Mounting Instructions

This technical note describes basic installation techniques for accelerometers and other vibration sensors. It will allow qualified field technicians to install vibration sensors in a variety of applications and environments. Some techniques will be general to all installations, whereas others may be specific to a particular application. If additional information is required, please consult the sensor manufacturer.

The process of installation begins with verifying that the proper sensor was selected for the measurement point. Refer to the Wilcoxon Research “Sensor Selection Guide” for assistance.

The vibration analyst must evaluate and determine the mounting location of the individual sensor based on the specific machine and vibration source to be monitored. With a firm understanding of the sensor’s, capabilities and limitations the installation can be quickly accomplished. After installation, verification of sensor operation must be made to complete the process.

Mounting the sensor

When using piezoelectric sensors to measure vibration, the sensor must directly contact the machine surface. The sensor should be mounted in a location that minimizes the vibration transmission route through the machine. Avoid mounting the sensor on thin sections or vibration free areas (antinodes).

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Mounting configurations

There are multiple mounting configurations that are used to couple the sensors to the machine surface. Figure 1 illustrates the various types of mounting configurations.

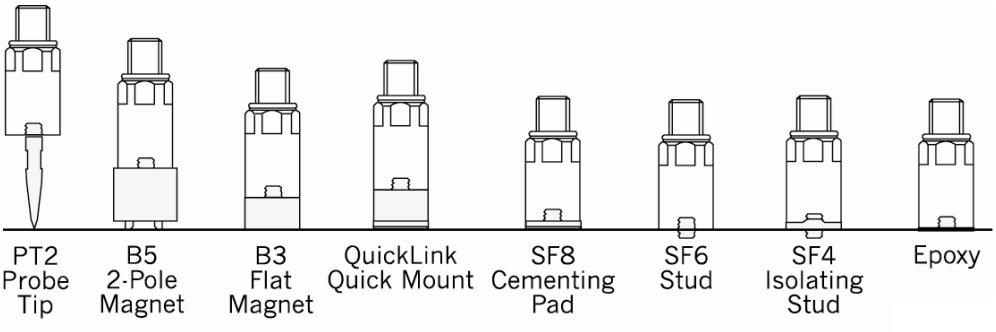


Figure 1: Mounting configurations

Direct stud mounting, epoxy and cementing pads are used for permanent installations. The sensor can be directly mounted by tapping a hole into the structure and attaching the sensor with a threaded stud. Cementing pads can be epoxied in place of the tapped hole; the sensor is then mounted to the pad. In some cases, the sensor can be mounted directly to the machine using epoxy. Attaching magnetic bases or probe tips (stingers) allows the sensor to be easily moved from point to point. Quick mounts combine the capabilities of a stud with the speed of a magnet. The most significant disadvantage of the magnet base or probe tip is the lower resonant frequency of the coupled system. The more intimate the contact between sensor and the machine, the better the ability to couple and measure high frequency signals.

Permanent mounting: Threaded stud, cementing pad

Cementing pads approach the capabilities of stud mounts when used properly. The following are recommended permanent mounting procedures. Alternative procedures should be evaluated with respect to frequency response, grounding, and installation requirements. Adhesive selection is critical for long-term reliability; please consult Wilcoxon before other procedures and materials are used.

Threaded stud

Stud mounting requires a tapped hole drilled directly into the structure. A threaded stud provides electrical and mechanical connection between the sensor

and machine. The sensor requires a flat spot faced surface with a perpendicular tapped hole. The spot face must be 1.1 times larger than the diameter of the sensor housing to ensure flush mounting. For measurements above 1,000Hz (60,000 cpm), the surface should be flat within 1 mil and have a surface texture no greater than 32 microinches. In all cases burrs between the sensor and the machine must be eliminated. The center line of the tapped hole must be perpendicular within 1° of the mounting surface to ensure no gaps are present between the base of the sensor and the structure. The tapped hole and spot face can be machined in one stop with proper tooling.

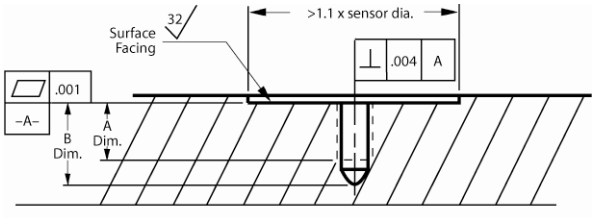
From the material list below, modify the shank of the tap drill to fit into the counterbore. Mount the tap drill into the counterbore with a minimum of .35 inches drill extension past the counterbore. If the extension (and #3 hole) is greater than .45 inches deep, the bottom tap can be eliminated.

Materials/Equipment for 1/4-28 Studs

- Counterbore larger than accelerometer base diameter, typically 1.1 x accelerometer hex size
- # 3 (.213) tap drill (modified shank)
- 1/4-28 starter tap
- 1/4-28 bottom tap
- Tap stand
- Silicone grease
- Cutting fluid
- 15/16 (24mm) torque wrench
- Screw driver

Procedure (see figure 2):

1. Machine the spot face and drill to a minimum depth of .350 inches. Use cutting fluid.
2. Using the tap stand, cut .250 inches of full thread (7 thread minimum). Use a bottom tap on holes less than .450 inches deep. Use cutting fluid.
3. Clean the hole and mounting surface free of metal shavings and debris.
4. Apply a service removable threadlock such as Loctite 242 glue to the tapped holes in both the structure and the sensor.
5. Screw the Wilcoxon model SF6 stud into the machine and seat with a screw driver.
6. Apply oil to the spot face taking care to avoid the stud.
7. Torque the sensor to its appropriate value as shown in figure 2.



Stud	Stud Size	A in. (min)	B in. (min)	Torque (in-lbs)
SF1	10-32 UNF	.188	.250	20
SF6	1/4-28 UNF	.250	.350	26
1/4 - 28 captive screw		.250	.350	30

NOTE: The above chart is based on the Wilcoxon Research standard stud length.

Figure 2: Stud mounting and

Cementing pad

Cementing pads eliminate tapping into the structure, but provide high frequency capability approaching stud mounts. The sensor should be used with a Wilcoxon Model SF8 cementing pad. The flat side is bonded to the machine with an appropriate adhesive. The opposite side contains a 1/4-28 stud for mounting the sensor. The procedure below leaves the pad and the sensor housing electrically isolated from ground.

Materials for cementing pad:

- End mill
- Versilok 406 adhesive
- Silicone grease
- Ohmmeter
- 15/16 (24mm) torque wrench

Procedure (see Figure 3):

1. Bore a spot face 1.1 times larger than the diameter of the cementing pad to be installed on the machine housing. Allow the machine tool to groove and abrade the surface to prepare for the adhesive bonding. Do not use cutting fluids as they may contaminate the bonding area.
2. Mix the bi-pack thoroughly by removing the clip and working the epoxy and catalyst into each other.
3. Apply a generous amount to the spot face and seat the model SF8 pad with a turning motion.
4. File the adhesive around the sides of the pad to increase shear strength and assist electrical isolation. The working time is 5 minutes but may vary depending on the ambient temperature.
   Do not get epoxy on the sensor mounting surface.
5. Test electrical isolation from the pad to the machine with the ohmmeter.
6. Apply a service removable threadlock such as Loctite 242 glue to the tapped hole in the sensor.
7. Torque the sensor to 24 inch-pounds.

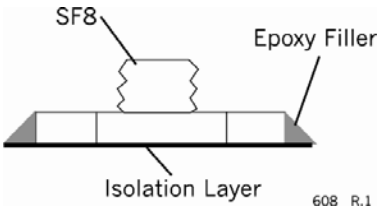


Figure 3: Cement pad mounting

Isolation pads

Isolation pads require a tapped hole drilled directly into the structure. A threaded stud provides secure mechanical connection between the isolation pad and machine. The isolation pad requires a flat spot faced surface with a perpendicular tapped hole. The spot face must be 1.1 times larger than the diameter of the isolation pad to ensure sufficient room for the pad to rotate while tightening, resulting in a flush mounted installation. The center line of the tapped hole must be perpendicular within 1° of the mounting surface to ensure no gaps are present between the base of the isolation pads and the structure. The tapped hole and spot face can be machined in one stop with proper tooling.

From the material list below, modify the shank of the tap drill to fit into the counterbore. Mount the tap drill into the counterbore with a minimum of .35 inches drill extension past the counterbore. If the extension (and #3 hole) is greater than .45 inches deep, the bottom tap can be eliminated.

Materials/Equipment for 1/4-28 Studs

- Counterbore larger than accelerometer base diameter, typically 1.1 x the hex size
- # 3 (.213) tap drill (modified shank)
- 1/4-28 starter tap
- 1/4-28 bottom tap
- Ohmmeter
- Tap stand
- Silicone grease
- Cutting fluid
- Appropriate torque wrench

Procedure (see figure 2):

1. Machine the spot face and drill to a minimum depth of .350 inches. Use cutting fluid.
2. Using the tap stand, cut .250 inches of full thread (7 thread minimum). Use a bottom tap on holes less than .450 inches deep. Use cutting fluid.
3. Clean the hole and mounting surface free of metal shavings and debris.
4. Apply a service removable threadlock such as Loctite 242 glue to the tapped holes in both the structure and the isolation pad.
5. Screw the selected isolation pad into the machine and seat with the appropriate wrench.
6. Apply oil to the bottom of the sensor to help fill material voids when seated.
7. Torque the sensor to the isolation pad with its appropriate value as shown in figure 2.
8. Verify isolation between the sensor and the structure with the ohmmeter after installation. The sensor should not be wired for this test. Ohm reading should be greater than 1 meg ohm.

For more information

Wilcoxon Research, Inc. offers a wide variety of vibration instrumentation with an extensive list of available options. A multitude of application requirements can be met with our standard products. Our application engineers can provide you with proper sensor selection, technical support for installations, tips and techniques, and troubleshooting. Call our customer service team directly for more information at 1-800-WILCOXON.

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