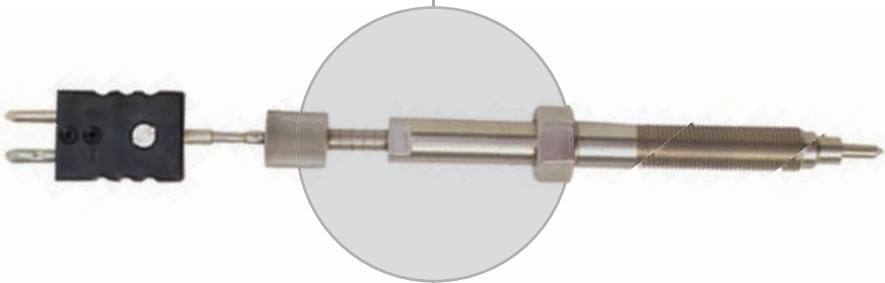


INSTALLATION GUIDE

Precision Tip Re-Adjustable Melt Bolt Thermocouple



PRODUCT DESCRIPTION

Pyromation's Precision Tip Re-Adjustable Melt Bolt Thermocouple is designed to accurately measure a temperature profile of varying depths across a plastic melt stream. The tip resists bending during start up and during maximum operating conditions and has a positive shut off to eliminate the backflow of plastic into the bolt. The sensor can be completely retracted from the extruder head while remaining installed. The re-adjustable design provides complete flexibility in installed sensor placement. Graduated markings on the sensor indicate varying depths for ease of use and placement repeatability.

SPECIFICATIONS

THERMOCOUPLE: 22 AWG Magnesium Oxide (MgO) Insulation

JUNCTION TYPE: Exposed Standard

TEMPERATURE RATING: 900 °F

BOLT: 3" or 6" Stainless Steel with 1/2"-20UNF 2A x 1 7/8" Threads

IMMERSION RANGE: 0" to 1"

TERMINATION: Standard Plug with Optional Mating Connector

ADJUSTING SCREW: Positive stop prevents disengagement during maximum operating conditions. Graduated markings appear at 1/8" increment.

INSTALLATION

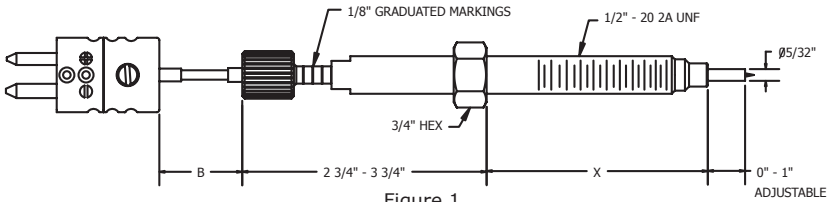


Figure 1

Removing existing sensor using the following steps:

1. Retract existing sensor to minimum immersion.
2. Allow machine to cool and return to an un-pressurized condition.
3. Remove sensor from machine.
4. Inspect mounting hole to ensure there is no debris or deterioration of the sealing surface and threads. See Figure 2 below. Clean and repair as needed.

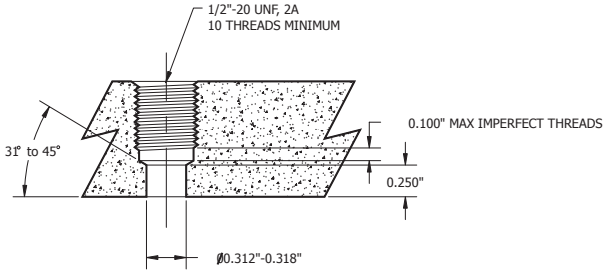


Figure 2

Install the new sensor using the following steps:

1. Retract the new sensor to minimum immersion.
2. Install sensor into mounting hole.
3. Tighten sensor into machine using the 3/4 inch hex to 40 foot/pounds.
4. Connect instrument extension leads.

OPERATION

The Melt Bolt should be fully retracted during operation start up. When the plastic reaches a melted state, the melt bolt can be immersed. Turn the adjusting screw clockwise to extend the tip, turn the screw counter-clockwise to retract the tip. The graduated markings are spaced at 1/8 inch intervals allowing for easy repeat sensor placement. Retract the melt bolt completely before allowing the melt stream to cool. Forcing the screw may result in damage to the sensor.

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