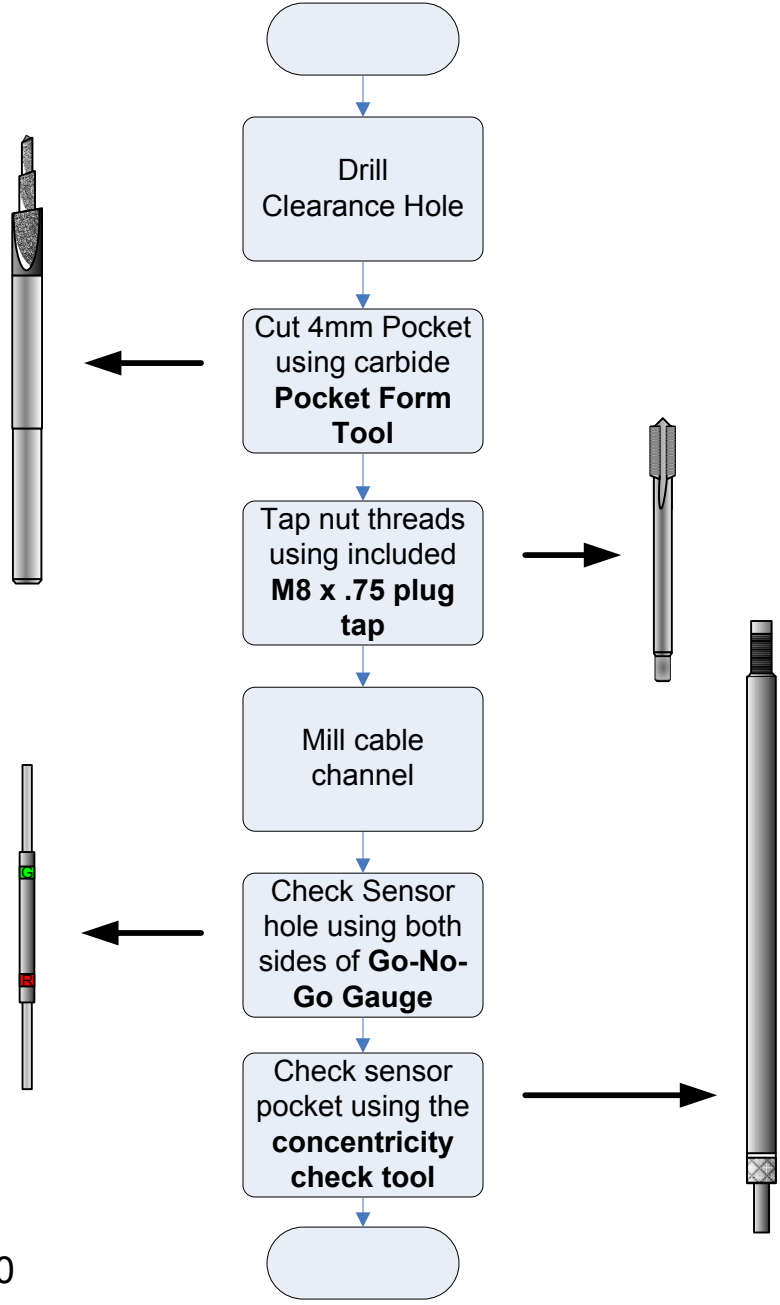


4 mm Flush Mount Sensor Installation/Check Kit



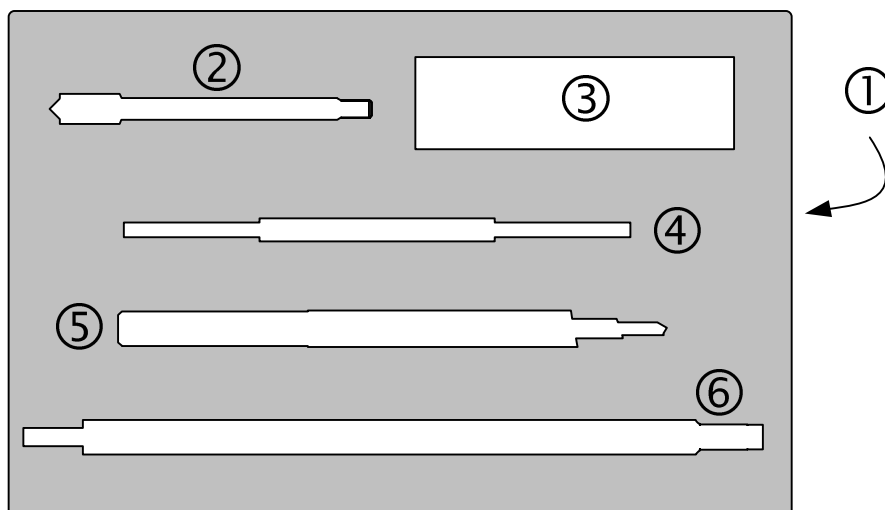
Rev. 6.0



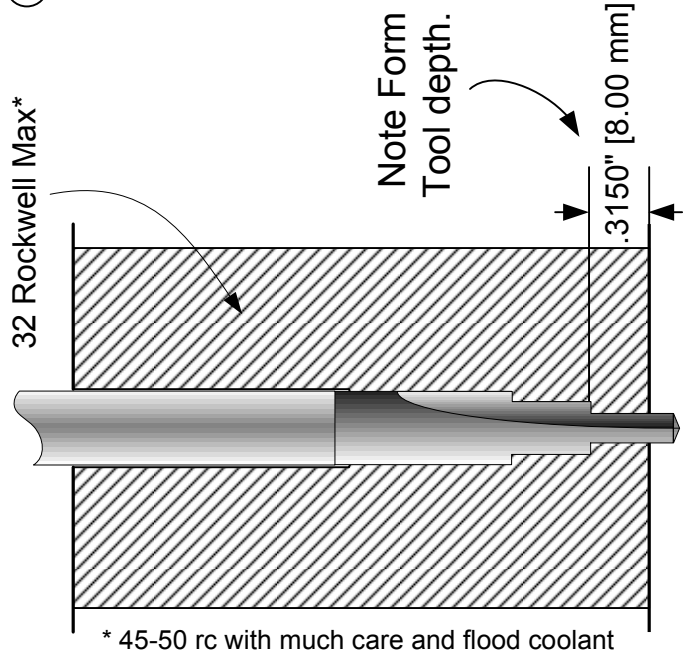
4 mm Flush Mount Sensor Installation/Check Kit

Reorder Information

	Part Number	Description
①	PA-BSPK-CAS	Carrying Case
②	89-00M8-TL1	M8 x .75 Thread Tap
③	MA-0040-BLK	4 mm Test Block
④	MA-6157-GNG	Go No-Go Gauge
⑤	MA-6157-SPM	4 mm Pocket Form Tool
⑥	MA-6157-CCK	Concentricity Checker



Pocket Form Tool Instructions [More](#)

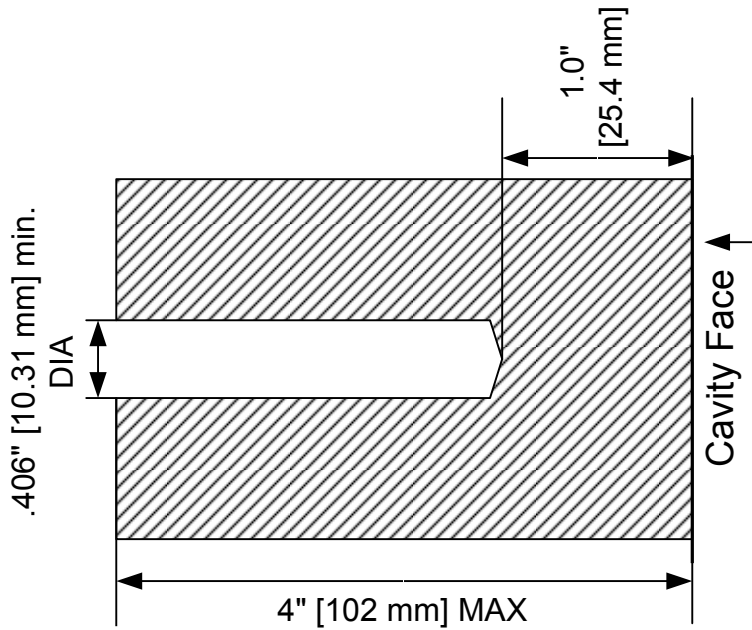


* 45-50 rc with much care and flood coolant

Step Two:

Use the Form Tool to form pocket.

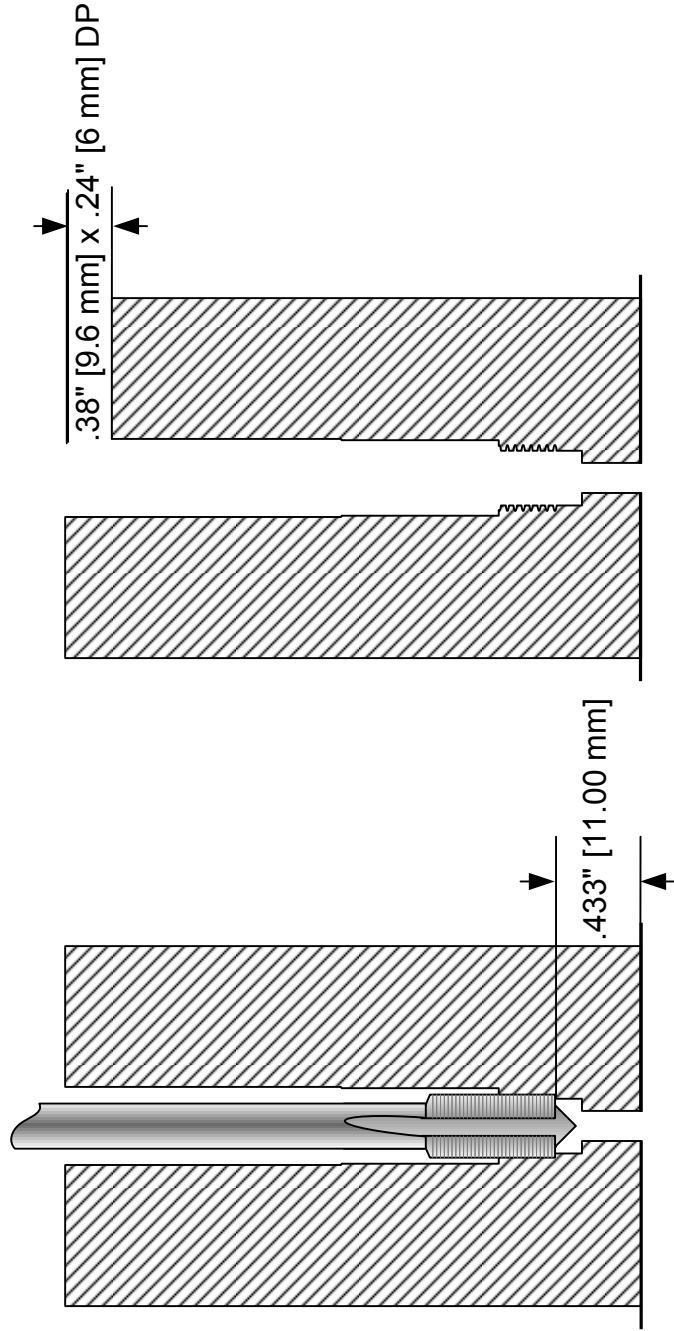
- 1680 rpm
- Bridgeport (or similar) type milling machine with a light hand feed
- Recommended .035 – .055 depth of cut pecking cycle used to clear material



Step One:

Drill a .406" minimum diameter clearance hole 1.0" from cavity.

Pocket Milling Instructions Cont'd



Step Three:

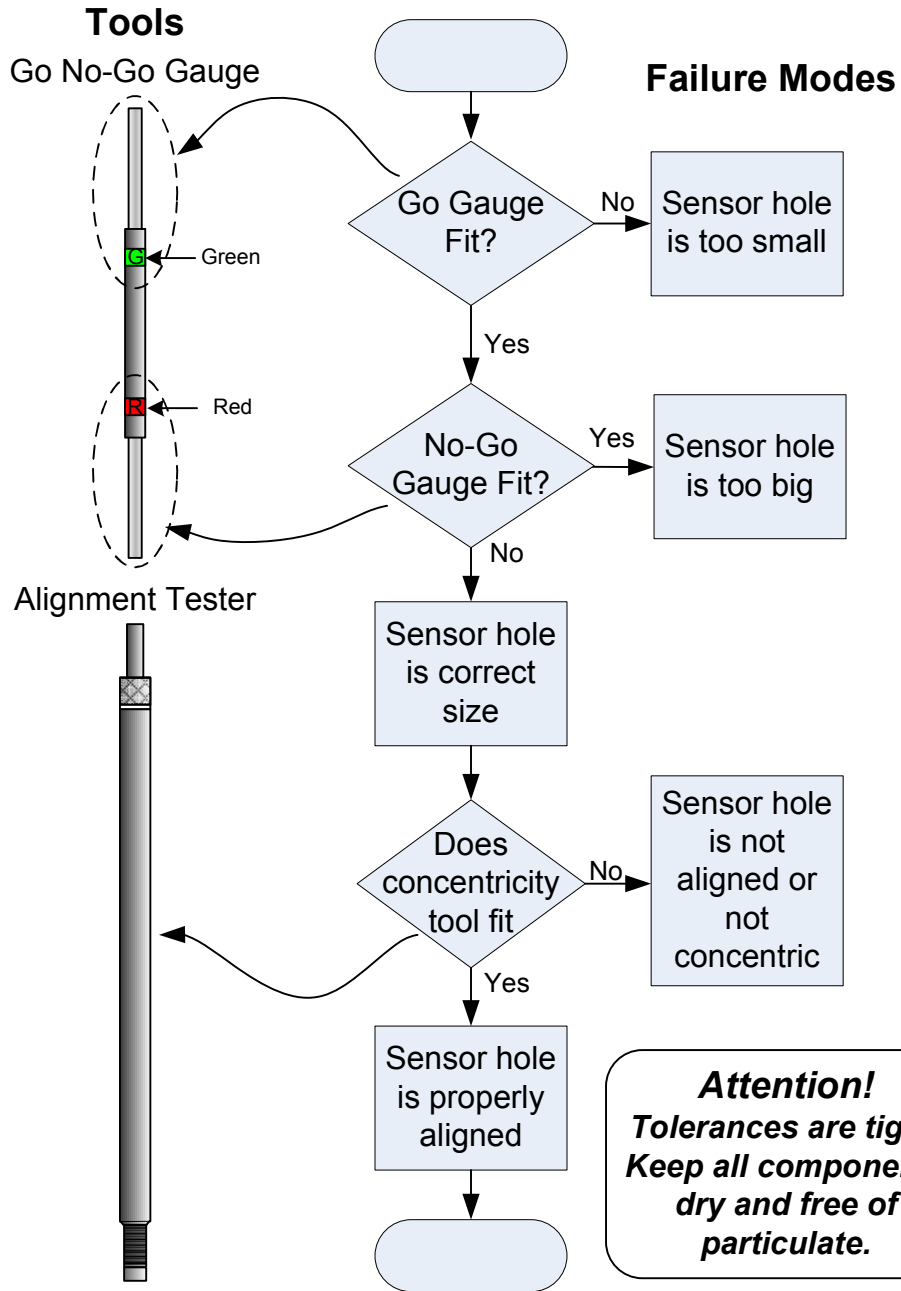
Use the M8 x .75 Thread Tap to form the Retaining Nut threads

Step Four:

Mill sensor cable channel.

Pocket Testing Instructions

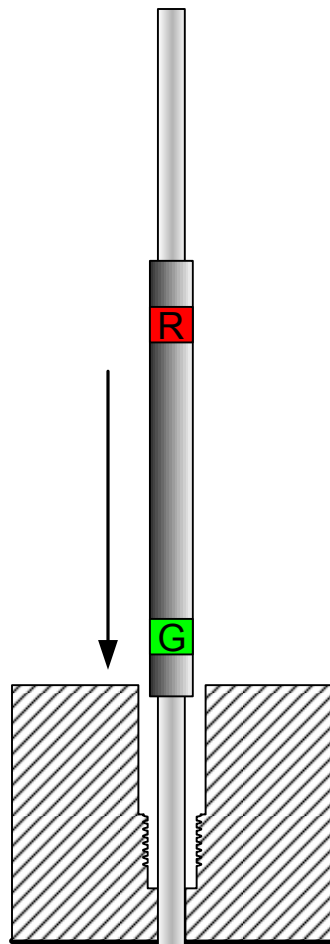
Order of Tests



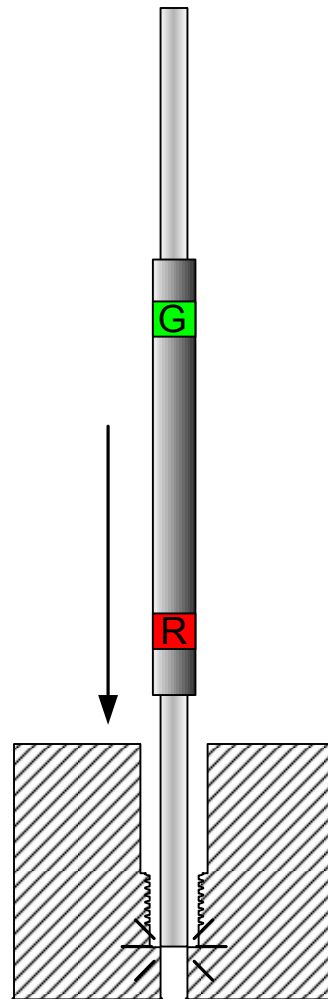
Go No-Go Gauge Instruction

The Go No-Go Gauge checks for the correct sensor hole size

The green side should fit in the hole easily



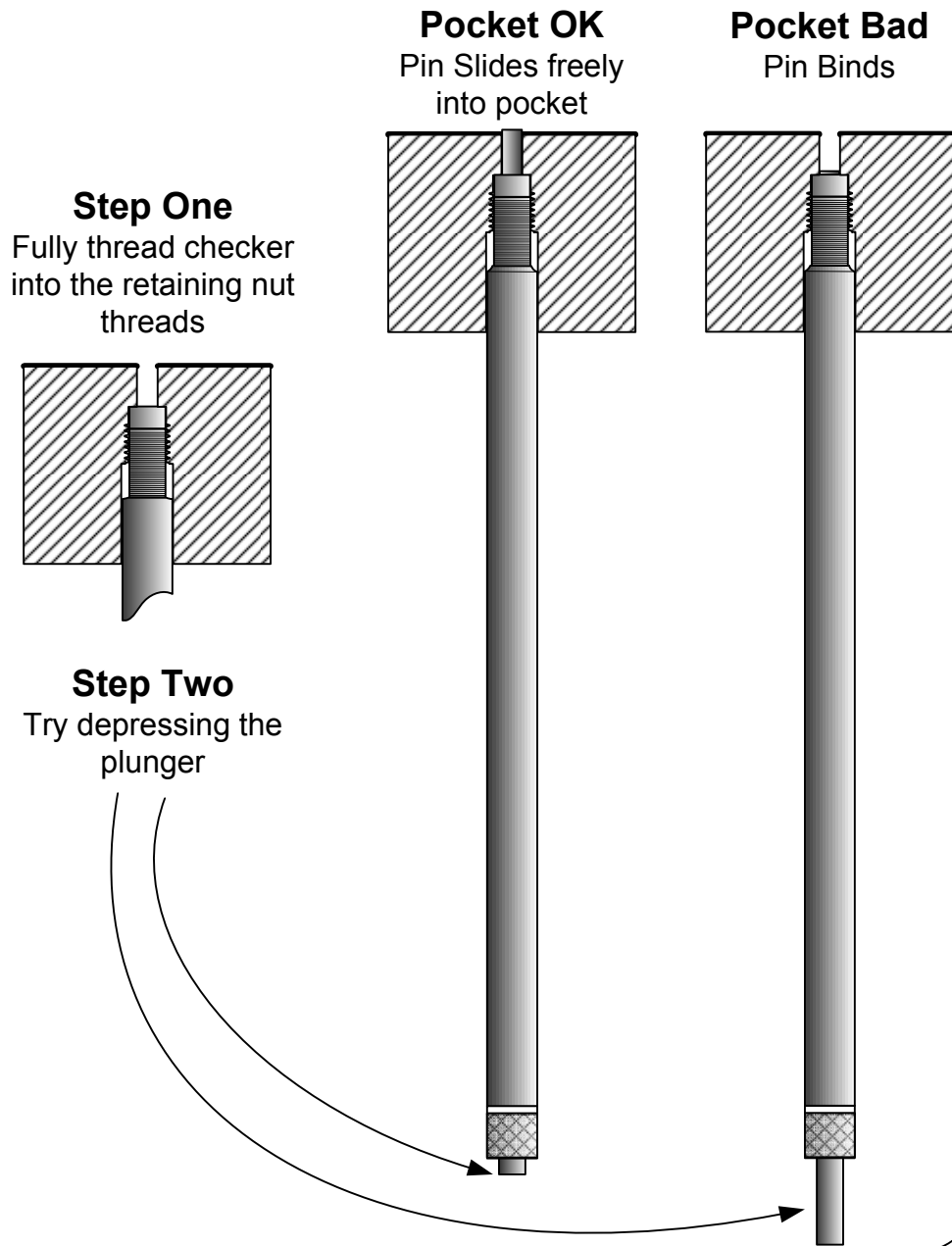
The red side should jam easily or not fit in the hole





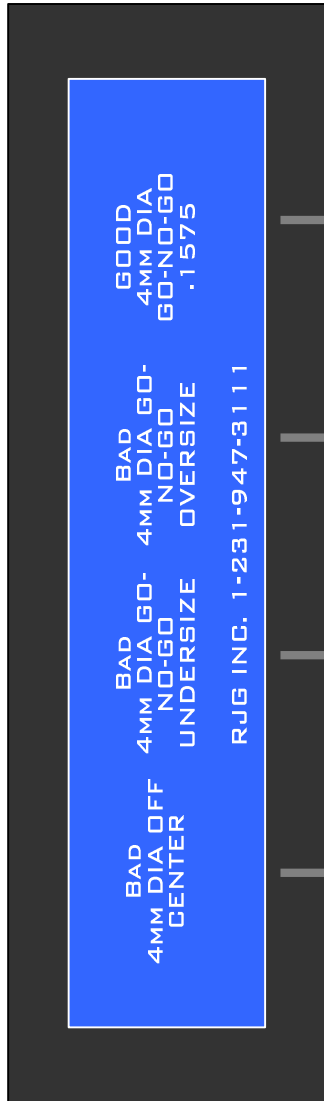
Concentricity Checker Instruction

checks the alignment and concentricity of the sensor pocket



Test Block Instruction

The test block reproduces a variety of pocket conditions so familiarity with the test equipment can be obtained



Order of Tests

Go Gauge Fit?

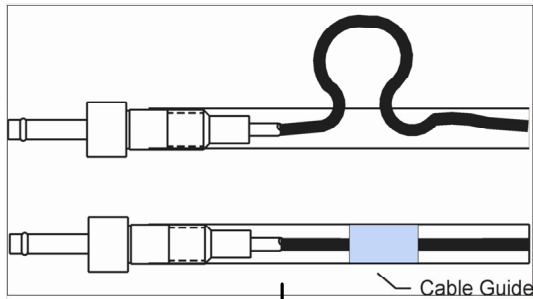
No-Go Gauge Fit?

Concentricity Tool Fit?

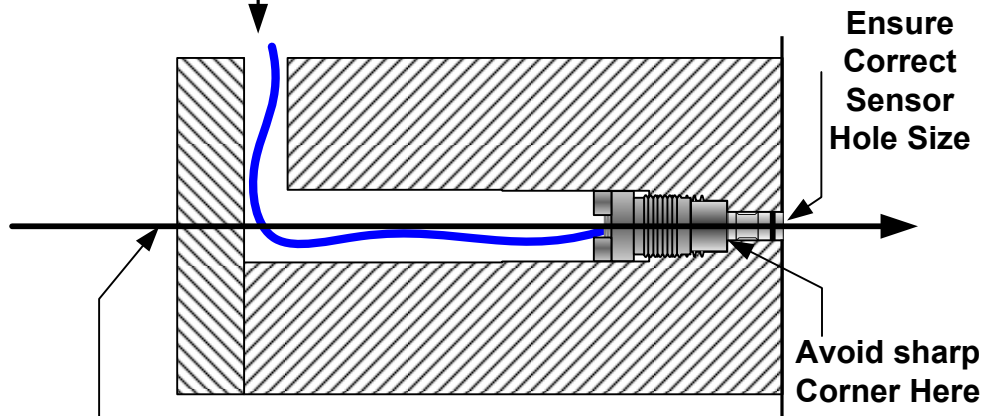
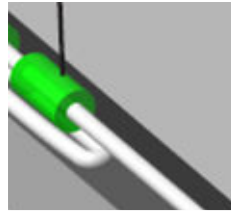
Yes (Hole not too small)	No (Hole too small) Pocket Fail	Yes (Hole not too small)	Yes (Hole not too small)
No (Hole not too big)		Yes (Hole too big) Pocket Fail	No (Hole not too big)
No (Hole off center) Pocket Fail			Yes (Hole is on center) Pocket OK

○ Installation Problems to be avoided

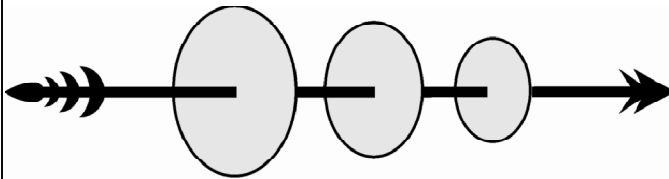
Avoid Pinched Wires



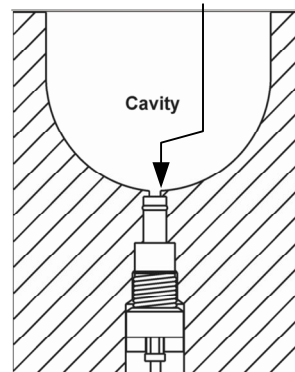
Avoid Kinked Wires



Ensure Pocket Concentricity



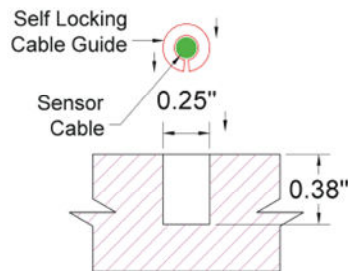
Avoid Steel Shut Off Conditions



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.



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.

