

MICRO PROBES

Please read carefully before installing probes
 REFER TO : MINI PRINT # 1700

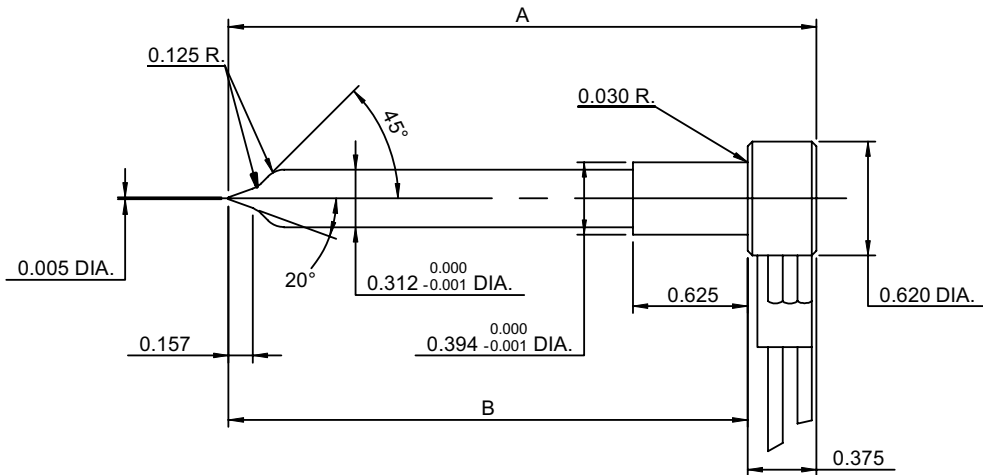


NOTE: PROBE DISCOLORATION

Each Integral Heater probe sold by D-M-E is pretested. This procedure discolors the outer surface of the probe, but in no way alters its performance or dimensions

AUTO-FIXED " INTEGRAL HEATER" MICRO PROBES
 (240 VAC, T/C TYPE J, 48" LEADS)

MATERIAL, AISI D-2 STEEL OR EQUIVALENT HARDNESS, 50-55 RC



CATALOG NUMBER	A DIM.	B DIM.	WATTS
AFIP3-310-90	3.095	2.720	110
AFIP3-360-90	3.595	3.220	130
AFIP3-410-90	4.095	3.720	150
AFIP3-460-90	4.595	4.220	170

Note: Dimensions shown in Inches.

IMPORTANT SAFETY INFORMATION

A hot-runner system includes electrical elements and may contain molten plastic at elevated temperature and pressure. To avoid injury, exercise caution by reading these instructions before servicing or operating the system.

These instructions must be passed on to the end user where they should be read before using this product. Failure to do so can result in serious injury or death.



Failure to comply will result in serious injury or death:

ELECTRICAL HAZARDS

Improper voltages or grounding can result in electrical shock. Use only with proper voltage and a proper earth ground.

To avoid electrical shock, do not operate product when wet.

Do not operate this equipment with covers or panels removed.

To avoid electrical shock, turn off main power disconnect and lockout / tag out before servicing this device. Do not connect temperature sensors to electrical power. It will damage the product and it can cause fire, severe injuries or even death.

If green ground wire present wire must be connected to the ground.

Do not rebend rigid leads. Rebending leads might result in damage to circuit. Product might absorb moisture when cool. Use low Voltage or power to drive out residual moisture before applying full power. Failure to do so may cause damage to this product.



Failure to comply can result in serious injury or death:

STORED ENERGY AND HIGH TEMPERATURE HAZARDS

This product maintains molten plastic at high pressure. Use caution when operating and servicing the system.

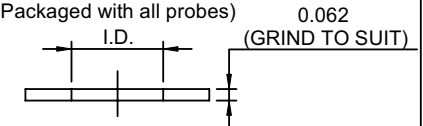
Physical contact with molten plastic may result in severe burns. Proper protective equipment, including eye protection, must be worn. This product has heated surfaces. Use caution when operating and servicing the system to avoid severe burns. Proper protective equipment should be worn.

ITEM	USED WITH AFIP3-310-90 THRU AFIP3-460-90
THERMOCOUPLE	TC-9900
ADJUSTMENT RING	RAF3-062
REGISTER RING	AFRR-03N
GATE INSERT	AFGI-03N

THERMOCOUPLE
 (Installed in probe)

CATALOG NUMBER	LEAD LENGTH
TC-9900	48"

ADJUSTMENT RINGS
 (Packaged with all probes)



CATALOG NUMBER	I.D.
RAF3-062	0.456

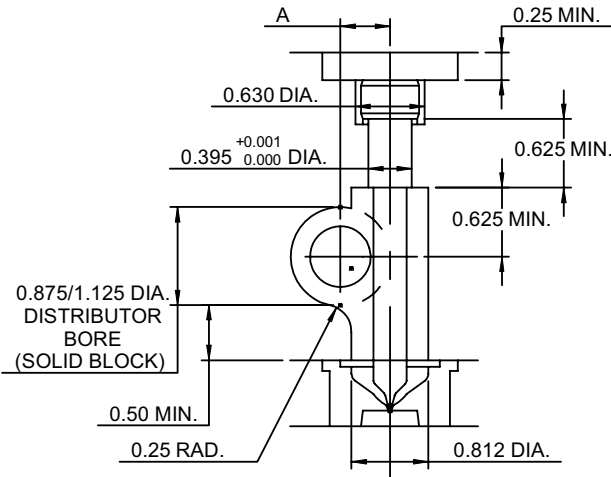
ME-0725-PS-216-B AFIP/ID
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 MICRO PROBES**

09-08

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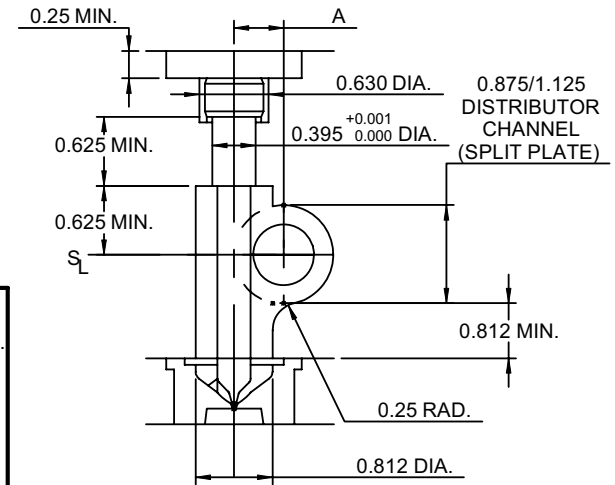
PROBE MACHINING DIMENSIONS - SOLID BLOCK DESIGN



PROBE CATALOG NUMBER	A DIMN. ±0.010	USED WITH
AFIP3 SERIES	0.428	0.394 DIA. DISTRIBUTOR PROBE (0.875 DIA. CHANNEL OR BORE)
	0.544	0.625 DIA. DISTRIBUTOR PROBE (1.125 DIA. CHANNEL OR BORE)
	0.550	0.628 DIA. DISTRIBUTOR TUBE (1.125 DIA. CHANNEL OR BORE)

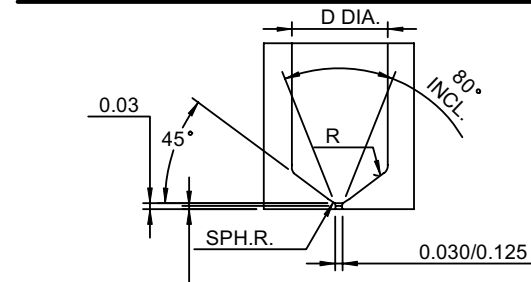
NOTE: THE S_L SYMBOL INDICATES THE SPLIT LINE FOR SPLIT PLATE DESIGNS.

PROBE MACHINING DIMENSIONS - SPLIT PLATE DESIGN



INSTALLATION CHECK LIST

- 1) Insure that 0.630 diameter counterbore has been machined for probe head.
- 2) Check the hold down plate thickness and machined channel to insure contact with probe and fit against adjustment ring.
- 3) Measure all probe machining dimensions the 0.395 diameter probe bore must be with in the tolerance specified.
- 4) Double check that the probe "X" dimension is correct.

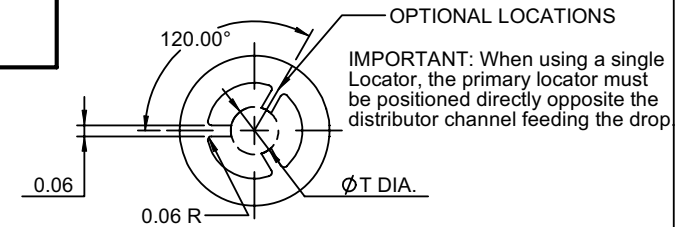


GATE MACHINING DIMENSIONS (SOLID BLOCK DESIGN)

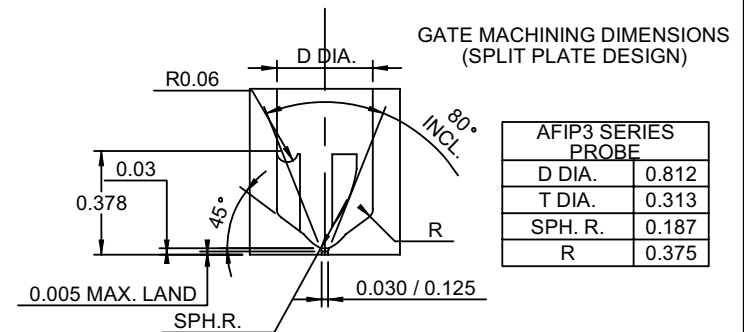
AFIP3 SERIES PROBE	
D DIA.	0.812
SPH. R.	0.187
R	0.375

WIRING INFORMATION

Probe Heaters are supplied with 48" long leads.
 Heaters are 240 VAC.
 2 power leads are Multi Color.
 Thermocouple is "J" Type.
 Thermocouple is supplied with 48"/ 24 Gage leads.
 1 T/C lead is WHITE and negative (-) constantan (non-magnetic).
 1 T/C lead is BLACK and positive (+) iron (magnetic).



OPTIONAL LOCATIONS
 IMPORTANT: When using a single Locator, the primary locator must be positioned directly opposite the distributor channel feeding the drop



AFIP3 SERIES PROBE	
D DIA.	0.812
T DIA.	0.313
SPH. R.	0.187
R	0.375

REFER TO MINI PRINT 1700 FOR GUIDELINES OTHER THAN THOSE SHOWN

INITIAL PROBE SET-UP DIMENSIONS

PROBE CATALOG NUMBER	X DIM.
AFIP3-310-90	0.000-0.003
AFIP3-360-90	0.000-0.004
AFIP3-410-90	0.000-0.004
AFIP3-460-90	0.000-0.005

X DIMENSION (PROBE TIP SETTING AT ROOM TEMPERATURE)

NOTE: X Dimension is for initial probe set up and may require further adjustment. Final position of probe tip will be determined by gate cosmetics and flow requirements.

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