## **INSTALLATION OF MINIATURE THREADED** AND STANDARD THREADED SERIES TRANSDUCERS HKS-375 ONLY 6-32 NC-2A 5/16-24 UNF-2A 3/8-24 UNJF-3A 10-32 UNF-2A 3/8-24 UNF-3A .760 NOM. OR .437 NOM .570 NOM. .520 NOM.-.320 NOM .103 NOM .152 NOM .250 NOM .320 NOM 10-32 UNF-2A 6-32 NC-2A -5/16-24 UNF-2A 3/8-24 UNJF-3A O - RING .145 I.D. X .026 C.S O - RING .176 I.D. X .040 C.S O - RING .239 I.D. X .061 C.S O - RING .301 I.D. X .064 C.S USE COPPER W ASHER .500 O.D. X .380 I.D. X .062 C.S FIG. 1 (b) FIG. 1 (c) FIG. 1 (a) FIG. 1 (d) FIG. 1 (e) For proper mounting of Figure 1 (e), an MS33649-3 port is required. The detail for this port is shown in Fig. 2 (e) and Fig. 2 (e) Detail. For convenience in machining, a contour cutter for MS33649 ports can be used to produce the required detail of the port and drill the pilot hole ready to be tapped. Mounting torque for the transducers is listed below. HKS-375 ONLY 6-32 NC-2A 10-32 UNF-2A 5/16-24 UNF-2A 3/8-24 UNF-3A 3/8-24 UNJF-3A 15 Inch Pounds (Max.) 80-120 Inch Pounds 80-120 Inch Pounds 15 Inch Pounds (Max.) 75 Inch pounds (Max.) 10-32 UNF-2B .750 MIN. DEPTH .510 BREAK CORNER 45° X .030 3/8" - 24 UNF-3B .500 MIN. FULL THREAD DEPTH 5/16 - 24 UNF-2B 6-32 NC-2B .525 MIN. DEPTH 500 MIN DEPTH .625 MIN. TAP DRILL DEPTH → .115 ← → .159 ← - .267 - .325 FIG. 2 (a) FIG. 2 (b) FIG. 2 (f) FIG. 2 (d) HKS-375 ONLY + .015 - .000 THREAD - PD MUST BE SQUARE WITH SURE K + .015 - .000 28 DIA WITHIN .003 FIR ACROSS .665 DIA. MIN. PD MUST BE CONCENTRIC WITH .665 DIA. WITHIN .030 FIR AND WITH .328 DIA. 438 328 + .015 WITHIN .005 FIR 328 CONCENTRIC TO .328 DIA. WITHIN .005 FIR. TO .665 DETAIL A .040 R .010 SURF. K .015 .063 DEPTH TO SUIT DESIGN .020 R MAX HEIGHT TO **DETAIL A** NOTE: MIN. FLAT BOSS FACE CLEARANCE PROVISIONS FOR FITTING, WRENCH, FITTING INSTALLATION AND TOOL FILLET RADII MUST BE ADDED AS REQUIRED FIG. 2 (c) MIN. DIA. FOR UNRESTRICTED FLOW OF FLUID MAY-BE ANY SIZE OR SHAPE PROVIDED CLEARANCE IS MAINTAINED TO .500 DEEP FOR FITTING 5/16-24 UNF-2B FIG. 2 (c) DETAIL THREAD - PD MUST BE SQUARE WITH SURF. K WITHIN .003 FIR ACROSS .665 DIA. MIN. PD MUST BE CONCENTRIC WITH .665 DIA. 500 WITHIN .030 FIR AND WITH .390 DIA. WITHIN .005 FIR. 32 + .015 - <u>.000</u> - 390. CONCENTRIC TO 125 .390 DIA. WITHIN .005 FIR. 120° ±0° 30' **DETAIL A** TO .665 SURF K .063 DEPTH TO SUIT DESIGN 45° ±5° .020 R MAX - HEIGHT TO SUIT DESIGN .162 NOTE: MIN. FLAT BOSS FACE CLEARANCE PROVISIONS FOR FITTING, WRENCH, FITTING INSTALLATION AND TOOL FILLET RADII MUST BE ADDED AS REQUIRED MIN. DIA. FOR UNRESTRICTED FLOW OF FLUID MAY BE ANY SIZE OR SHAPE PROVIDED CLEARANCE IS MAINTAINED TO .500 DEEP FOR FITTING FIG. 2 (e) 3/8-24 UNJF-3B FIG. 2 (e) DETAIL