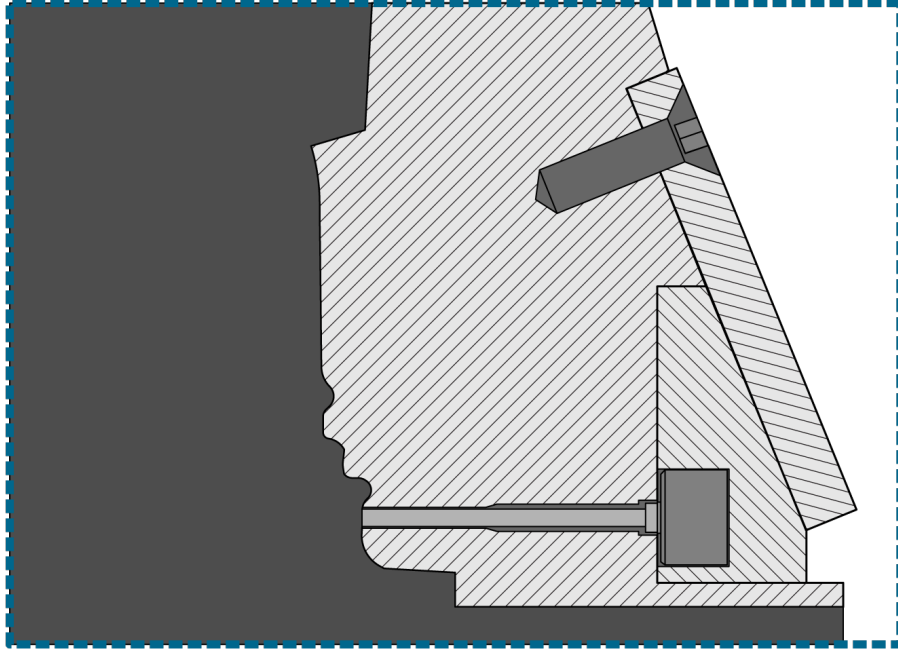


NON-STANDARD INSTALLATIONS (continued)

STATIC PIN EXAMPLE



NON-STANDARD INSTALLATIONS (continued)
STATIC TRANSFER PIN EXAMPLES



INSTALLATION VALIDATION

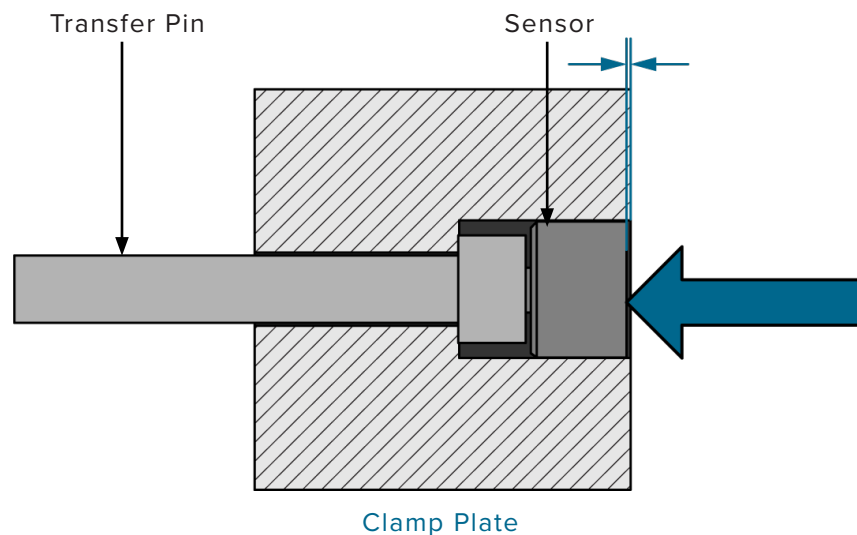
SENSOR INSTALLATION CHECK—CLAMP PLATE (TYPICAL) INSTALLATIONS

Verify that the each sensor, transfer pin, and ejector pin pocket is machined correctly.

PRE-ASSEMBLY CHECKS

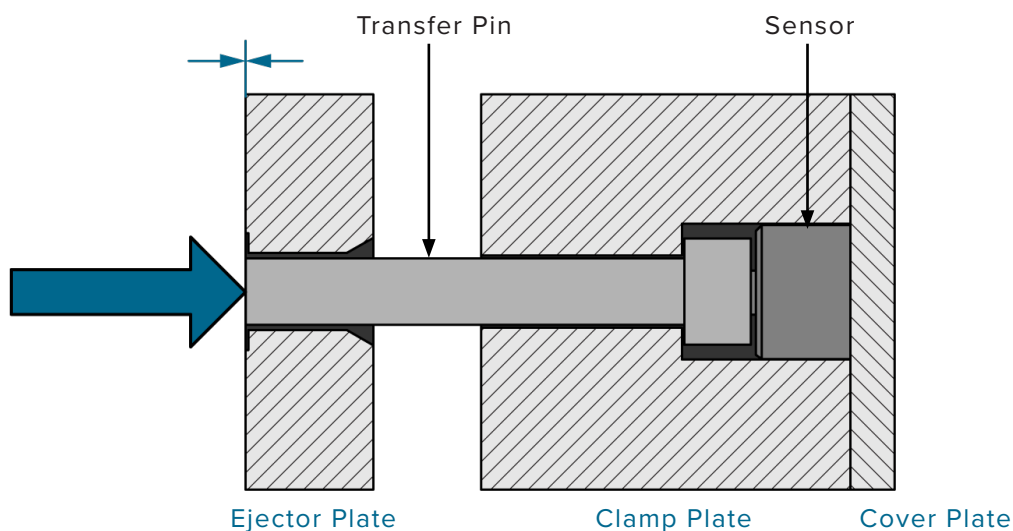
1. Indentation Test (with sensor)

With the clamp plate disassembled, sensor in place, and cover plate removed, push the sensor and transfer pin forward; there should be 0.012–0.02” (0,3–0,5 mm) clearance between the sensor bottom and the clamp plate/sensor pocket bottom before the cover plate surface. Verify that the pin moves freely without any resistance.



2. Flush Test (with sensor)

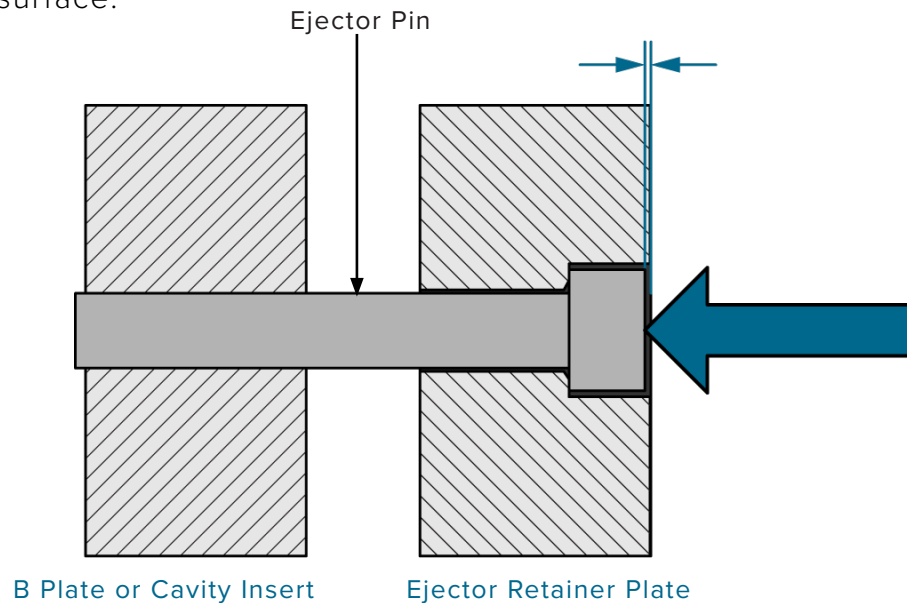
With the transfer pin, sensor, and cover plate installed, place the ejector plate above the clamp plate, and position fully back. Verify that the counterbore depth equals 0.012” (0,3 mm) and that the diameter is larger than the ejector pin head; the transfer pin should be flush with the ejector retainer plate.



SENSOR INSTALLATION CHECK—CLAMP PLATE (TYPICAL) INSTALLATION *(continued)*

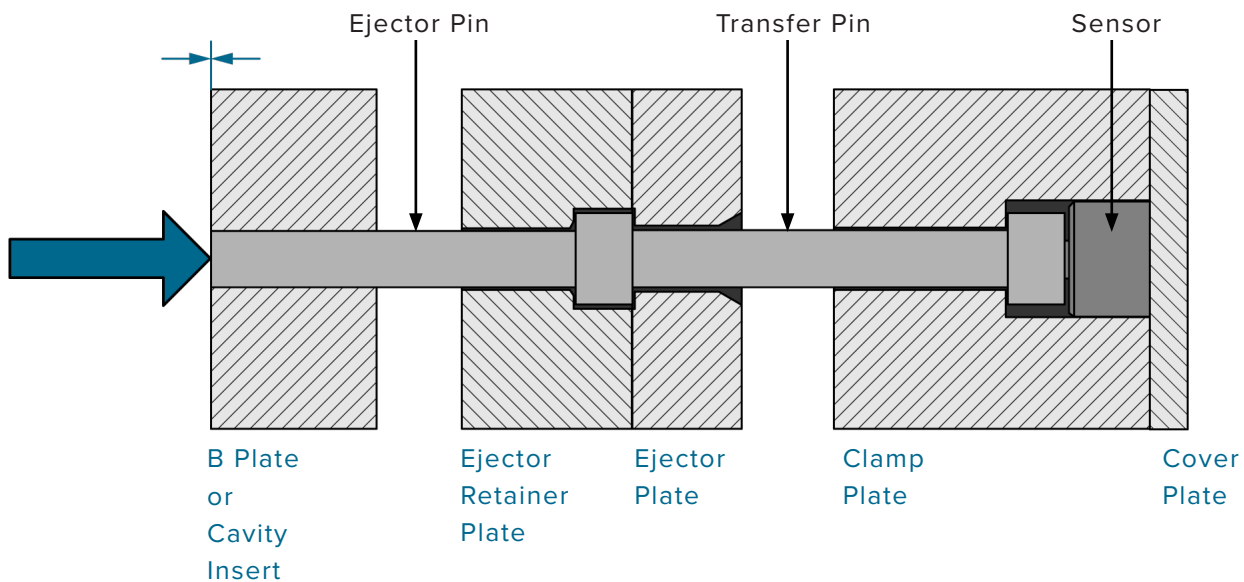
3. Indentation Test (with Ejector Pin)

With the ejector pin installed, push on the ejector pin; verify the clearance of 0.012” (0,3 mm (or 1/5 part thickness)) exists between the bottom of the ejector pin head and the ejector retainer plate surface.



4. Flush Test (Full Stack)

With the sensor, ejector, and transfer pin installed, and the ejector plate in the injection position, fixed towards clamp plate, the ejector pin should be flush with the ejector plate/ cavity surface.

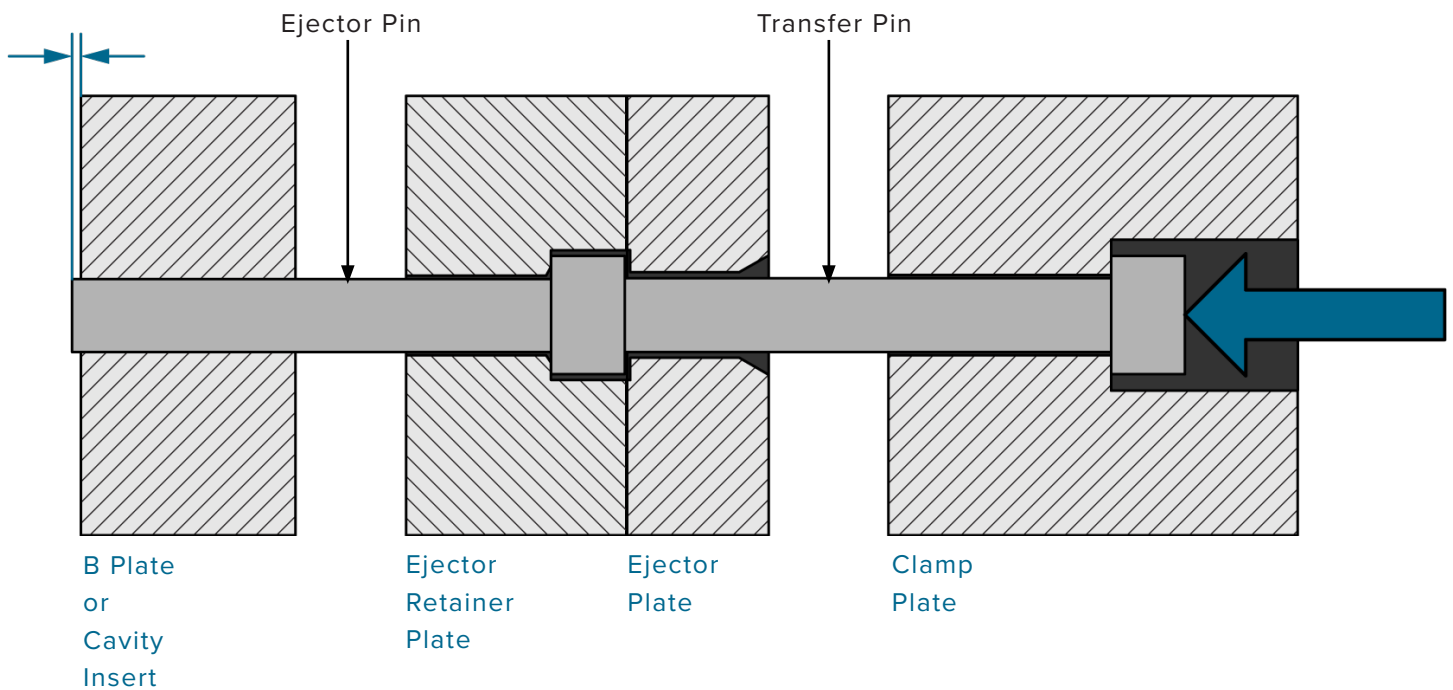


SENSOR INSTALLATION CHECK—CLAMP PLATE (TYPICAL) INSTALLATION *(continued)*

POST-ASSEMBLY CHECKS

1. Protrusion Test (without sensor)

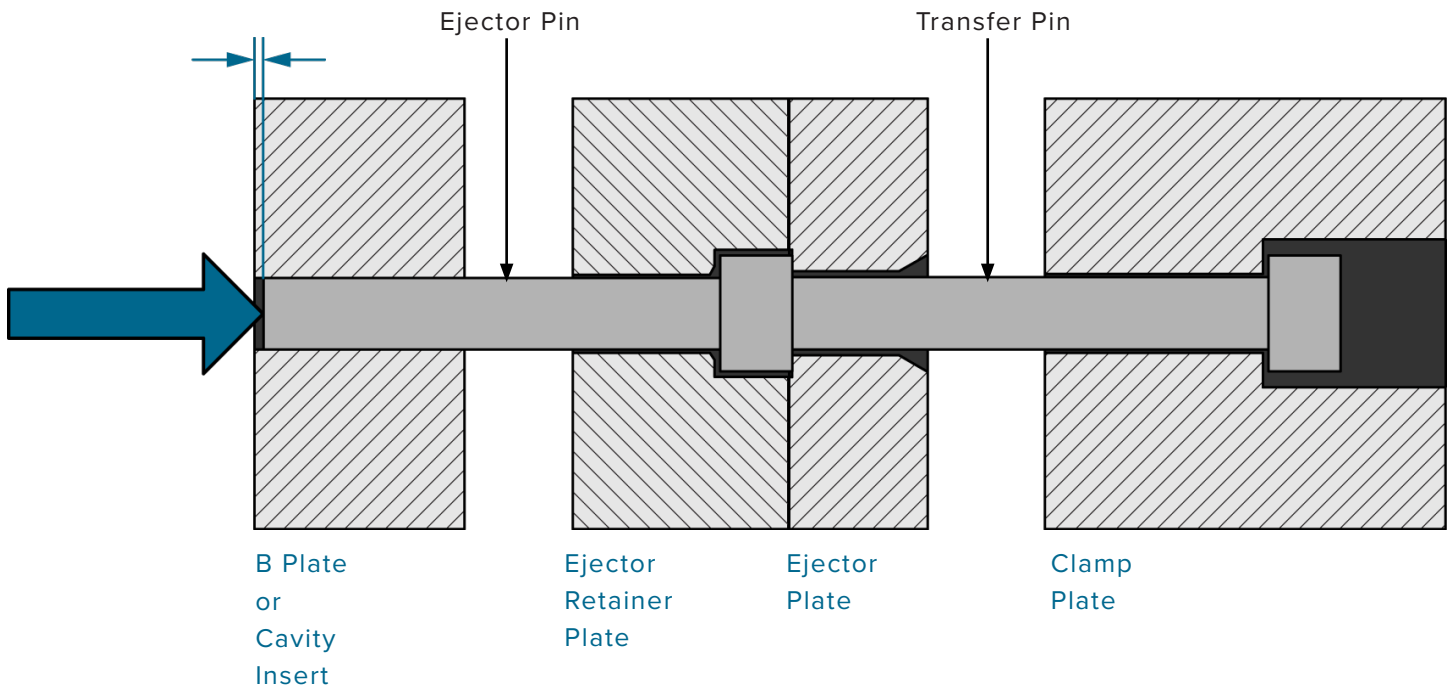
With the ejector and transfer pins installed, the ejector plate in injection position, and the ejector plate fixed towards clamp plate, press the ejector and transfer pin together, towards the cavity; the ejector pin should protrude 0.008–0.01” (0,2–0,3 mm).



SENSOR INSTALLATION CHECK—CLAMP PLATE (TYPICAL) INSTALLATION (continued)

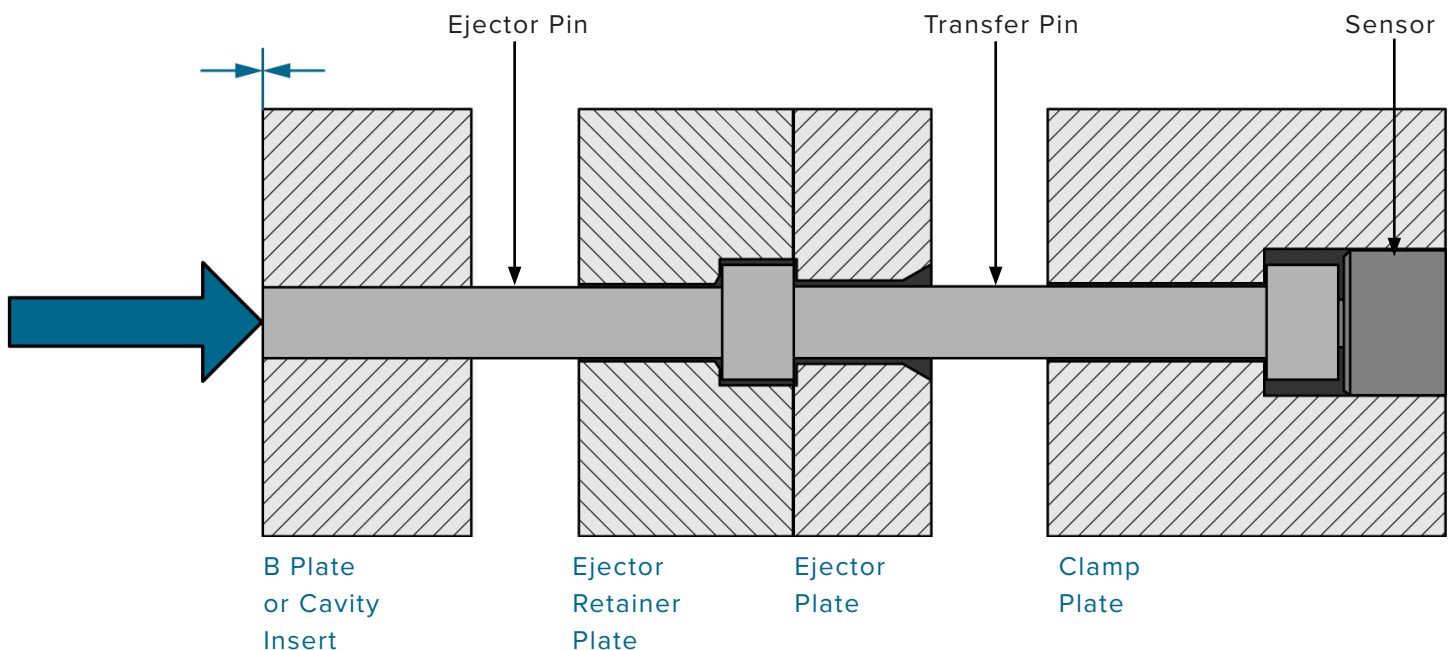
2. Indentation Test (without sensor)

With the ejector and transfer pins installed, the ejector plate in the injection position, and the ejector plate fixed towards clamp plate, press the ejector and transfer pin together, away from the cavity; the ejector pin should recess in the ejector plate 0.008–0.01" (0,2–0,3 mm).



3. Flush Test (with sensor)

With the sensor, ejector, and transfer pin installed, and the ejector plate in the injection position, fixed towards clamp plate, the ejector pin should be flush with the ejector plate/cavity surface.



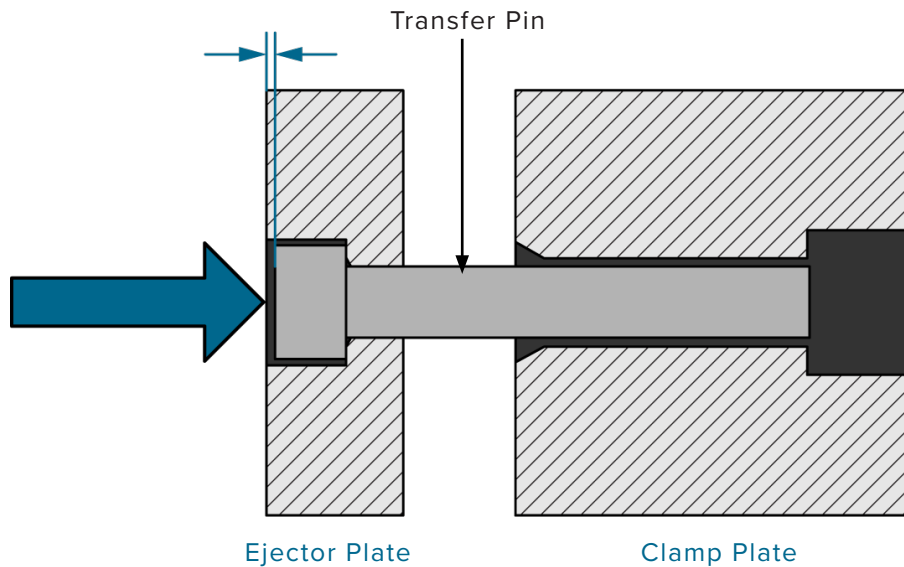
SENSOR INSTALLATION CHECK—CLAMP PLATE (HEAD-TO-HEAD) INSTALLATIONS

Verify that the each sensor, transfer pin, and ejector pin pocket is machined correctly.

PRE-ASSEMBLY CHECKS

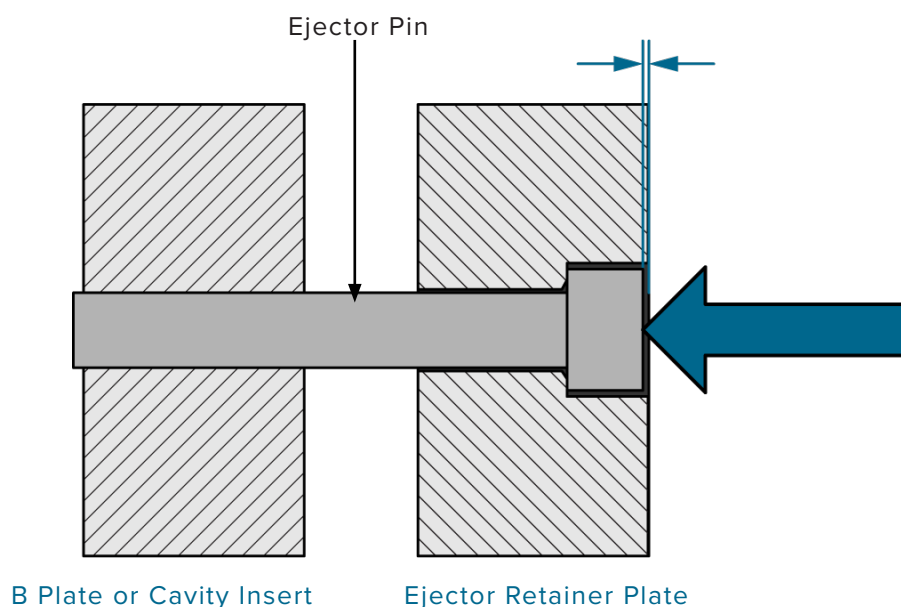
1. Indentation Test (without sensor)

With only the transfer pin installed, push on the transfer pin head and verify a clearance of exists 0.012" (0,3 mm) MIN between the transfer pin head and retainer ejector plate surface.



2. Indentation Test (with Ejector Pin)

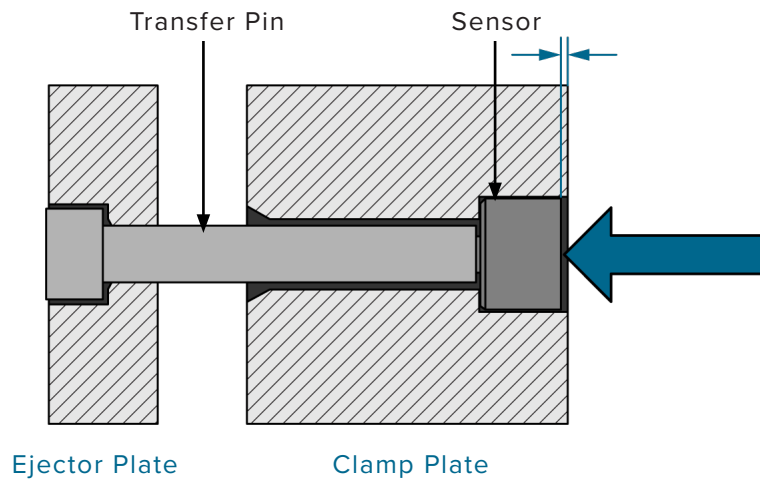
With the ejector pin installed, push on the ejector pin; verify the clearance of 0.012" (0,3 mm (or 1/5 part thickness)) exists between the bottom of the ejector pin head and the ejector plate surface.



SENSOR INSTALLATION CHECK—CLAMP PLATE (HEAD-TO-HEAD) INSTALLATION *(continued)*

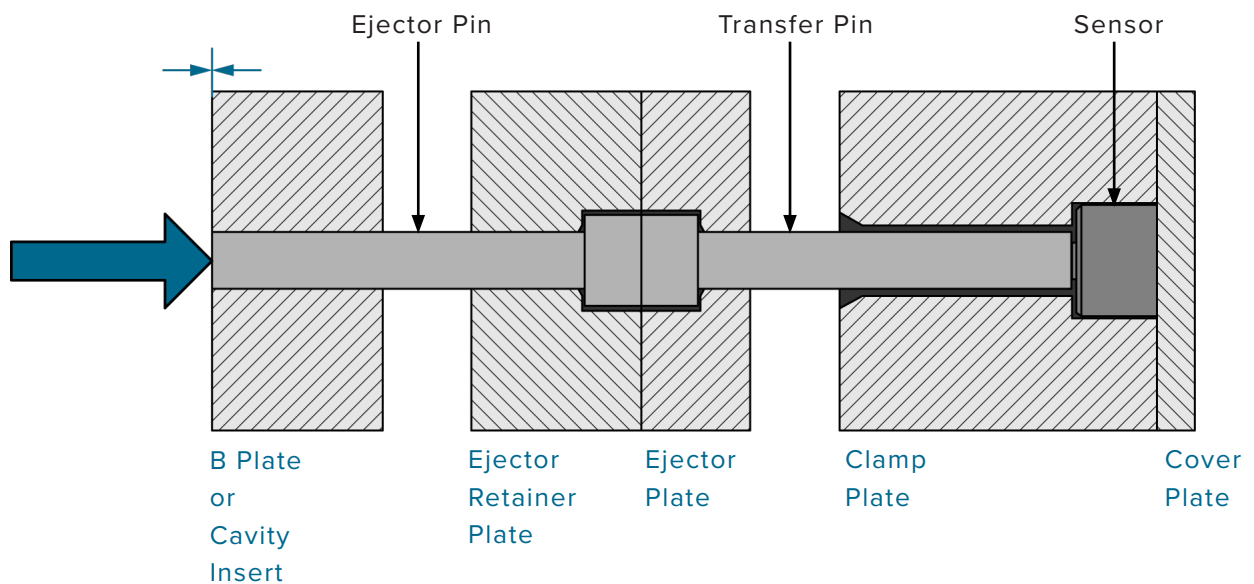
3. Indentation Test (with sensor)

With the clamp plate disassembled, sensor in place, and cover plate removed, push the sensor and transfer pin forward; there should be 0.012–0.02” (0,3–0,5 mm) clearance between the sensor bottom and the clamp plate/sensor pocket bottom before the cover plate surface. Verify that the pin moves freely without any resistance.



4. Flush Test (Full Stack)

With the sensor, ejector, and transfer pin installed, and the ejector plate in the injection position, fixed towards clamp plate, the ejector pin should be flush with the ejector plate/cavity surface.

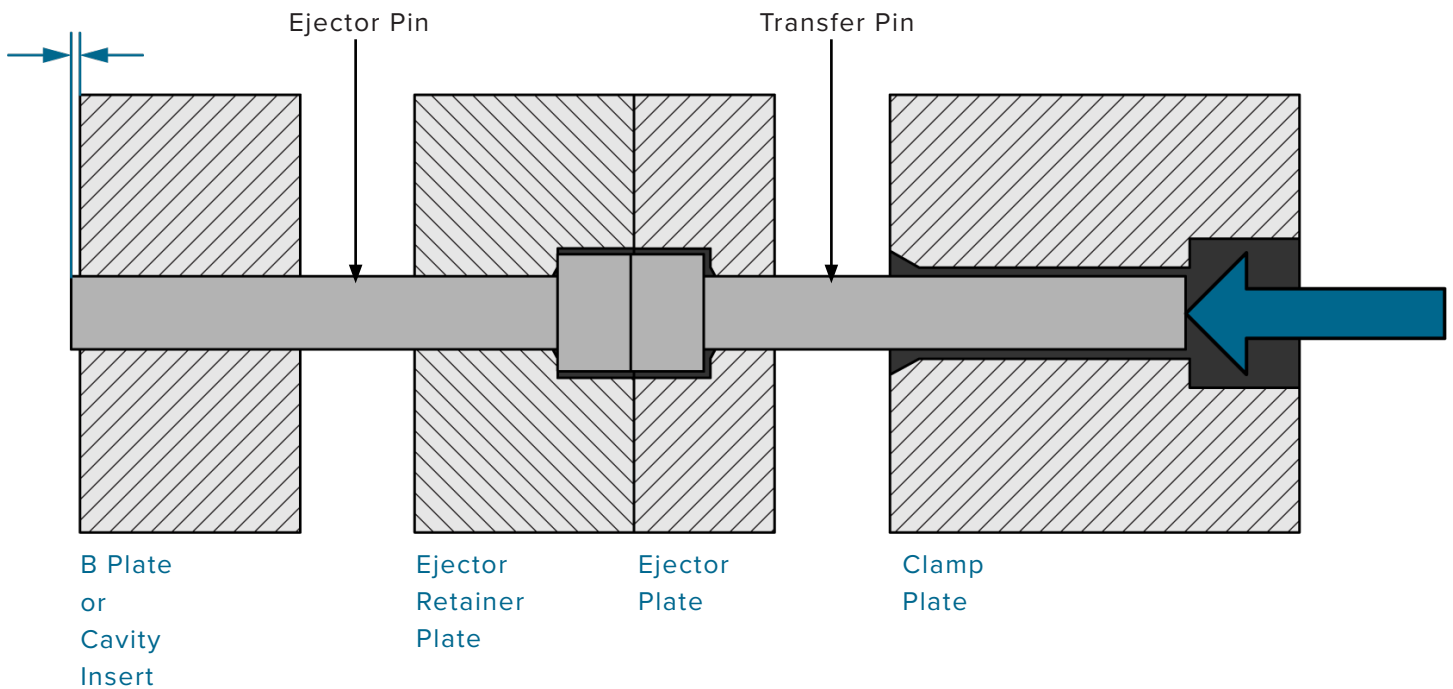


POST-ASSEMBLY CHECKS

Verify that the each sensor, transfer pin, and ejector pin pocket is machined correctly.

1. Protrusion Test (without sensor)

With the ejector and transfer pins installed, the ejector plate in injection position, and the ejector plate fixed towards clamp plate, press the ejector and transfer pin together, towards the cavity; the ejector pin should protrude 0.008–0.01” (0,2–0,3 mm).

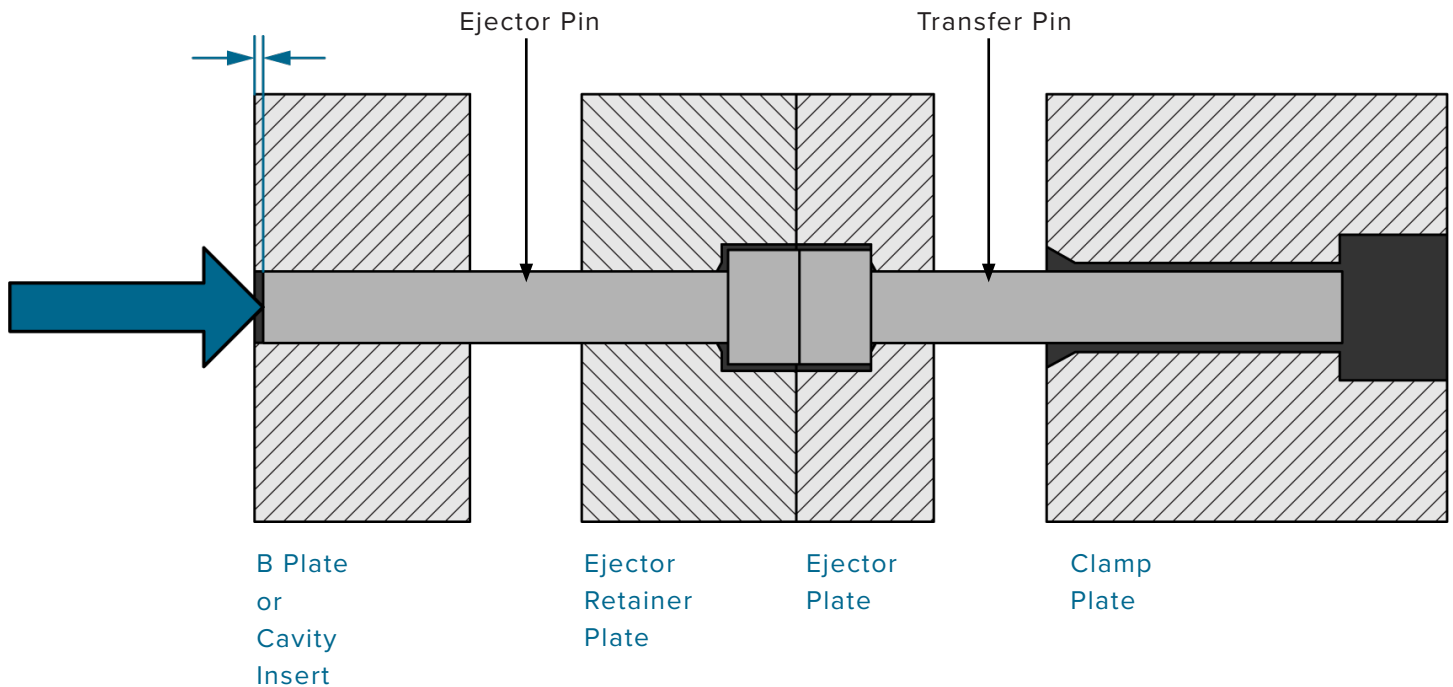


SENSOR INSTALLATION CHECK—CLAMP PLATE (HEAD-TO-HEAD) INSTALLATION

(continued)

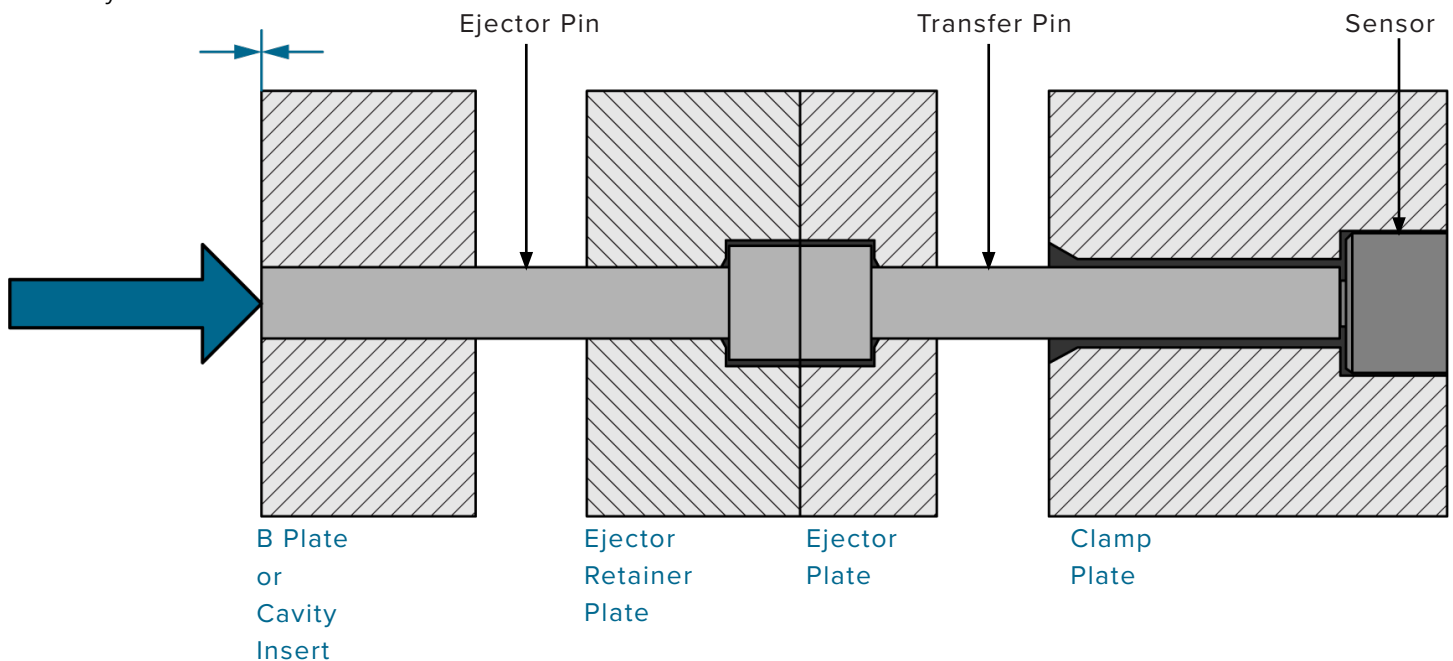
2. Indentation Test (without sensor)

With the ejector and transfer pins installed, the ejector plate in the injection position, and the ejector plate fixed towards clamp plate, press the ejector and transfer pin together, away from the cavity; the ejector pin should recess in the ejector plate 0.008–0.01" (0,2–0,3 mm).



3. Flush Test (with sensor)

With the sensor, ejector, and transfer pin installed, and the ejector plate in the injection position, fixed towards clamp plate, the ejector pin should be flush with the ejector plate/cavity surface.



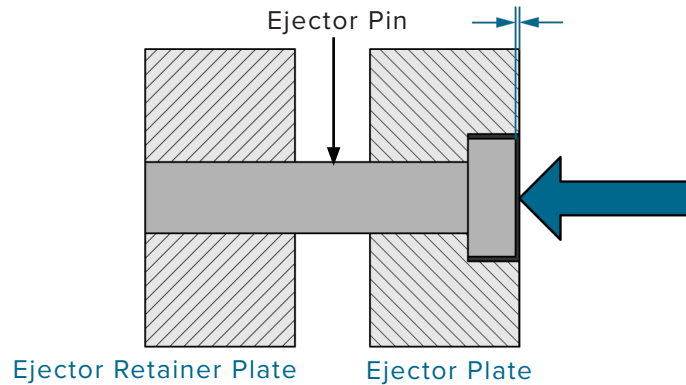
SENSOR INSTALLATION CHECK—EJECTOR PLATE INSTALLATIONS

Verify that the each sensor, transfer pin, and ejector pin pocket is machined correctly.

PRE-ASSEMBLY CHECKS

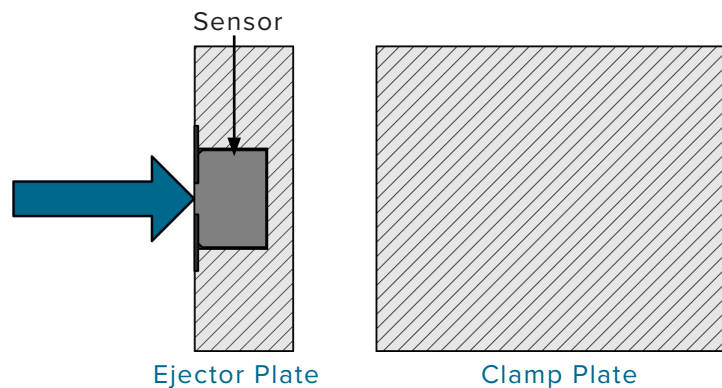
1. Indentation Test (with Ejector Pin)

With the ejector pin installed, push on the ejector pin; verify the clearance of 0.012” (0,3 mm (or 1/5 part thickness)) exists between the bottom of the ejector pin head and the ejector plate surface.



2. Flush Test (with Sensor)

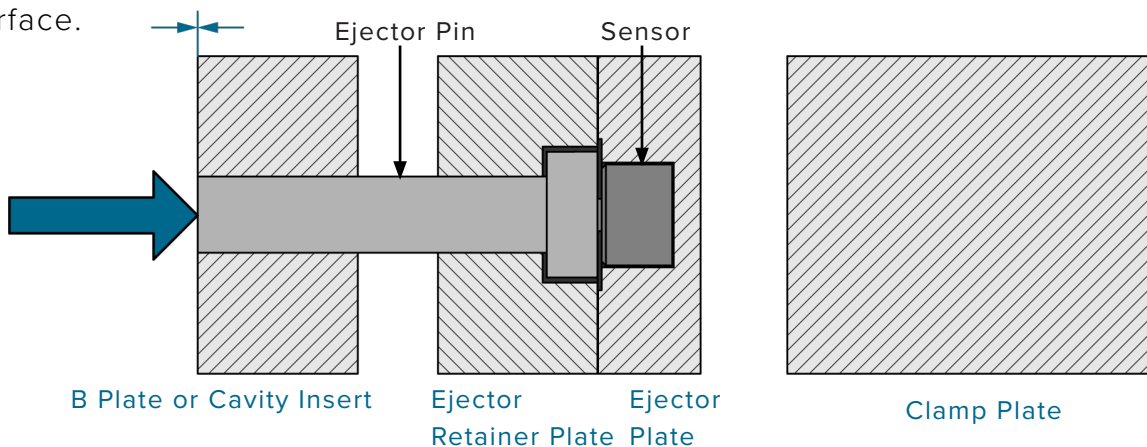
With the sensor installed in the ejector retainer plate, verify that the counterbore depth equals (0,5mm) (if needed) and the counterbore diameter is larger than the ejector pin head. The sensor head should be flush with the ejector retainer plate.



POST-ASSEMBLY CHECK

1. Flush Test (Full Stack)

With the sensor and ejector pin installed, and the ejector plate in the injection position, fixed towards clamp plate, the ejector pin should be flush with the ejector plate/cavity surface.

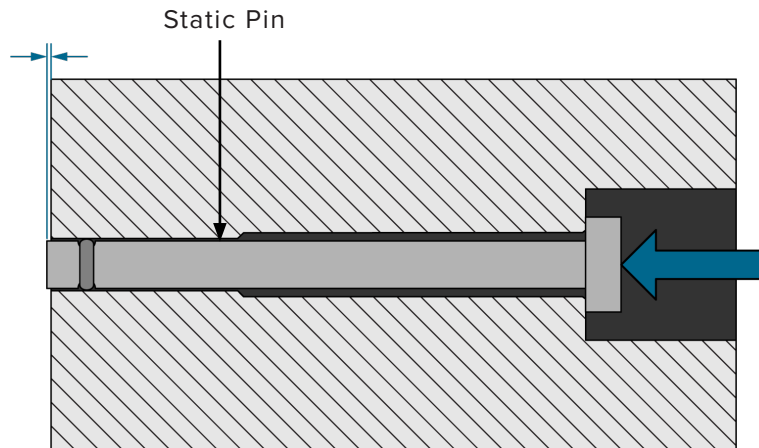


SENSOR INSTALLATION CHECK—STATIC PIN INSTALLATIONS

Verify that the each sensor and static pin pocket is machined correctly.

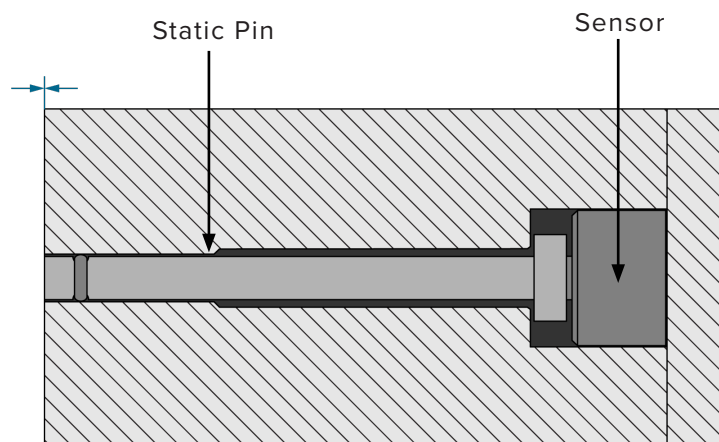
2. Protrusion Test (without sensor)

With only the static pin installed, push on the static pin; verify the pin protrudes clearance above the pin head equal to $1/5$ th of the part thickness at pin location if part thickness is less than or equal to 0.06" (1,5 mm), or 0.012" (0,3 mm) if the part thickness at pin location is greater than 0.06" (1,5 mm).



3. Flush Test (with sensor)

With the plates disassembled, sensor and pin in place, and cover plate removed, the end of the static pin should be flush with the plate surface.



MAINTENANCE

Strain gage sensors require little maintenance.

CLEANING

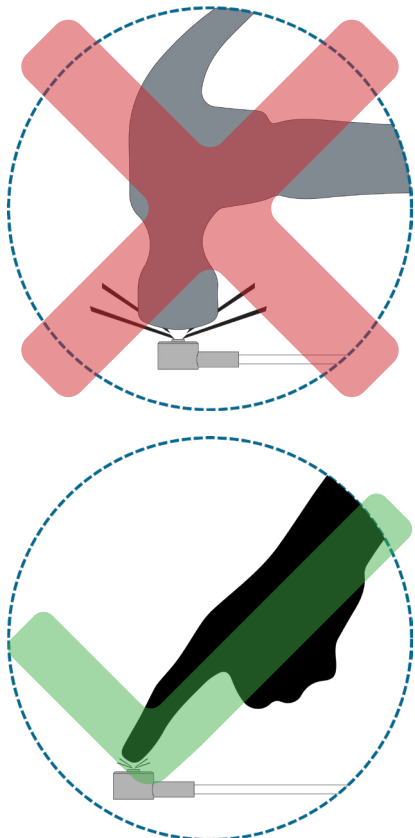
Pull sensors from the mold and clean out the pockets and channels when a mold is pulled for preventative maintenance. LES-B-127-50/125/500/2000 sensors must be installed in pockets free from oil, dirt, grime, and grease.

TESTING & CALIBRATION

TESTING SENSORS

Basic force tests are easily performed on the LES-B-127-50/125/500/2000 sensors; a small, even amount of force applied to the sensor head loading nub is sufficient to determine if the sensor is correctly reading pressure.

CAUTION NEVER strike the sensor head with excessive force; failure to comply will result in damage or destruction of sensor.



RJG, Inc. offers the following tools to test sensors.

4. Sensor eValuator

The Sensor eValuator provides diagnostics on typical sensor problems such as sensor drift, preload, and zero shift, and can also detect sensor installation errors caused by improper pocket dimensions, damaged wires, and damaged sensor heads. A test report with sensor configuration can be emailed or printed from the device. This device allows testing of up to thirty-two sensors at one time and can verify that a force was applied to the sensor.

5. eDART Software—Raw Data Viewer

The eDART Raw Data Viewer displays the status of the sensor, either Valid, No Reply, Stale, or Invalid.

- A Valid sensor has raw counts that change when force is applied to the sensor; this indicates a properly working sensor.
- A No Reply sensor is not communicating with the eDART; the sensor may be unplugged.
- A Stale sensor indicates a sensor that is unused.
- An Invalid sensor will indicate a Failure of either Over-range (Ovrng) or Under-range (Undrng). The Ovrng indicates the sensor's calibration has changed too far in a positive direction, outside of the upper specification. The Undrng indicates that the sensor's calibration has changed too far in a negative direction, and the sensor may report a number below zero when load is applied.

TESTING & CALIBRATION *(continued)*

CALIBRATION

RJG recommends that sensors be calibrated every year, but the need for regular calibration depends largely on the accuracy required for the application and the requirements of individual quality systems and industry regulations.

RJG sensors are designed to hold calibration for operating life. The vast majority stay within a 2% accuracy specification, which is sufficient for most customer applications.

COMMON FACTORS AFFECTING SENSOR RECALIBRATION

1. Required Application Accuracy

Some applications require more accuracy than others. If using cavity pressure control on a precise part with a narrow processing window, it may be important to maintain sensor calibration to within 1%.

If simply detecting short shots, calibration shifts of 5% or more may be tolerated. As a point of reference, a 2% calibration error means that a cavity pressure of 3,000 psi (207 bar) may read as low as 2,940 psi (203 bar), or as high as 3,060 psi (211 bar), which is insignificant in most applications. For most applications, calibration accuracy of 2% is more than sufficient, and is used by RJG as the specification for repaired sensors.

2. Quality System Regulations

If US Food and Drug Administration (FDA) quality system requirements must be met, or those of other stringent quality systems, sensor calibration may be required. However, even in these cases, there is often flexibility to adjust guidelines to meet the needs of the application.

3. Sensor Cycle Count

In the most aggressive environments, it takes at least 100,000 cycles for a sensor to show significant calibration errors. In more typical applications, calibration will remain stable for 500,000–1,000,000 cycles. Even then, many sensors in the field with multiple millions of cycles show little calibration shift. If a sensor is in a low volume mold that sees fewer cycles, the need for sensor recalibration is minimized.

4. Sensor Load

The higher the peak load on the sensor, the more the loading nub can wear—and the higher the potential for calibration shift. Low force sensors (125-pound sensors, for example) show less calibration shift than high force sensors (2000-pound sensors); sensors that run at the lower end of their force range (less than 40% of full scale) show less calibration shift than sensors that run at the high end of their range.

TESTING & CALIBRATION *(continued)*

5. Sensor Operating Temperature

The higher the mold temperature, the greater the potential for calibration shift. Below 212 °F (100 °C), calibration usually remains stable. Sensors running at 300–400 °F (150–200 °C) have a greater potential for permanent calibration shift over time.

6. Visible Sensor Wear

It is normal for the loading nub to show some wear. However, if the wear pattern exceeds half the diameter of the loading nub, the sensor calibration is more likely to have shifted significantly.

7. Sensor Zero Offset Shift

The zero offset is the reading of the sensor with no load applied. While not directly related to the sensor calibration, the zero offset does provide indication that the sensor's calibration may be suspect.

8. Abnormal Readings

A sensor reading abnormally high or low relative to template or to other sensors can be an indication of a calibration shift. Before sending the sensor back, check for other more common causes of erroneous readings, such as incorrect sensor pocket dimensions, sensor preload, contamination in the sensor pocket, and binding ejector pin due to misalignment, debris/contamination, or galling.

WARRANTY

RJG, INC. STANDARD THREE-YEAR WARRANTY

RJG, Inc. is confident in the quality and robustness of the LES-B-127-50/125/500/2000 cavity pressure sensors, and so are offering a three-year warranty on all RJG strain gage and piezoelectric cavity pressure sensors. RJG's cavity pressure sensors are guaranteed against defects in material and workmanship for three years from the original ship date. The warranty is void if it is determined that the sensor was subjected to abuse or neglect beyond the normal wear and tear of field use, or in the event the sensor has been opened by the customer. This new warranty policy is the most generous offered in the cavity pressure sensor industry, with one year being the most common.

PRODUCT DISCLAIMER

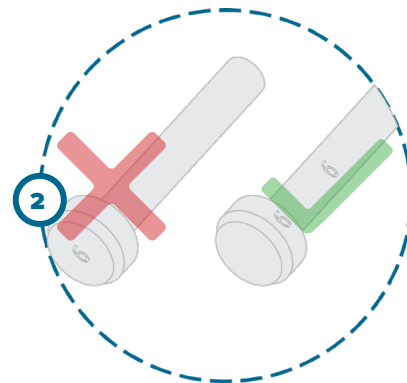
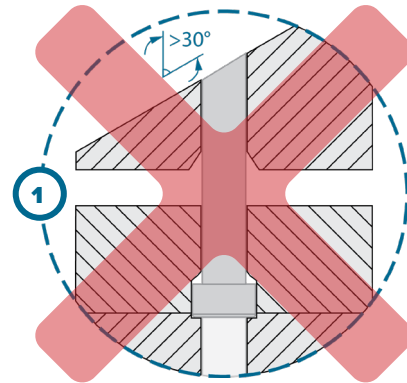
RJG, Inc. is not responsible for the improper installation of this equipment, or any other equipment RJG manufactures.

Proper RJG equipment installation does not interfere with original equipment safety features of the machine. Safety mechanisms on all machines should never be removed.

INSTALLATION ERRORS

EJECTOR PIN ISSUES

1. Pin size, expected pressure, and/or expected temperature not appropriate for selected sensor.
 - Refer to “Sensor and Ejector Pin Size” on page 2.
2. Ejector pin is located behind mold surface with angle greater than 30° (**1** at right).
 - Angles greater than 30° cause excessive side-load friction and influence sensor accuracy.
3. Pin is engraved on head (**2** at right).
 - Pin heads must remain flat. Engrave pins on the side if necessary.

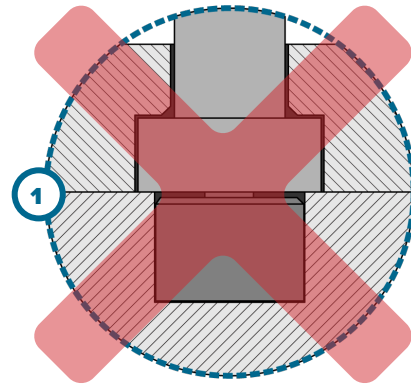


INSTALLATION ERRORS (continued)

SENSOR HEAD ISSUES

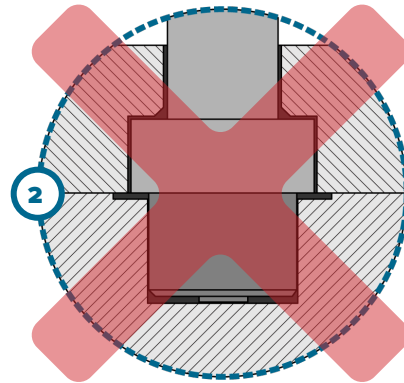
1. Ejector Pin head diameter is larger than sensor pocket diameter (1 at right).

- Counterbore the ejector plate, or chamfer the pin head to ensure that the pin rests only on the sensor nub.



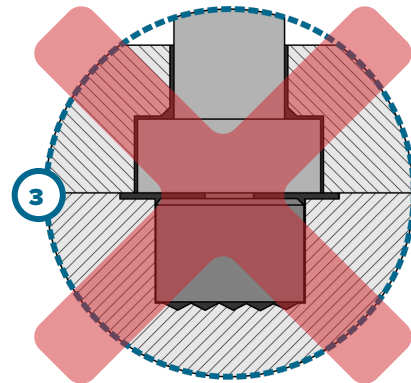
2. Sensor head is installed incorrectly (2 at right).

- The sensor nub must face the ejector pin. DO NOT install the sensor head upside-down.



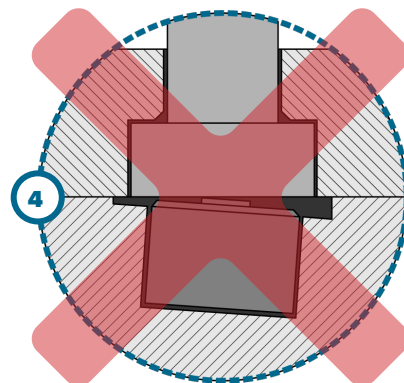
3. Sensor pocket surface is not smooth (3 at right).

- The mold surface must have a finish of $\sqrt[32]{}$ or better; the sensor pocket must have a smooth surface.



4. Sensor and ejector pin are not perpendicular (4 at right).

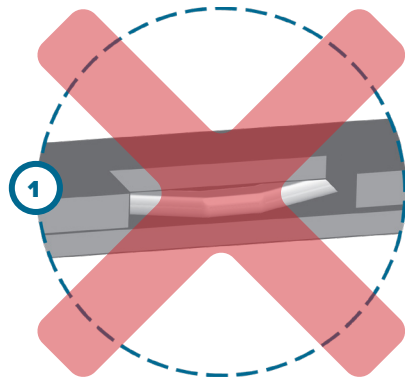
- The sensor and ejector pin must be perpendicular.



INSTALLATION ERRORS *(continued)*

CASE AND CABLE ISSUES

1. Sensor cable is pinched during mold assembly (1 at right).



CUSTOMER SUPPORT

Contact RJG's Customer Support team by phone or email.

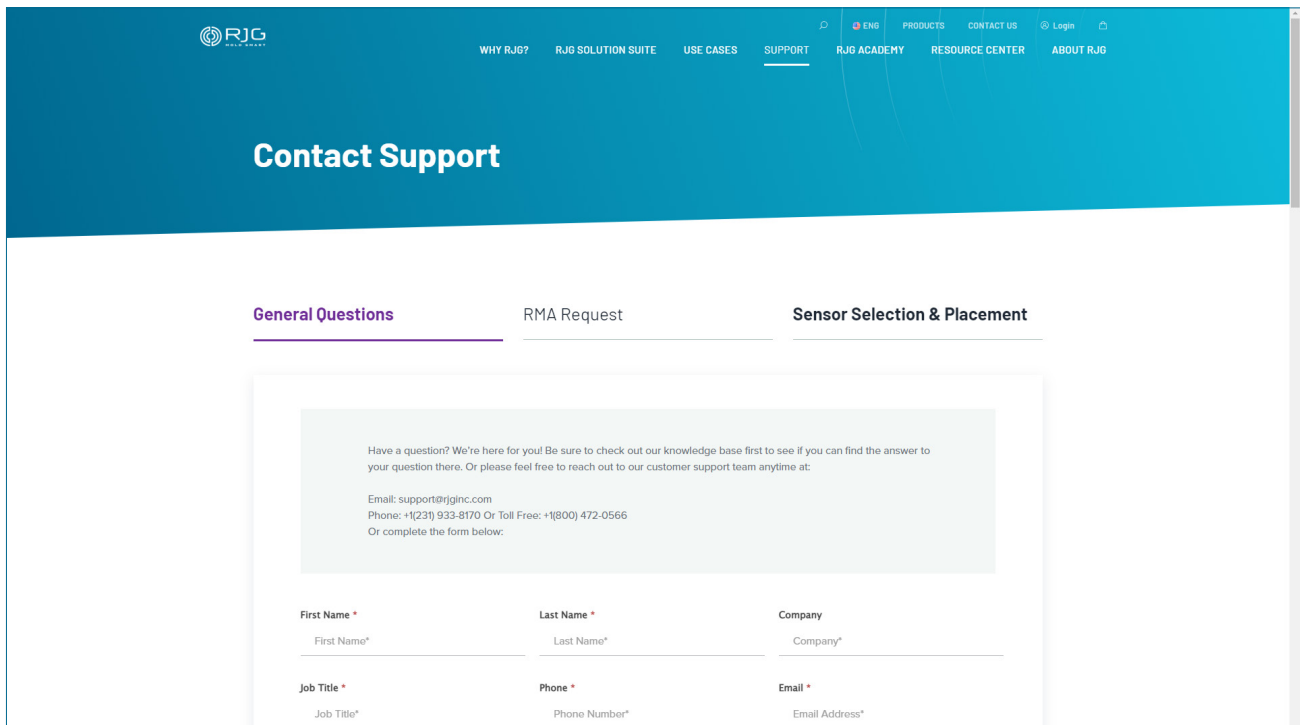
RJG, Inc. Customer Support

P: 800.472.0566 (Toll Free)

P: +1.231.933.8170

email: support@rjginc.com

www.rjginc.com/support



The screenshot shows the RJG Customer Support website. The header is blue with the RJG logo on the left and navigation links: WHY RJG?, RJG SOLUTION SUITE, USE CASES, SUPPORT (highlighted), RJG ACADEMY, RESOURCE CENTER, and ABOUT RJG. On the right side of the header, there are links for ENG, PRODUCTS, CONTACT US, and Login. Below the header, the main content area has a blue banner with the text "Contact Support". Underneath, there are three tabs: "General Questions" (selected), "RMA Request", and "Sensor Selection & Placement". The "General Questions" tab contains a light blue box with the following text: "Have a question? We're here for you! Be sure to check out our knowledge base first to see if you can find the answer to your question there. Or please feel free to reach out to our customer support team anytime at: Email: support@rjginc.com Phone: +1(231) 933-8170 Or Toll Free: +1(800) 472-0566 Or complete the form below:". Below this text is a contact form with six input fields arranged in two rows and three columns. The first row contains "First Name *", "Last Name *", and "Company". The second row contains "Job Title *", "Phone *", and "Email *". Each field has a corresponding label below it: "First Name*", "Last Name*", "Company*", "Job Title*", "Phone Number*", and "Email Address*".

RELATED PRODUCTS

COMPATIBLE PRODUCTS

The LES-B-127-50/125/500/2000 are compatible with other RJG, Inc. products for use with the eDART process control and monitoring system.

LYNX CABLES CE-LX5

The Lynx sensor cable (1 at right) is a polypropylene-coated cable suited for the heat and stress found in injection molding environments. The cable is available in lengths from 12– 473” (0,3–12 m), and can be ordered with straight or 90° fittings. One CE-LX5 is required to interface the LES-B-127-50/125/500/2000 with the eDART system.



LYNX FIVE-PORT JUNCTION BOX J-LX5-CE

Up to five Lynx devices may be connected to the five-port junction box (2 at right), which interfaces the Lynx devices with the eDART System. The J-LX5-CE can be mounted on the mold or machine.



LYNX NINE-PORT JUNCTION BOX J-LX9-CE

Up to nine Lynx devices may be connected to the nine-port junction box (3 at right), which interfaces the Lynx devices with the eDART system. The J-LX9-CE can be mounted on the mold or machine.



SIMILAR PRODUCTS

RJG, Inc. offers a wide array of cavity pressure sensors for each application—strain gage, single-channel, multi-channel, and digital.

LYNX EMBEDDED 4,000 POUND SENSOR

The Lynx Strain Gage LES-B-159-4000 button-style sensor provides the same strain gage technology and indirect installation style as the LES-B-147-50/125/500/2000 sensors, but with a greater pressure threshold. The additional pressure range requires the LES-B-159-4000 to have a larger sensor head than its counterparts, and thus requires greater mold real estate for installation.

LYNX MULTI-CHANNEL STRAIN GAGE SYSTEM

The Lynx Multi-Channel Strain Gage system (1 at right) saves real estate on the mold providing simplified installation of up to eight sensors to one connection point on the mold.

2. Eight-Channel Strain Gage Adapter with Mold ID SG/LX8-S-ID

The ID SG/LX8-S-ID adapter resides on the molding machine, allowing technicians to move molds easily by disconnecting and connecting the connector cable. A Lynx cable then connects the adapter to the eDART system.

3. Eight-Channel Sensor Plate with Mold ID SG-8

The SG-8 plate resides on the mold allowing users to interface up to eight multi-channel strain gage sensors. A Lynx cable then connects the plate to the adapter and the eDART system.



4. Lynx Multi-Channel Strain Gage Button Sensors MCSG-B-127-125/500/200 and MCSG-B-159-4000

The MCSG-B-127-125/500/2000 and MCSG-B-159-4000 sensors provide the same strain gage technology and indirect installation style as the LES-B-147-50/125/500/2000 and LES-B-159-4000 sensors, but are compatible with the mold or machine-mount multi-channel components.

LOCATIONS / OFFICES

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