


Transmitter Mounting on Machine Surface

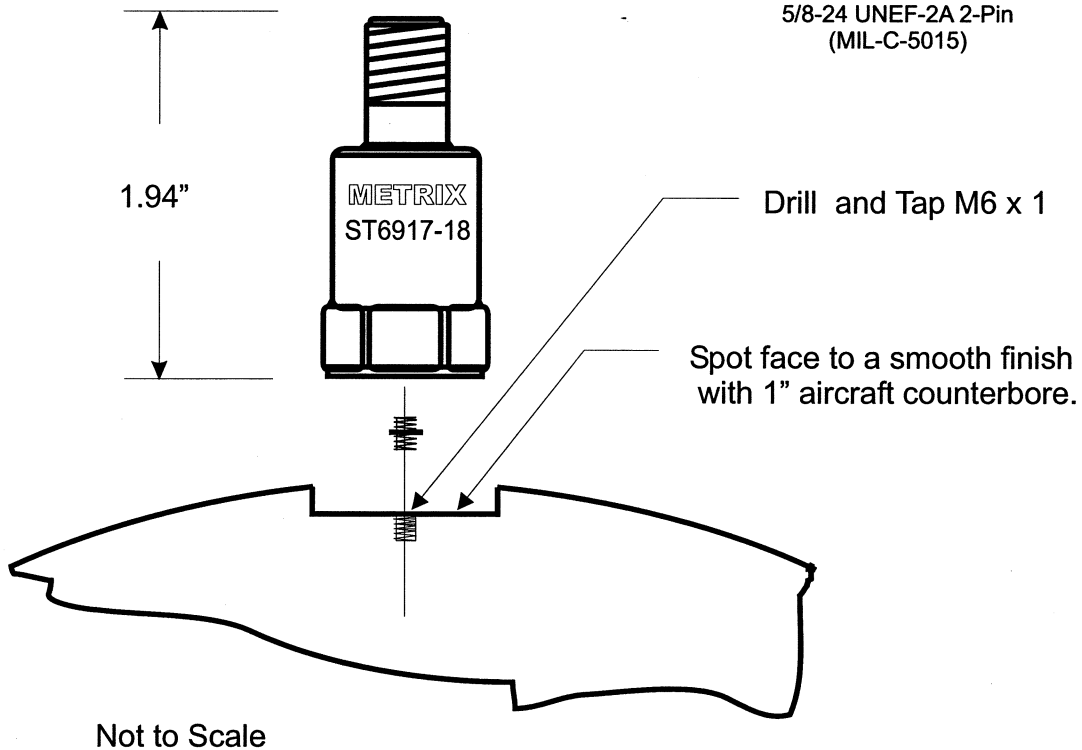
- 1) Verify mounting surface and tapped hole is free of Burrs and debris.
- 2) Verify mating surfaces are flat and perpendicular with the 1/4-28 threaded hole.
- 3) Coat mating areas and threads with thin film of oil.
- 4) Hand tighten the accelerometer and 1/4-28 stud to the machine taking care to see that nothing is trapped between the mating surfaces.
- 5) Torque accelerometer between 18 and 22 inch-pounds.

		ST 6911, ST6917, ST6923 Transmitter Instructions for 1/4-28 Threaded Mounting	
TITLE:			
DRAWN BY:	A. Wilson	DATE:	2-16-04
CHECKED BY:		DATE:	
APP NOTE:	116		REV: A
		REF:	REV
		SHEET:	1 of 1




Pin A, Signal & Power
Pin B, Common

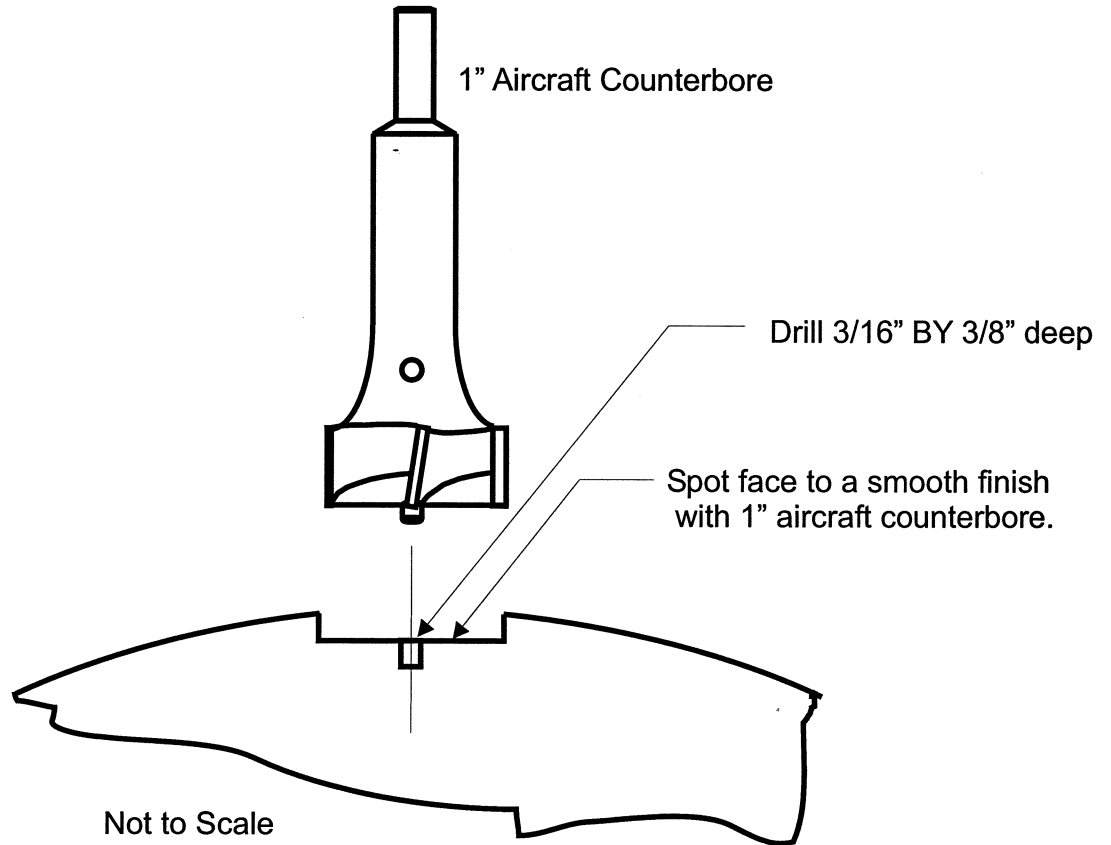
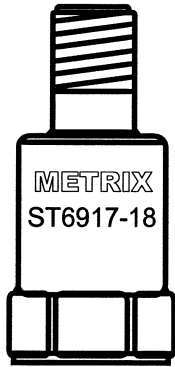
Elector Connector, Face View
5/8-24 UNEF-2A 2-Pin
(MIL-C-5015)



Accelerometer Mounting on Machine Surface

- 1) Verify mounting surface and tapped hole is free of burrs and debris.
- 2) Verify mating surfaces are flat and perpendicular with the M6 x 1 threaded hole.
- 3) Coat mating areas and threads with thin film of oil.
- 4) Hand tighten the accelerometer and M6 x 1 stud to the machine taking care to see that nothing is trapped between the mating surfaces.
- 5) Torque accelerometer between 18 and 22 inch-pounds.

		TITLE: ST6917-18 Vib. Transmitter Instructions for M6 x 1 Threaded Mounting	
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CHECKED BY:	DATE:	SHEET: 1 of 2	
DWG NO: 117		REV: A	




TOOL LIST FOR STUD MOUNTING THE ST6917-18 VIB. TRANSMITTER

- 1) Half inch variable speed Drill Motor.
- 2) 3/16" (#12) drill bit.
- 3) 13/64" (#7) drill bit.
- 4) 1" Aircraft Counterbore with 3/16" pilot.
- 5) 3/32" Allen Wrench.
- 6) Cutting fluid, Tap Magic or equal.
- 7) Torque wrench calibrated in inch pounds.
- 8) M6 x 1 taper and bottom tap.
- 9) 7/8" crow foot attachment.
- 10) Tap handle.
- 11) Small ball peen hammer.
- 12) Center punch.
- 13) Light Oil.

INSTALLATION PROCEDURE

- 1) Center punch hole location.
- 2) Drill 3/16" diameter by 1/2" deep hole on punch mark.
- 3) Remove metal shavings.
- 4) Using the 3/16" hole as a guide, spot face to the depth required for a flat mounting surface.
- 5) Drill out the center hole using the 13/64" (#7) drill bit
- 6) Tap hole with M6 x 1 tapered tap.
- 7) Remove tap and metal shavings.
- 8) Continue tapping M6 x 1 bottom tap.
- 9) Remove tap and deburr.
- 10) Remove metal shavings.
- 11) Apply a light oil to accelerometer stud and mating surface.
- 12) Install accelerometer, torque between 18 and 22 in/lbs.

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