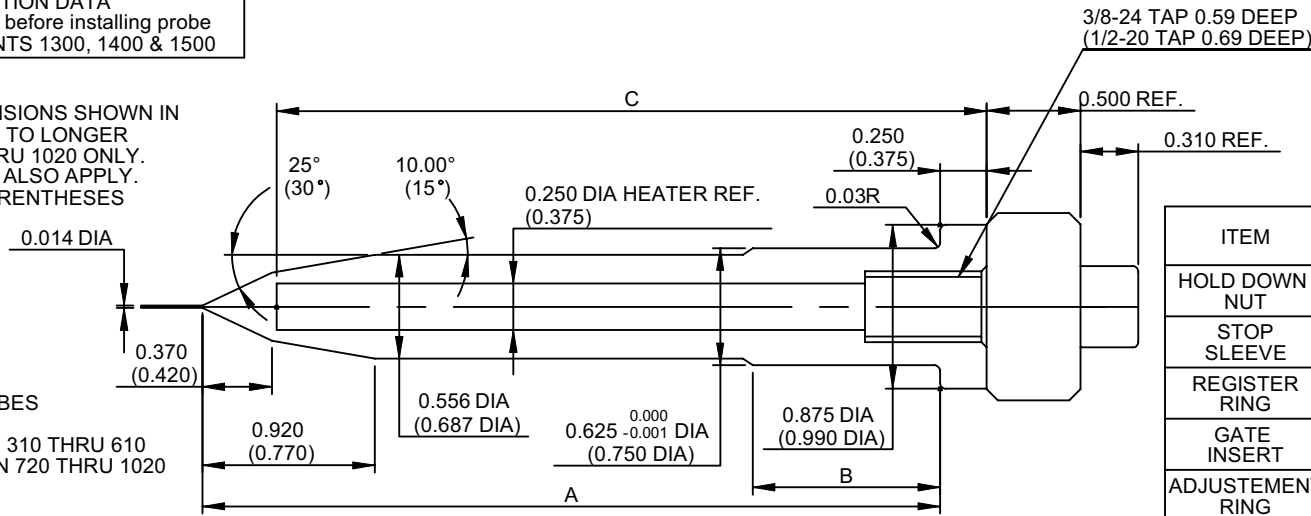


ME-0725-PS-217-B ID/AFN 09-08
 D-M-E
 AUTO-FIXED FINLESS PROBE
 INSTALLATION DATA
 Please read carefully before installing probe
 REFER TO MINI-PRINTS 1300, 1400 & 1500

AUTO-FIXED FINLESS PROBE(CAT. NOS. AFPN.310, .410, .510 and .610)
 Material: AISI D-2 Steel or equivalent (CAT. NOS. AFPN.720, .820, .920 and .1020)
 Hardness: 50-55 Rc



IMPORTANT: DIMENSIONS SHOWN IN PARENTHESES APPLY TO LONGER PROBES AFPN-720 THRU 1020 ONLY. TOLERANCES SHOWN ALSO APPLY TO DIMENSIONS IN PARENTHESES



EXAMPLE:
 +0.000
 -0.001 ----FOR ALL PROBES
 0.625 DIA ----FOR AFPN 310 THRU 610
 (0.750)DIA ----FOR AFPN 720 THRU 1020

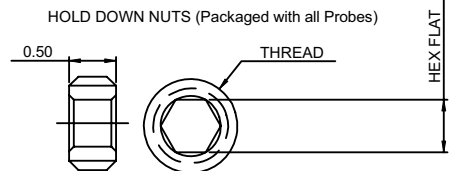
ITEM	USED WITH AFPN-310 THRU-610	USED WITH AFPN-720 THRU-1020
HOLD DOWN NUT	AFN-100	AFN-125
STOP SLEEVE	AFSS-38	AFSS-12
REGISTER RING	AFRR-10N	AFRR-20N
GATE INSERT	AFGI-10N	AFGI-20N
ADJUSTMENT RING	RAF-002 THRU RAF-125	TO SUIT

CAT.NO.	A DIM	B DIM	C DIM	T/C HEATER NO.
AFPN-410	3.625	0.875	3.470	AFTC-214-2
AFPN-510	4.625	0.875	4.470	AFTC-215-2
AFPN-610	5.609	0.875	5.450	AFTC-216-2

CAT.NO.	A DIM	B DIM	C DIM	T/C HEATER NO.
AFPN-720	7.000	1.500	6.925	AFTC-327-2
AFPN-820	8.000	1.500	7.925	AFTC-328-2
AFPN-920	9.000	1.500	8.925	AFTC-329-2
AFPN-1020	10.000	1.500	9.925	AFTC-3210-2

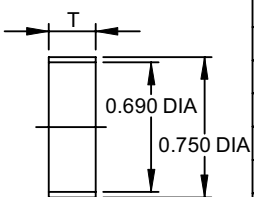
NOTE: Dimensions are in Inches.

'OMIT' "T" From T/C Heater Number When Ordering Non-T/C Heaters



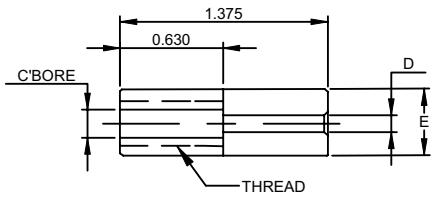
ADJUSTMENT RINGS
 For AFP(N)-310 Thru 610

CAT NO.	THREAD	HEX FLAT	USED WITH
AFN-100	1" - 8	9/16	AFP(N)-310 thru 610
AFN-125	1 1/4" - 12	5/8	AFPN-720 thru 1020

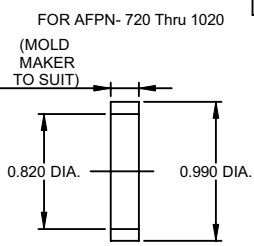


CAT. NO.	TDIM.
RAF-002	0.002
RAF-003	0.003
RAF-005	0.005
RAF-007	0.007
RAF-032	0.032
RAF-062	0.062
RAF-125	0.125

STOP SLEEVES (Packaged with all Probes)



CAT. NO.	D	E	C'BORE	THREAD	USED WITH
AFSS-38	0.187	0.375	0.265 DIA.	3/8" - 24	AFP(N)-310 thru 610
AFSS-12	0.300	0.500	0.390 DIA.	1/2" - 20	AFPN-720 thru 1020



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D-M-E
AUTO-FIXED FINLESS PROBE
INSTALLATION DATA

Please read carefully before installing probe
 REFER TO MINI-PRINTS 1300, 1400 & 1500

INSTALLATION CHECKLIST

- 1) 0.875 (1.000) Diameter Counterbore
 Is the thread depth sufficient to permit full tightening of the probe against the flat surface of the counterbore or adjustment ring?
- 2) 0.626 (0.751) Diameter Probe Bore
 Is the "A" dimension within the specified range?
- 3) Probe Set-Up Dimensions
 "Refer to chart. Check "X" dimension.

WIRING INFORMATION

Probe Heaters are supplied with 46" long leads.
 Heaters are 240 VAC.
 2 power leads are MultiColor.
 Thermocouple is "J" Type.
 Thermocouple is supplied with 46" long leads.
 1 T/C lead is WHITE and negative (-)
 constantan (non-magnetic).
 1 T/C lead is BLACK and positive (+)
 iron (magnetic).

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.

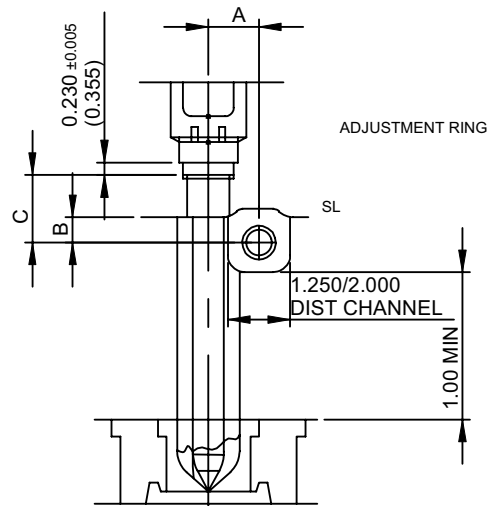


Failure to comply can result in serious injury or death:

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.

PROBE MACHINING DIMENSIONS (NOTE: Dimensions shown are common to either round or trapezoid)



NOTE: ONLY AFPN Series probes are recommended for the trapezoidal and round split plate concept

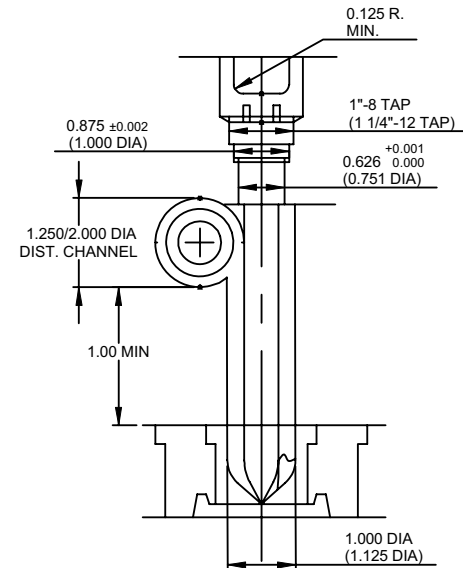
USED WITH 0.875 DIA. DISTRIBUTOR TUBE (1.25 CHANNEL)

PROBE CAT. NO.	A DIM.	B DIM. *	C DIM.
	±0.020	MIN.	MIN.
AFPN-410	0.796	0.37	1.25
AFPN-510	0.796	0.37	1.25
AFPN-610	0.796	0.37	1.25
AFPN-720	0.861	0.46	1.96
AFPN-820	0.861	0.46	1.96
AFPN-920	0.861	0.46	1.96
AFPN-1020	0.861	0.46	1.96

USED WITH 1.625 DIA. DISTRIBUTOR TUBE (2.00 CHANNEL)

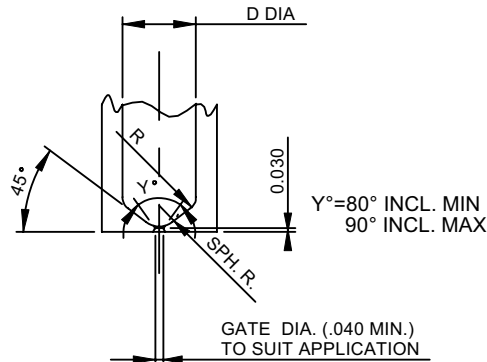
PROBE CAT. NO.	A DIM.	B DIM.	C DIM.
	±0.020	MIN.	MIN.
AFPN-410	1.171	0.48	1.35
AFPN-510	1.171	0.48	1.35
AFPN-610	1.171	0.48	1.35
AFPN-720	1.236	0.62	2.12
AFPN-820	1.236	0.62	2.12
AFPN-920	1.236	0.62	2.12
AFPN-1020	1.236	0.62	2.12

NOTE: Dimensions are in Inches.



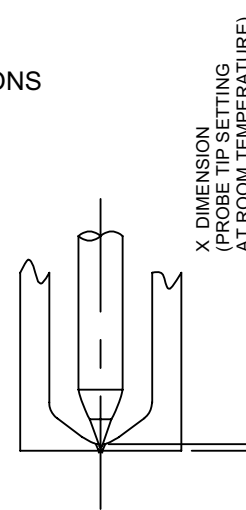
Dimensions in parentheses apply to AFPN-720 thru 1020 only

* The purpose of the "B" dimension is to insure adequate probe bore depth. It is NOT used to establish the location of the distributor tube.



INITIAL PROBE SET-UP DIMENSIONS

PROBE CAT. NO.	X DIM.
AFPN-410	0.000 - 0.004
AFPN-510	0.000 - 0.005
AFPN-610	0.000 - 0.006
AFPN-720	0.000 - 0.007
AFPN-820	0.000 - 0.008
AFPN-920	0.000 - 0.009
AFPN-1020	0.000 - 0.010



PROBE CAT NO.	D DIA.	SPH. R	R
AFPN - 310 THRU - 610	1.000	0.187	0.380
AFPN - 720 THRU - 1020	1.125	0.250	0.50

D-M-E COMPANY

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