

TDMP-1-CLEANKIT

The Cleaning Tool Kit is used to remove excess plastic from transducer mounting holes prior to installation. Installation of transducers into plugged and/or dirty mounting holes is a major cause of installation-related damage. The Cleaning Tool Kit allows the mounting hole to be properly cleaned and checked for integrity.

Cleaning tools are available for 1/2-20 mounting holes

Note: The cleaning tool should be used when the polymer is molten. Care must be taken not to exceed the specified torque rating (100 inch-pounds) so as to not damage the tool.



Tap

Guide Sleeve / Cleaning Drill

Gauge Plug

1/2-20 MOUNTING HOLE CLEANING PROCEDURE

Cleaning the Hole:

1. Clean threads of hole with bottoming tap until threads are clean.
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.

Checking the Hole:

1. Apply machinist blueing on gauge plug surfaces.
2. Insert the gauge plug into the hole and rotate until resistance is encountered.
3. Remove the gauge plug. Blueing should only be scraped off the 45 degree seat.
4. If blueing is removed elsewhere, the mounting hole is not clean or has been improperly machined.