

# DYNISCO P/N 200925

## Transducer Mounting Hole Machining Tool Kit

### Description

The Transducer Mounting Hole Machining Tool Kit contains all of the necessary drills and taps to prepare a standard 1/2 - 20 UNF transducer mounting hole. The kit contains the special pilot drill required to machine the 45 degree seat. All tools included in this kit are made of premium grade, high strength tool steel. Care should be taken in the use of proper speeds and feeds, lubricants, and a method to assure continual alignment of each progressing tool. Consult Dynisco for additional or more specific information. M10 and M18 kits also available.



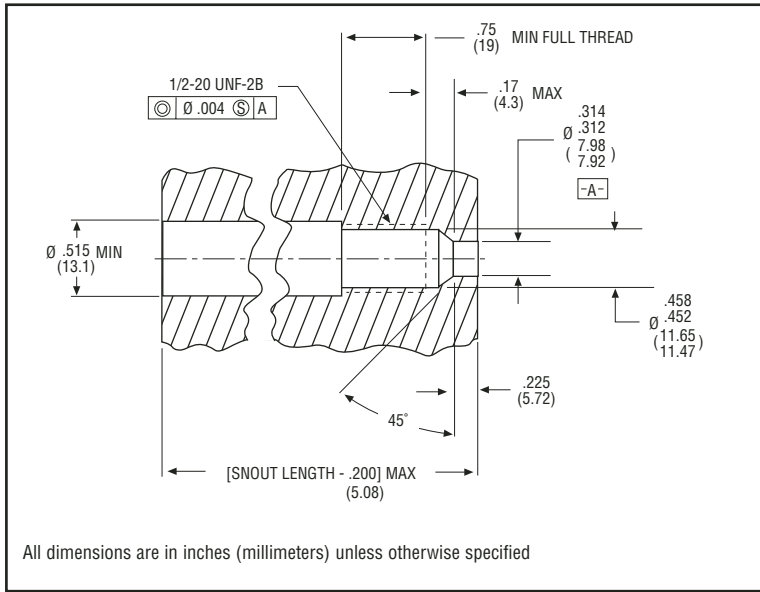
### Suggested Procedure

- Step 1** Drill a hole with the 9/32" drill.
- Step 2** Ream the hole with the 5/16" reamer.
- Step 3** Consult the mounting hole drawing and calculate the depth required for the .451/.458" hole to leave .225" minimum length of the 5/16" diameter hole. Using the special 29/64" pilot drill, drill to the depth calculated above, perhaps leaving a little excess to be removed in step 7.
- Step 4** Drill with the 17/32" drill, if necessary, so as to leave approximately 1" of the 29/64" diameter hole length.
- Step 5** Tap with the 1/2 - 20 plug tap (tap with tapered lean) as deep as possible without striking the chamfered seating surface that was produced by the pilot drill.
- Step 6** Tap to the final depth with the 1/2 - 20 UNF bottoming tap.
- Step 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.

It is generally good practice to check the mounting hole before installing the transducer. One procedure is to coat a gauge plug (P/N 200908) with Dykem machine blueing on surfaces below the thread. Insert the gauge plug into the mounting hole and rotate the plug until surface binding is encountered. Remove and inspect. Blueing should only be scraped off of the 45 degree sealing chamfer. If blueing has been removed from other surfaces, the mounting hole has not been machined properly.

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**Note:** For models PT467 and PT435 please refer to mounting hole detail shown on page 216.

### Ordering Guide

Part Number	Weight
200925	1.5 lbs.

**Note:** The Transducer Mounting Hole Machining Kit contains all the necessary drills and taps to prepare a standard 1/2 - 20 UNF - 2B transducer mounting hole. All tools are contained in a convenient carrying case. Specify P/N901949 for an M10 cleaning tool kit or P/N200101 for an M18 kit.

### Ordering Guide (Replacement Parts)

Part Number	Description
200924	29/64 Pilot Drill
200926	9/32 Drill (.281)
200927	5/16 reamer (.3125)
200928	1/2-20 UNF GH5 Tap
200929	1/2-20 UNF GH5 Bottoming Tap
200930	17/32 Drill (.531)

### Delivery

All configurations express delivery.