



A properly machined mounting hole is vital to optimal operation of a melt pressure transducer or transmitter. Poorly machined holes can result in damage that causes unreliable output or even total failure.

The transducer mounting hole drill kit contains the necessary drill bits and taps needed to machine a standard transducer mounting hole, including a special pilot drill required to machine the 45 degree seat. Drill kits are available for the 1/2-20 mounting hole (KF12) and the M18x1.5 mounting hole (KF18)

1/2-20 MOUNTING HOLE DRILLING PROCEDURE

1. Drill starter hole with the 9/32" drill bit.
2. Ream the hole with the 5/16" reamer.
3. Review mounting hole drawing and figure the depth required for the .451/.458" hole to leave .225" minimum length of the 5/16" (.312") diameter hole. Using the special 29/64" pilot drill bit, drill to the above specified depth, leaving a little excess to be removed in step 7.
4. Drill with the 17/32" drill bit, if necessary, so as to leave approximately 1" of the 29/64" diameter hole length.
5. Tap with the 1/2-20 plug tap; do not touch the chamfered seating surface that was produced by the pilot drill bit.
6. Tap to final depth with the 1/2-20 UNF bottoming tap.
7. Examine the seating surface of the mounting hole. If it has been marked by the tapping operation, touch it up with the pilot drill bit.

ORDER CODE

MOUNTING HOLE	
1/2-20 UNF	12
M18x1.5	18

Both KF12 and KF18 come complete with all necessary drills, reamers, taps, and instructions.

GEFRAN reserves the right to make any kind of design or functional modification at any moment without prior notice.