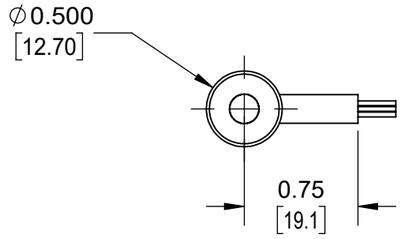
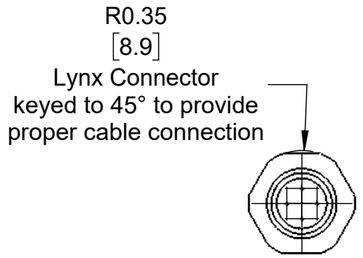
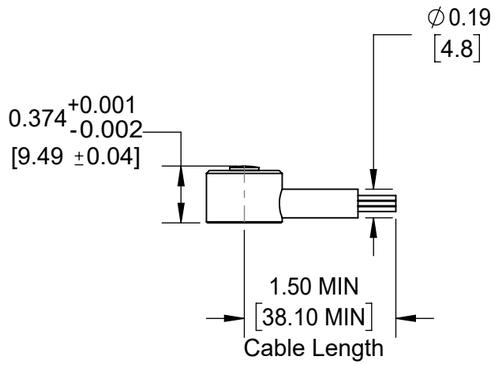
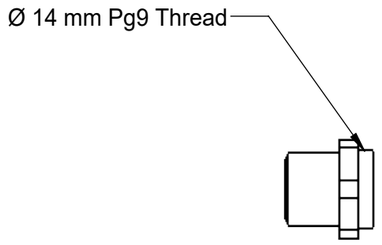
Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXX) Installation—Sensor Dimensions

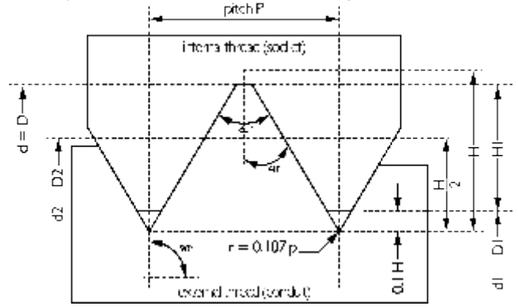








Lynx™ Connector Pg9 Thread



Data in mm
p = 25.4/tpi
r = 0.107 p
H = 0.595875 p
H1 = 0.8 h = 0.4767 p

Lynx Connector Pg9 Thread			
PG Nominal Size Callout	Pg9	Minor ∅ Male Thd. d1 [mm]	13.86
Major ∅ d=D [mm]	15.2	Thread Height H1 [mm]	0.67
Pitch p [mm]	1.411	Tap Drill ∅ [mm]	14
Threads per Inch tpi	18	Radius [mm]	0.15
Pitch ∅ d2=D2 [mm]	14.53		

NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30°

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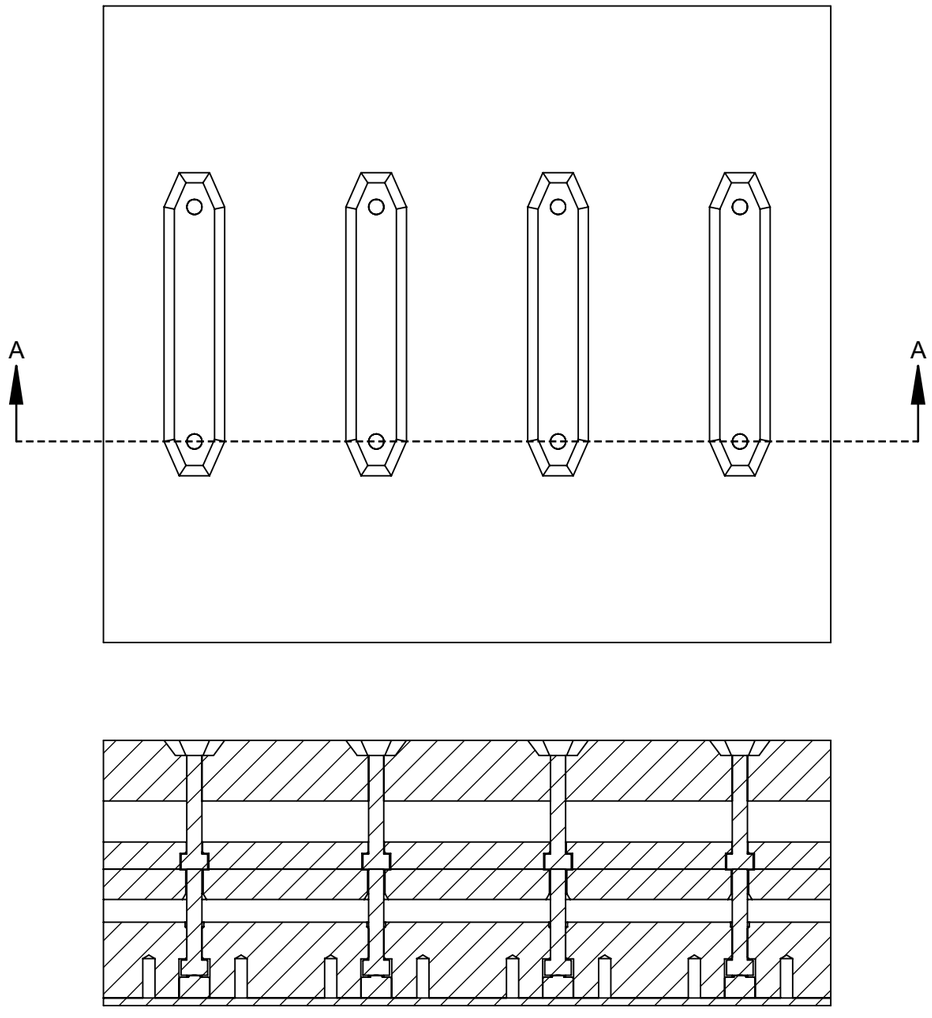
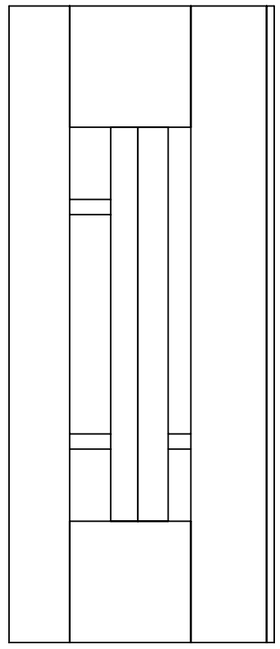
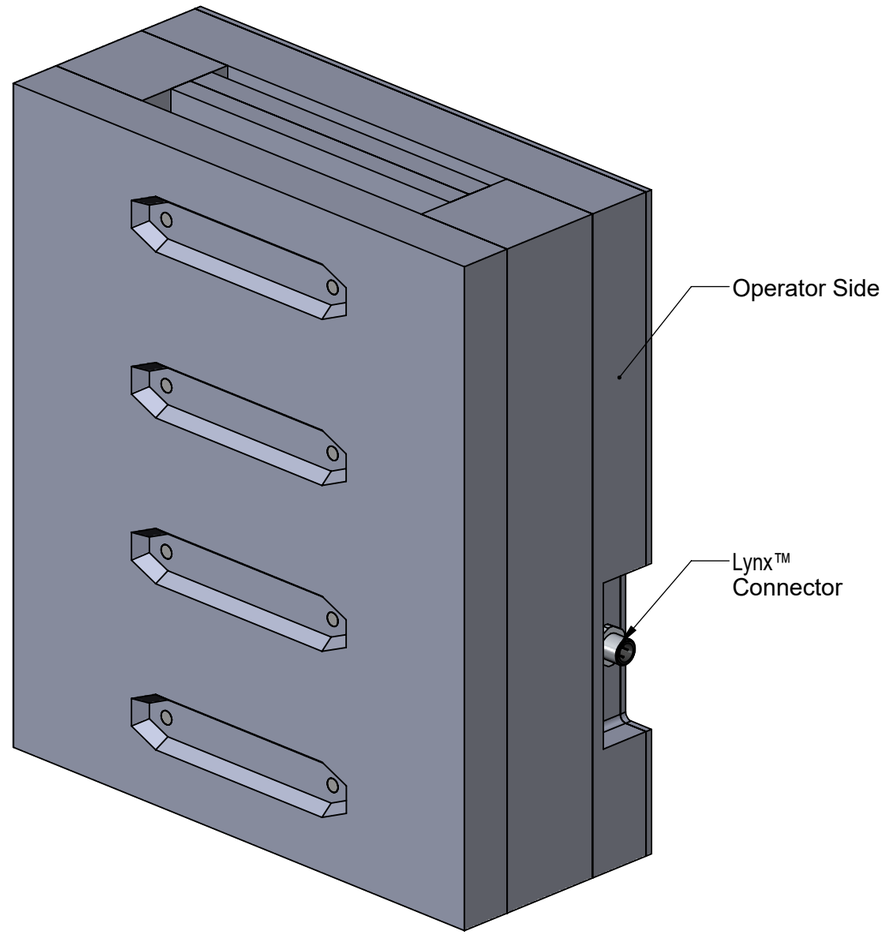
Description: LES-B-127-XXXX Sensor Installation	
Drawn:K.J.Brettschneider	
Design:	
Check: M.Groleau	
Date: 07.21.2022	

Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXXX) Installation—Clamp Plate Installation







SECTION A-A
SCALE 1 : 2.5

NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30'

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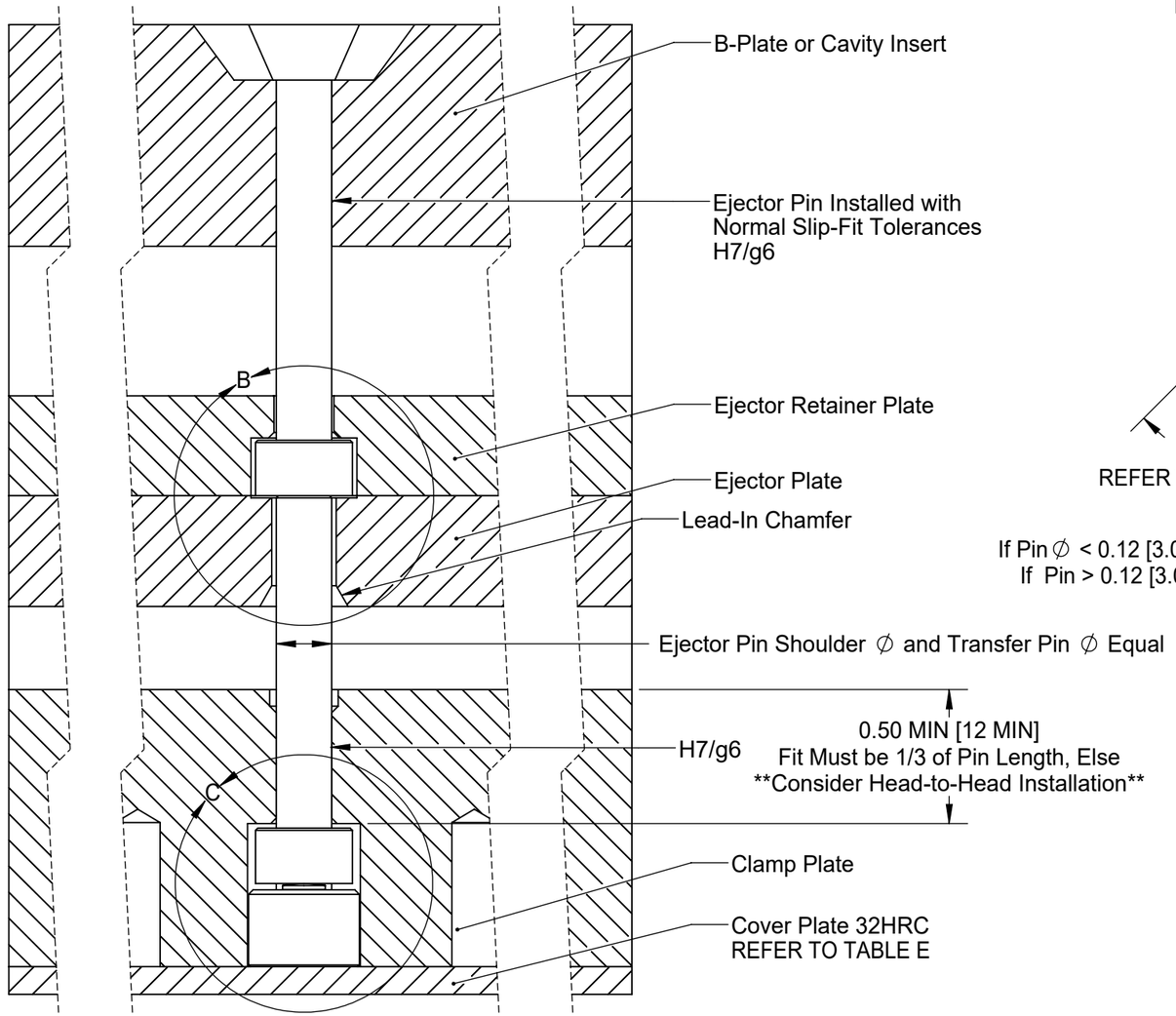
Description: LES-B-127-XXXX Sensor Installation	
Drawn:K.J.Brettschneider	
Design:	
Check: M.Groleau	
Date: 07.21.2022	

Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXXX) Installation—Clamp Plate Installation



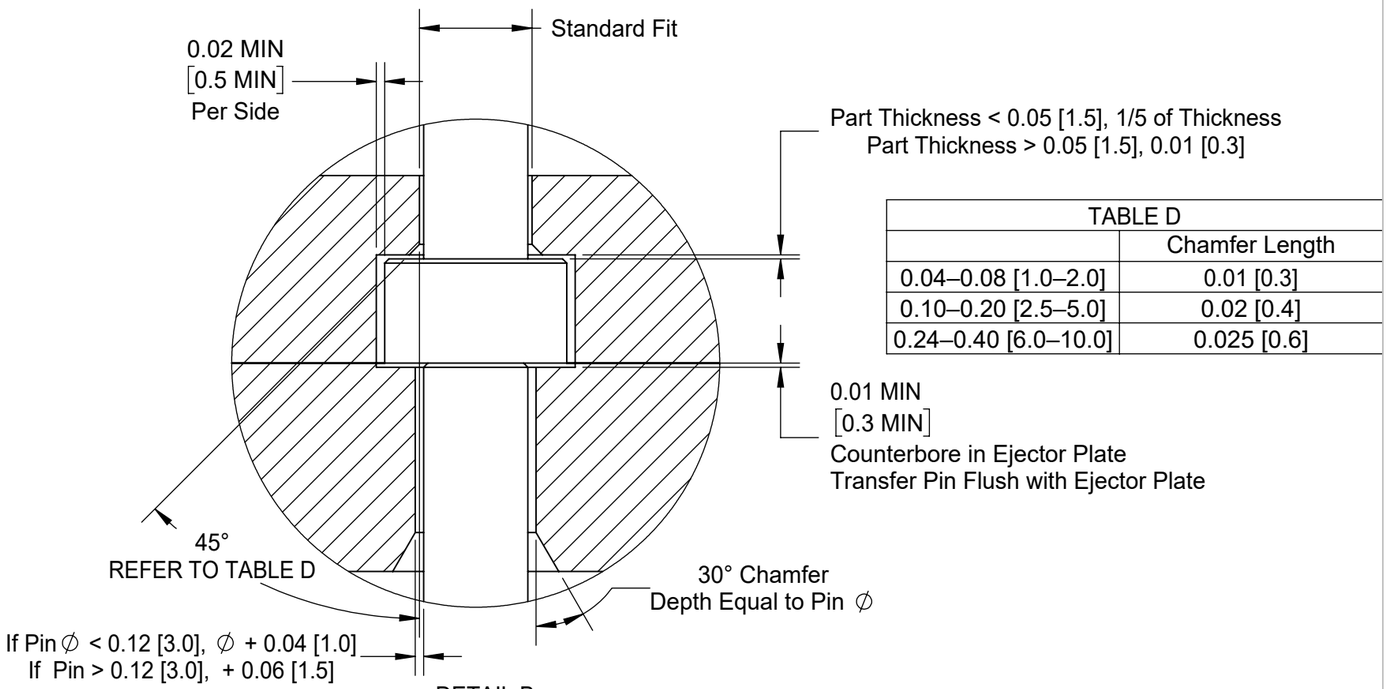
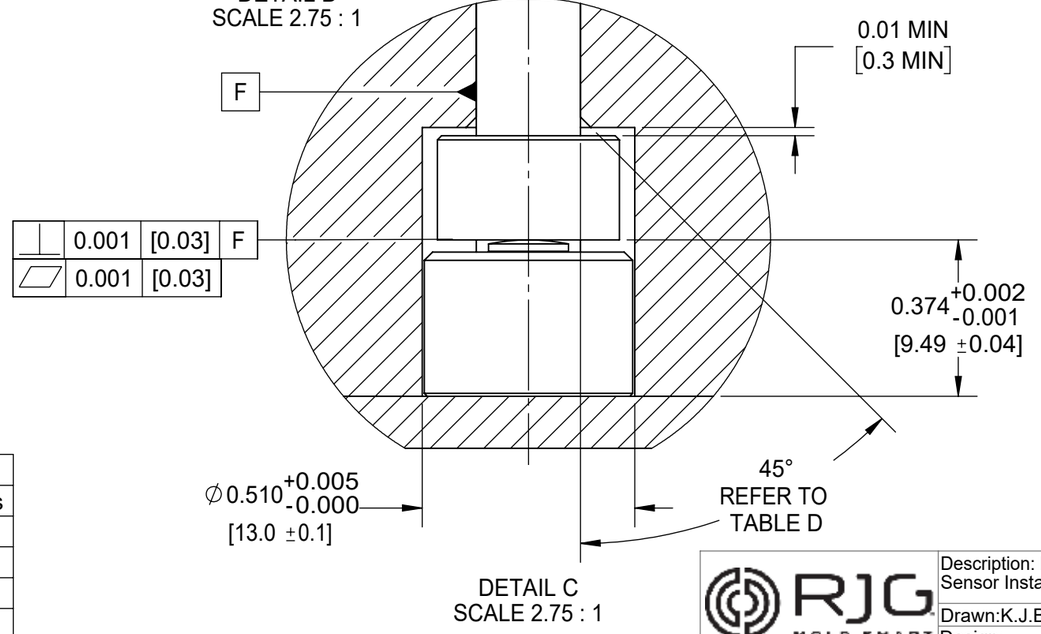


TABLE D	
	Chamfer Length
0.04–0.08 [1.0–2.0]	0.01 [0.3]
0.10–0.20 [2.5–5.0]	0.02 [0.4]
0.24–0.40 [6.0–10.0]	0.025 [0.6]



NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30°

TABLE E	
Sensor Model	MIN Plate Thickness
LES-B-127-50	0.2 [5]
LES-B-127-125	0.2 [5]
LES-B-127-500	0.25 [6]
LES-B-127-2000	0.25 [6]

Refer to Product Manual for Cover Plate Alternatives

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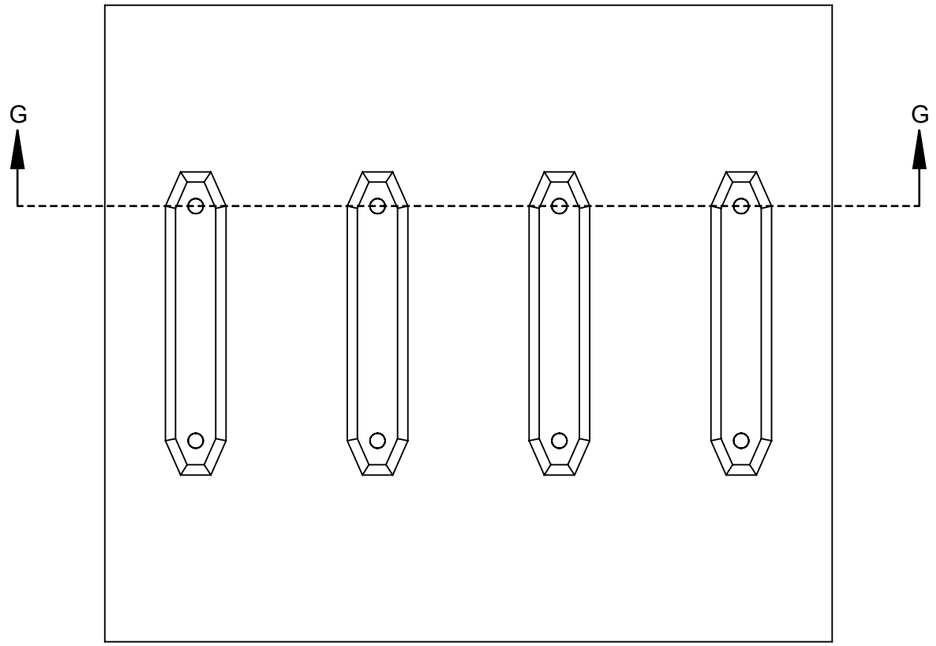
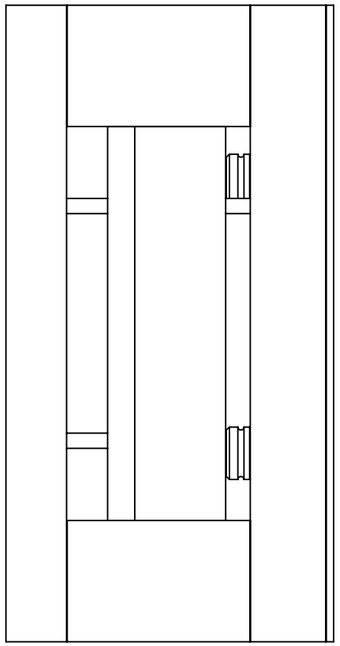
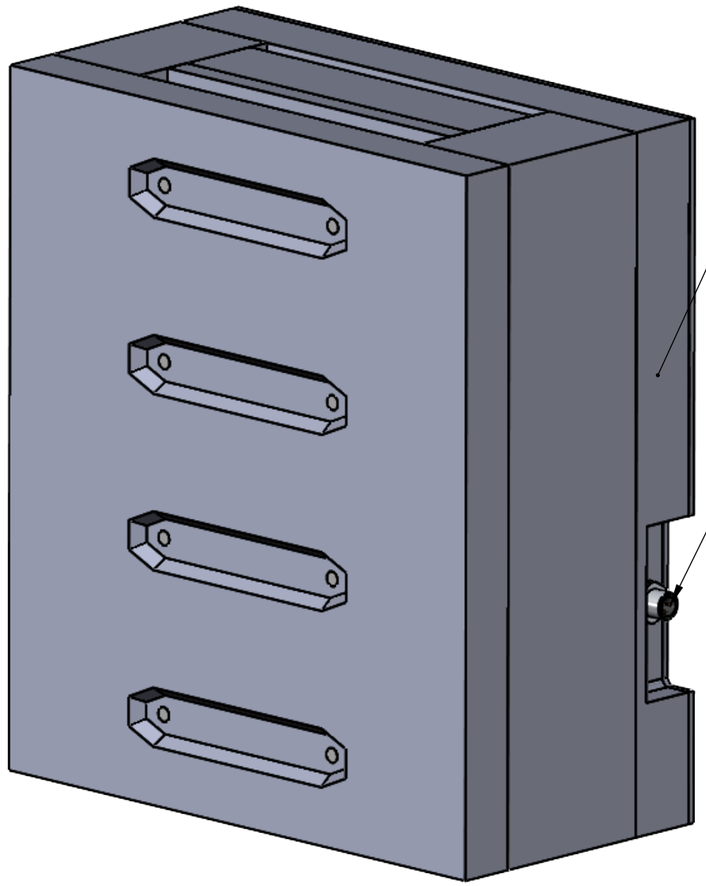
Description: LES-B-127-XXXX Sensor Installation
Drawn:K.J.Brettschneider
Design:
Check: M.Groleau
Date: 07.21.2022

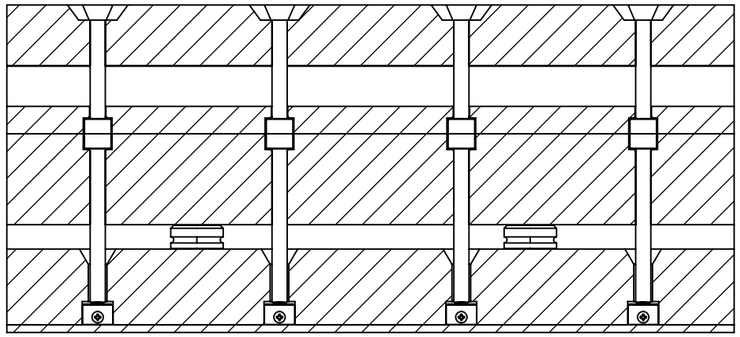
Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXXX) Installation—Head-to-Head Installation









SECTION G-G
SCALE 1 : 2.5

NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30°

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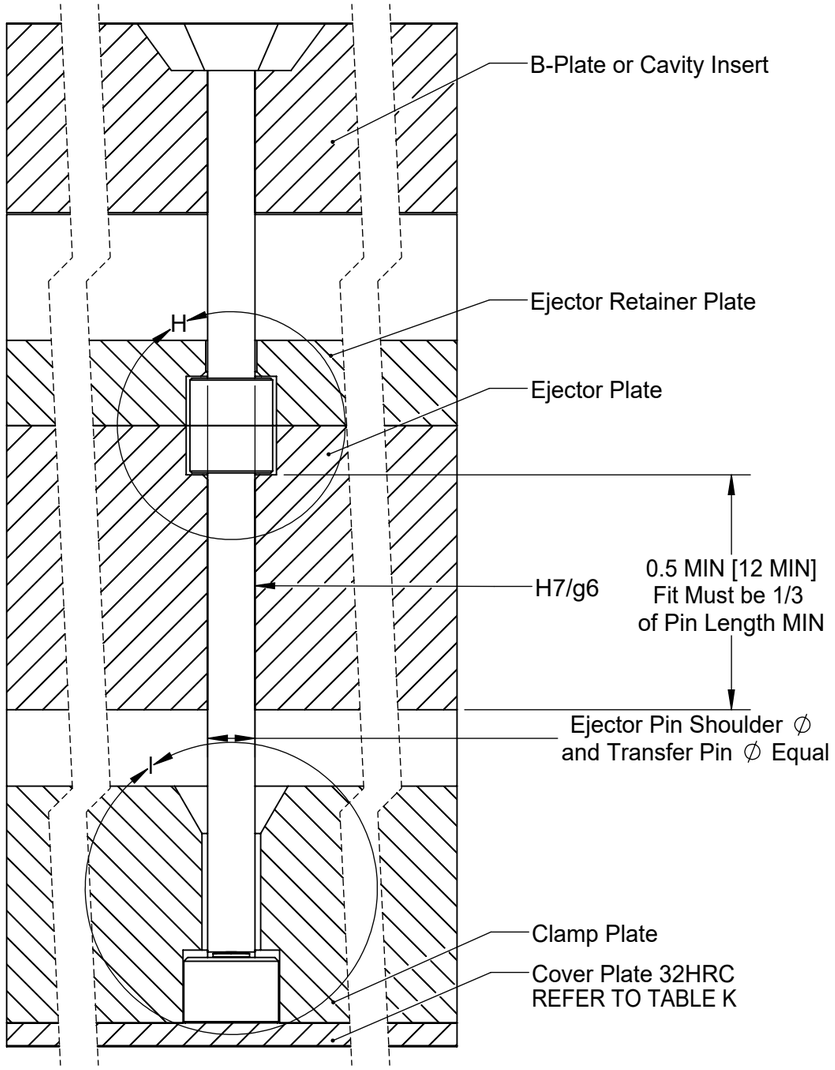
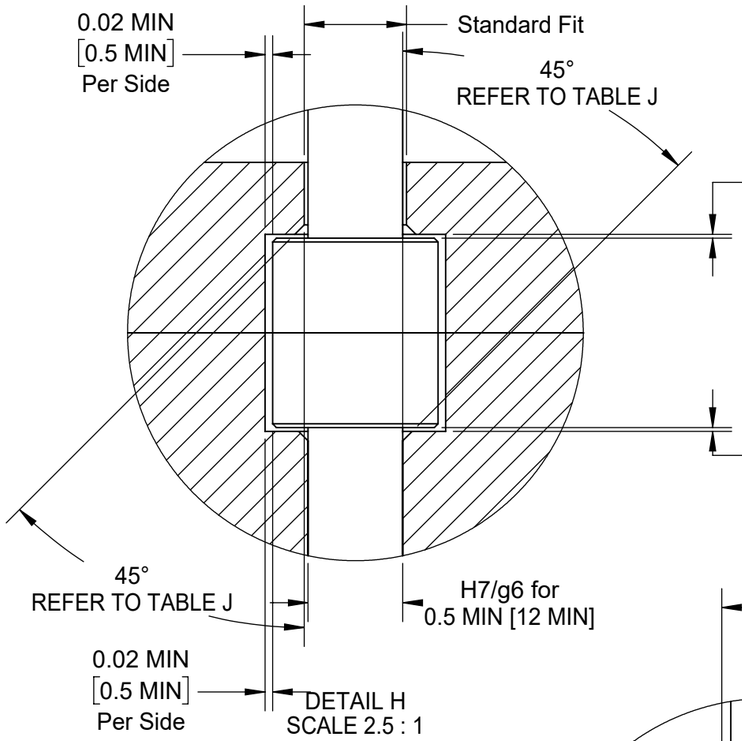
Description: LES-B-127-XXXX Sensor Installation	
Drawn:K.J.Brettschneider	
Design:	
Check: M.Groleau	
Date: 07.21.2022	

Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXXX) Installation—Head-to-Head Installation

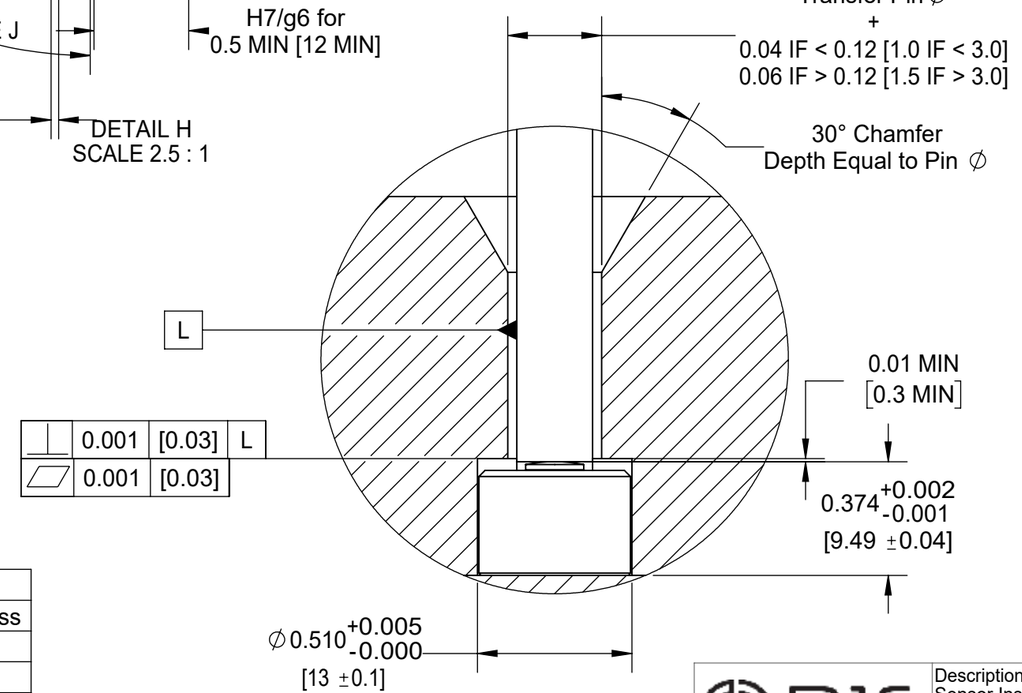




Part Thickness < 0.05 [1.5], 1/5 of Thickness
Part Thickness > 0.05 [1.5], 0.01 [0.3]

TABLE J	
	Chamfer Length
0.04–0.08 [1.0–2.0]	0.01 [0.3]
0.10–0.20 [2.5–5.0]	0.02 [0.4]
0.24–0.40 [6.0–10.0]	0.025 [0.6]

0.01 MIN
[0.3 MIN]
Counterbore in Ejector Plate
Transfer Pin Flush with Ejector Plate



NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30°

TABLE K	
Sensor Model	MIN Plate Thickness
LES-B-127-50	0.2 [5]
LES-B-127-125	0.2 [5]
LES-B-127-500	0.25 [6]
LES-B-127-2000	0.25 [6]

Refer to Product Manual for Cover Plate Alternatives

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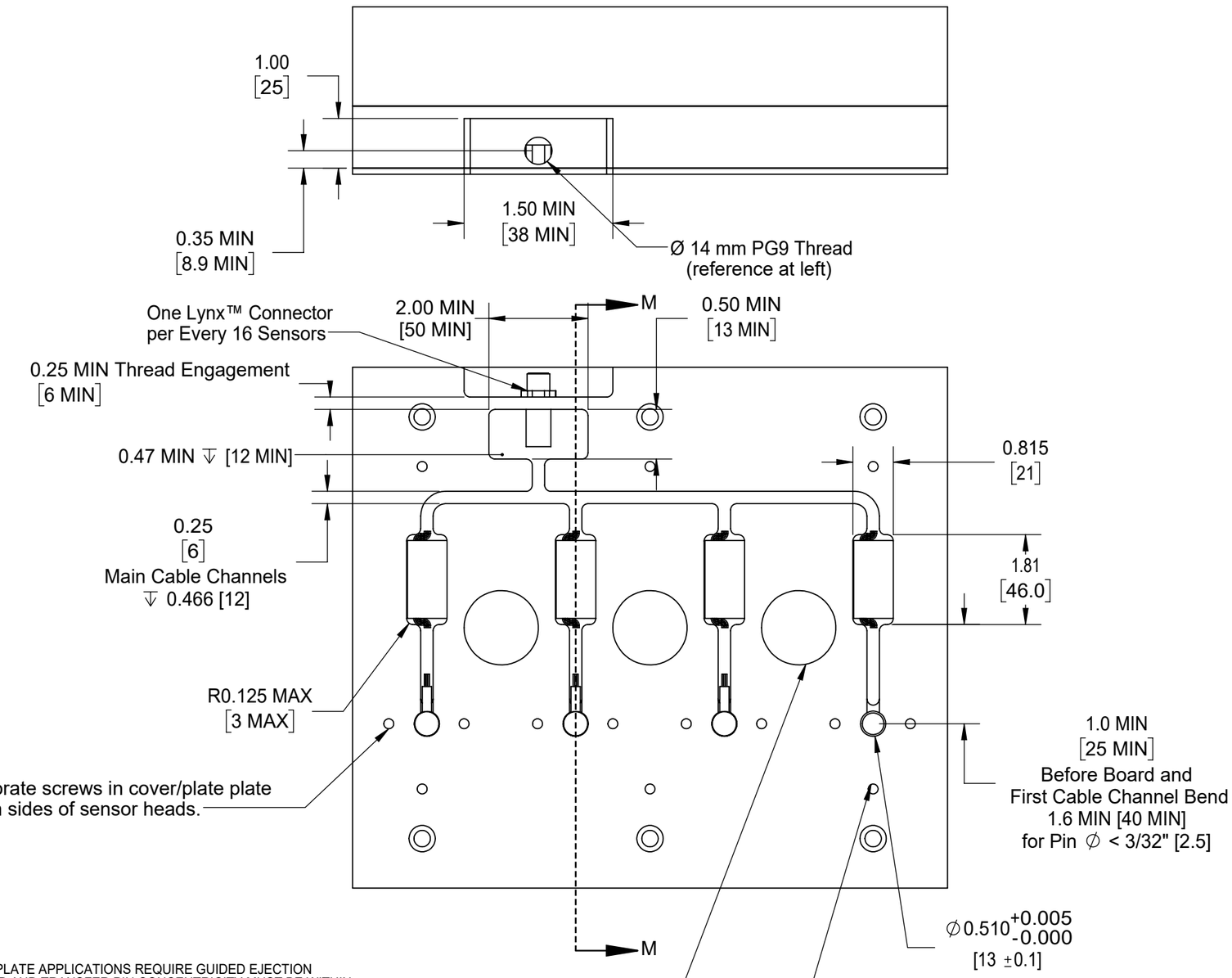
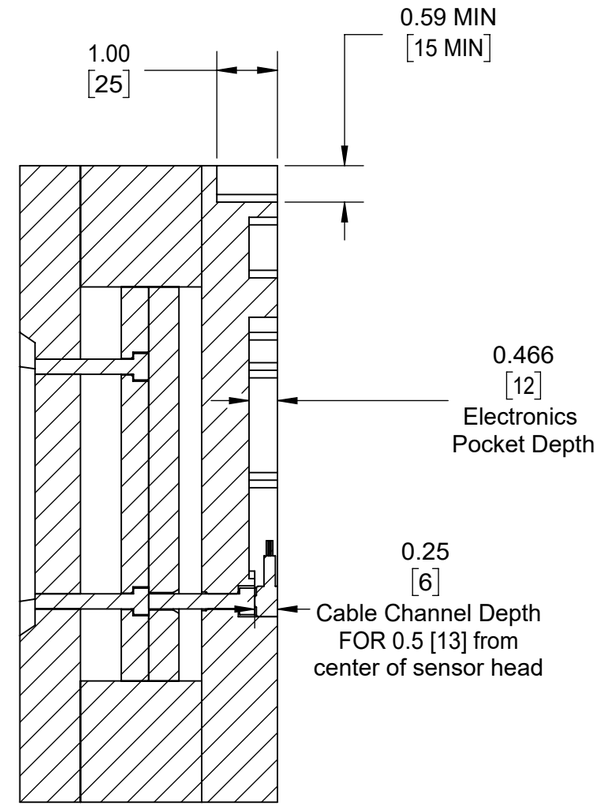
Description: LES-B-127-XXXX Sensor Installation	
Drawn:K.J.Brettschneider	
Design:	
Check: M.Groleau	
Date: 07.21.2022	

Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXXX) Installation—Clamp Plate Installations





SECTION M-M
SCALE 1 : 2.5

NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30°

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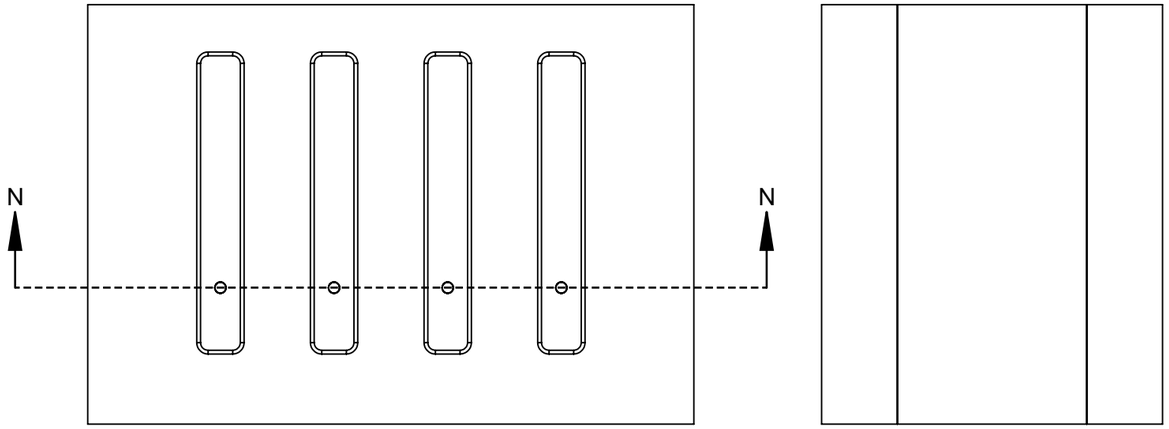
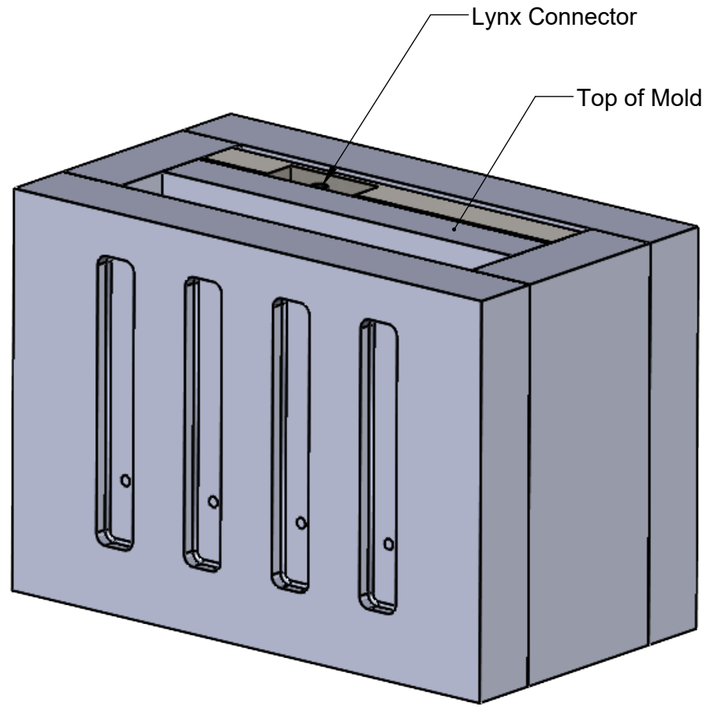
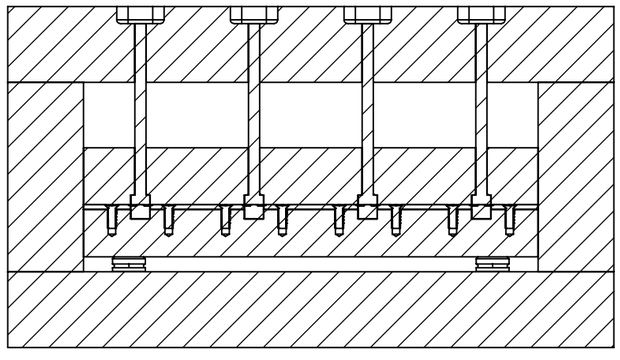
Description: LES-B-127-XXXX Sensor Installation
Drawn:K.J.Brettschneider
Design:
Check: M.Groleau
Date: 07.21.2022

Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXXX) Installation—Ejector Plate Installation







SECTION N-N

NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30°

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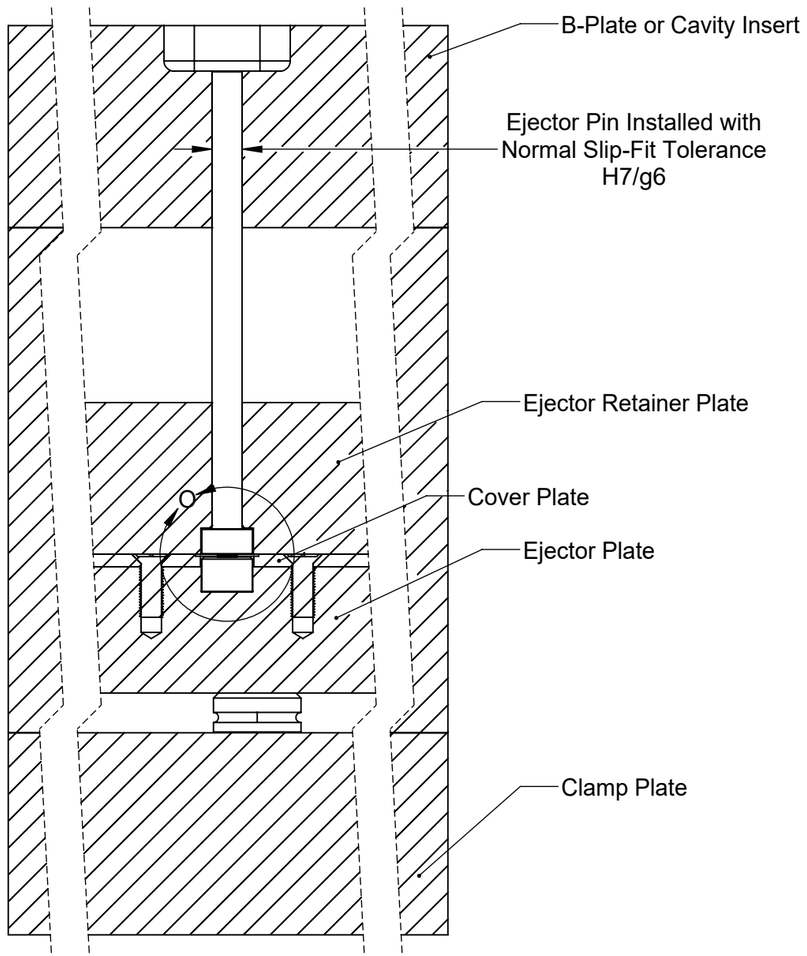
Description: LES-B-127-XXXX Sensor Installation	
Drawn:K.J.Brettschneider	
Design:	
Check: M.Groleau	
Date: 07.21.2022	

Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXX) Installation—Ejector Plate Installation



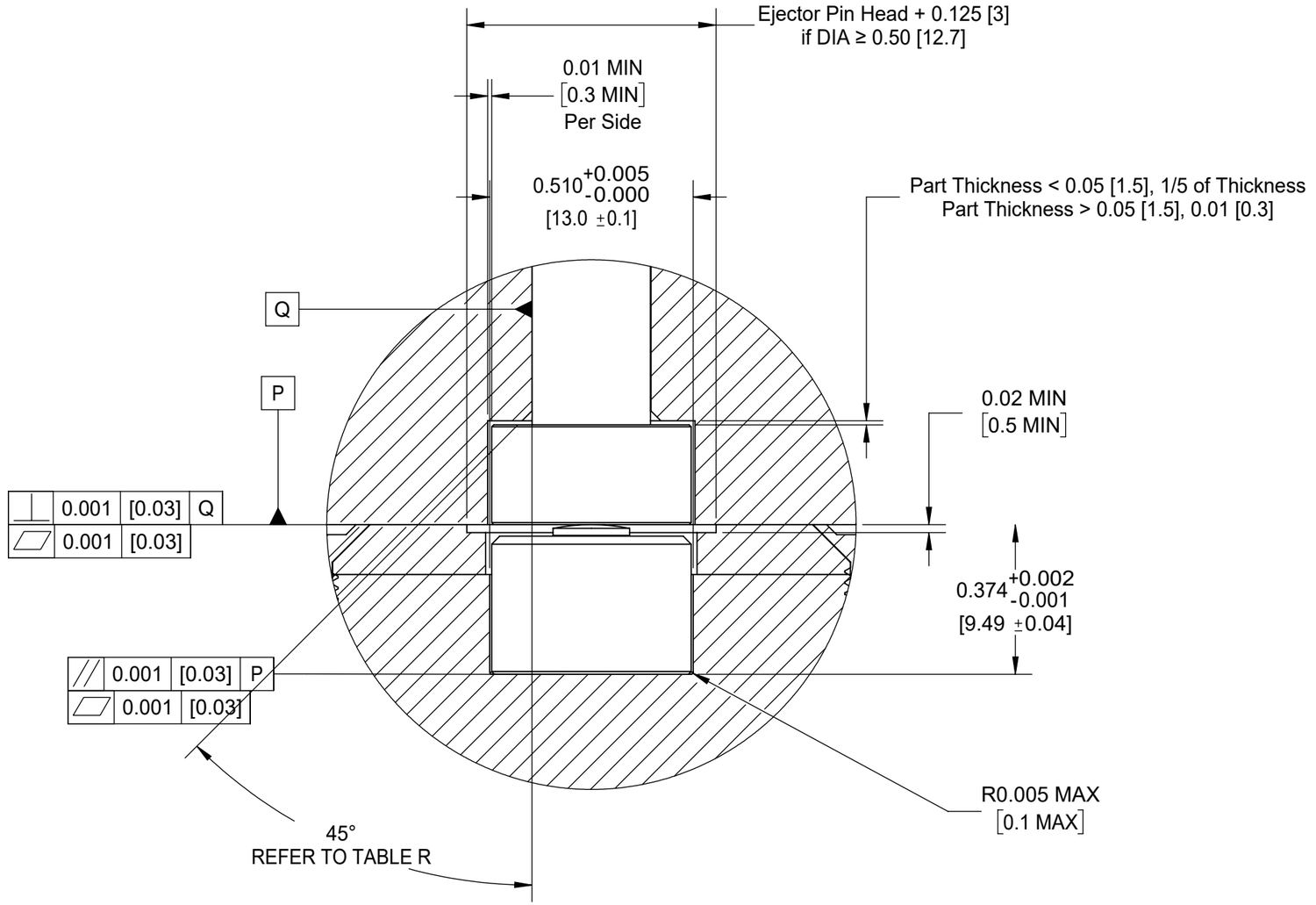


TABLE R	
	Chamfer Length
0.04–0.08 [1.0–2.0]	0.01 [0.3]
0.10–0.20 [2.5–5.0]	0.02 [0.4]
0.24–0.40 [6.0–10.0]	0.025 [0.6]

DETAIL O
SCALE 3 : 1

NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
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3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30°

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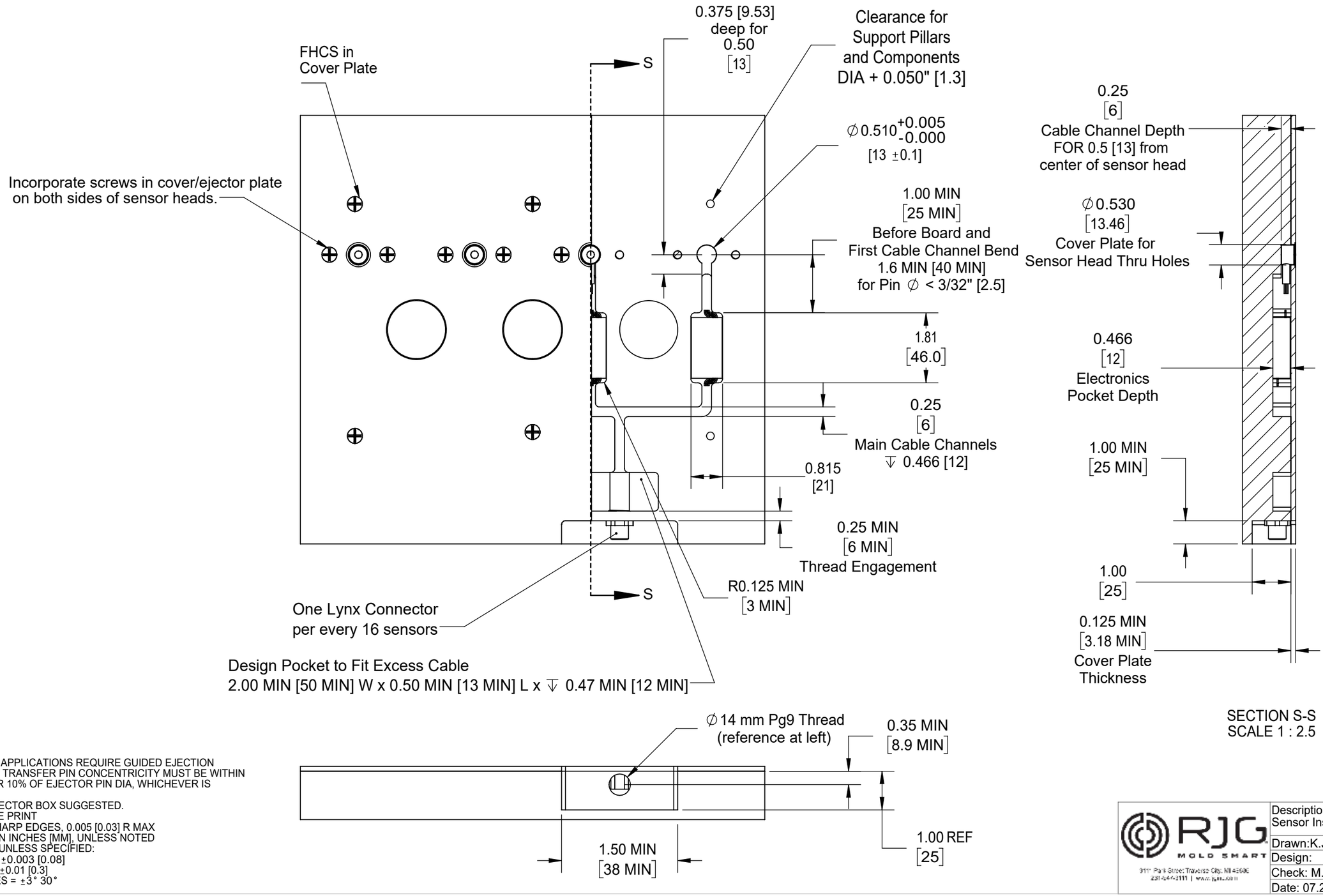
Description: LES-B-127-XXXX Sensor Installation	
Drawn:K.J.Brettschneider	
Design:	
Check: M.Groleau	
Date: 07.21.2022	

Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXX) Installation—Ejector Plate Installation



SECTION S-S
SCALE 1 : 2.5

NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
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6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30°

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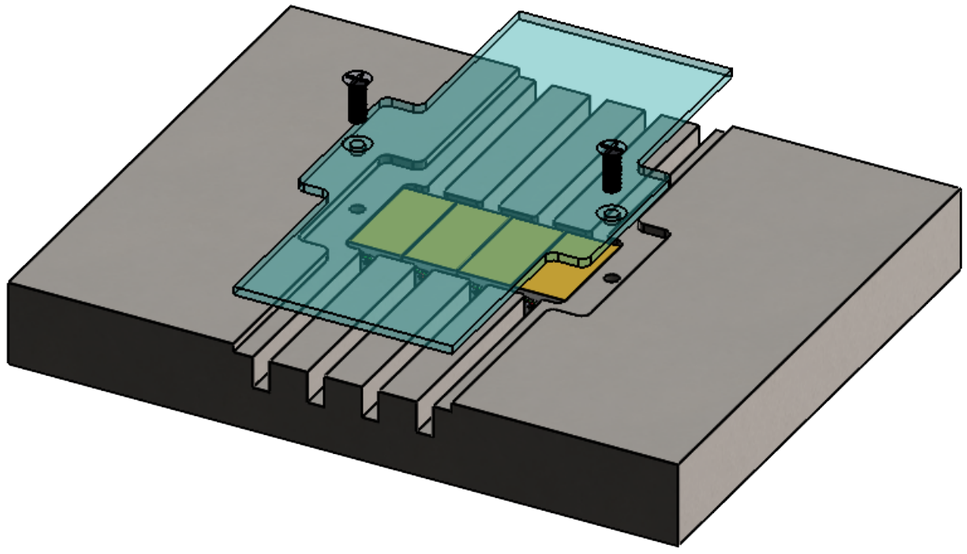
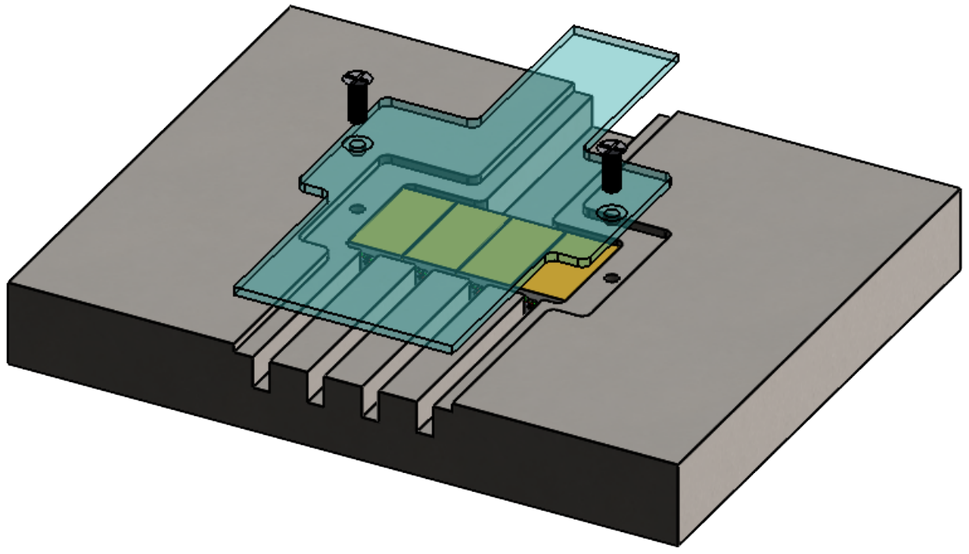
Description: LES-B-127-XXXX Sensor Installation
Drawn:K.J.Brettschneider
Design:
Check: M.Groleau
Date: 07.21.2022

Drawing Title: LES-B-127-XXXX-11

Lynx™ Embedded Sensors (LES-B-127-XXX) Installation—Sensor Electronics Alternate Installation

Sensor electronics can be grouped and installed in a single pocket within the mold, as shown below.
Refer to pages LES-B-127-XXXX-06 and LES-B-127-XXXX-09 for all sensor electronic pocket dimensions.





NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30'

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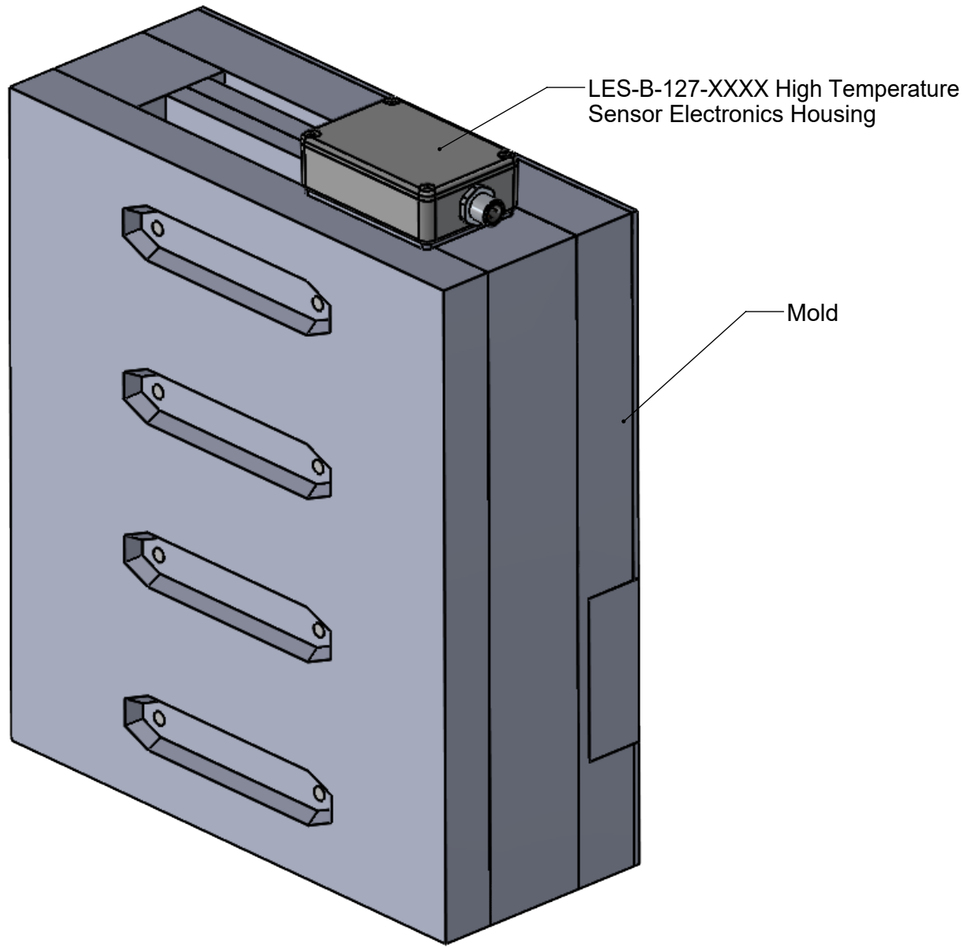
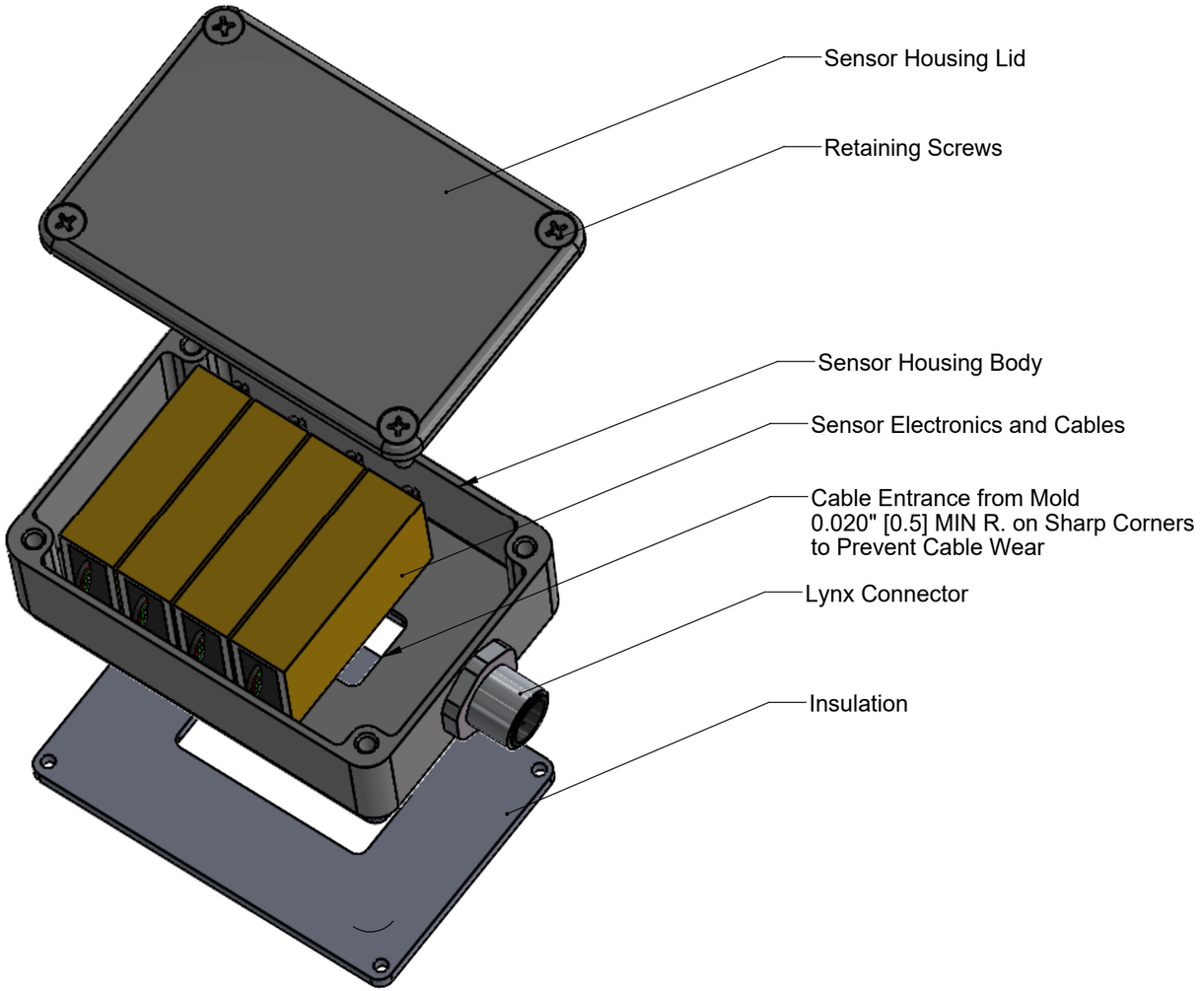
Description: LES-B-127-XXXX Sensor Installation
Drawn:K.J.Brettschneider
Design:
Check: M.Groleau
Date: 07.21.2022

Drawing Title: LES-B-127-XXXX-11

LES-B-127-XXXX Sensor Installation—High Temperature Installation

NOTE: Sensor electronics MUST NOT be installed in molds which exceed 140 °F (60 °C).





NOTES:
1. CLAMP PLATE APPLICATIONS REQUIRE GUIDED EJECTION
2. EJECTOR AND TRANSFER PIN CONCENTRICITY MUST BE WITHIN 0.030" [0.76] OR 10% OF EJECTOR PIN DIA, WHICHEVER IS SMALLER.
3. ENCLOSED EJECTOR BOX SUGGESTED.
4. DO NOT SCALE PRINT
5. BREAK ALL SHARP EDGES, 0.005 [0.03] R MAX
6. DIMENSIONS IN INCHES [MM], UNLESS NOTED
7. TOLERANCES UNLESS SPECIFIED:
   XXX = ±0.003 [0.08]
   XX = ±0.01 [0.3]
   ANGLES = ±3° 30°

LES-B-127-XXXX High Temperature Sensor Electronics Housing Recommended Dimensions			
	Length	Width	Depth
4 Sensors	4.5 [115]	2.6 [65]	1.2 [30]
8 Sensors	4.5 [115]	2.6 [65]	2.2 [55]
Housing Supplied by Customer			

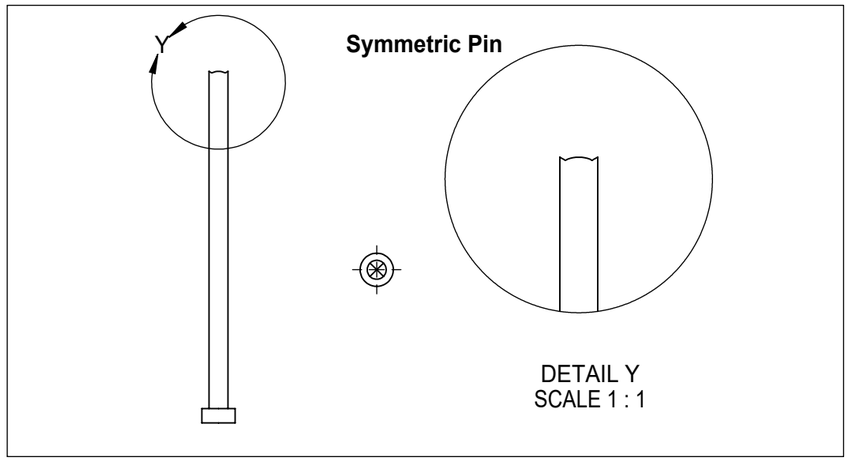
RJG MOLD SMART
3111 Park Street Traverse City, MI 49686
231-946-3111 | www.rjginc.com

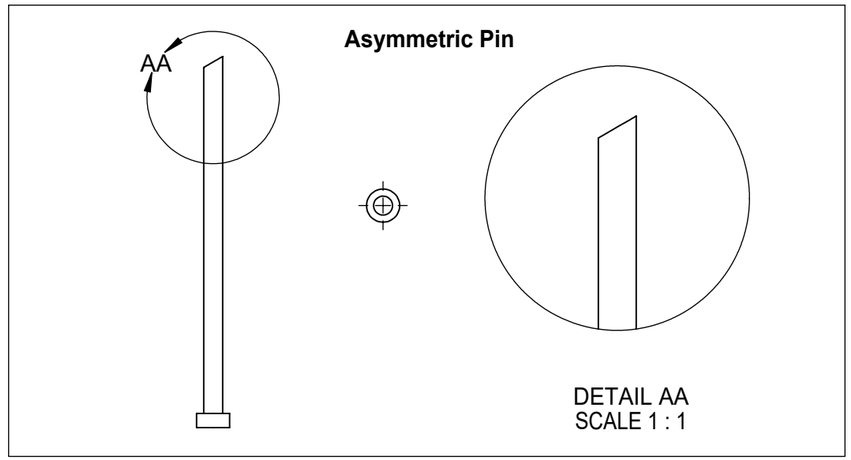
Description: LES-B-127-XXXX Sensor Installation	
Drawn:K.J.Brettschneider	
Design:	
Check: M.Groleau	
Date: 07.21.2022	

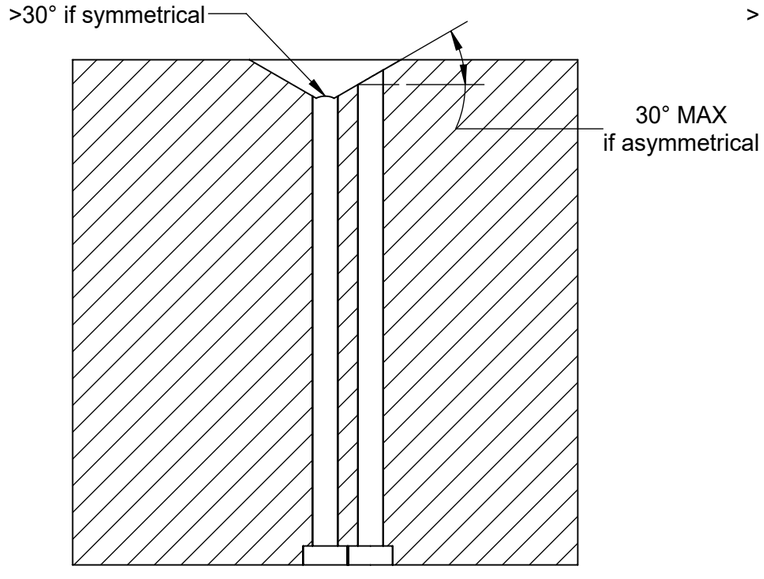
Drawing Title: LES-B-127-XXXX-11

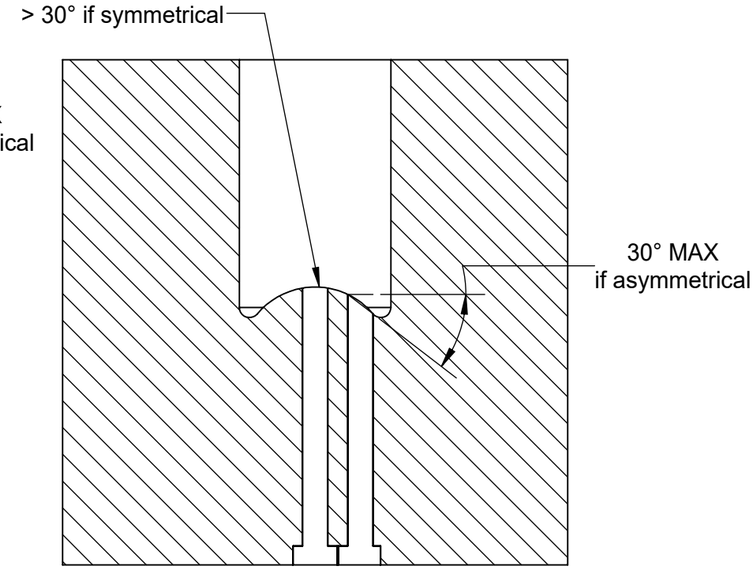
LES-B-127-XXXX Sensor Installation—Contoured Pin Angle Specification

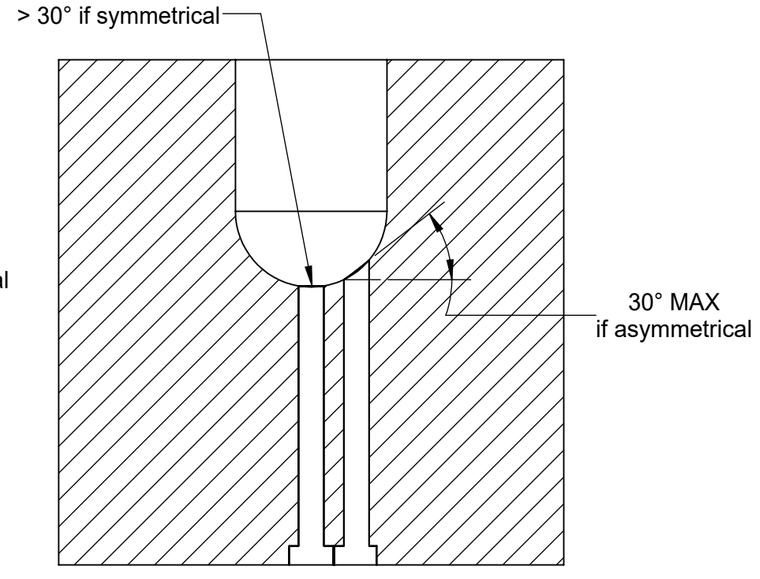
NOTE: Contoured/angled pins (asymmetric) not to exceed 30° MAX unless pin design is symmetrical to provide even, downward pressure across pin surface to loading of sensor. Contact RJG Customer Support for assistance in verification of contoured/angled pin use.











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Drawn:K.J.Brettschneider
Design:
Check: M.Groleau
Date: 07.21.2022