Temperature Sensors
for Injection Molding

Temperature sensors for measuring the contact temperature directly in the cavity at the surface of the solidified plastic melt.

- Integral steel braiding glass silk insulated high-temperature cable with Fischer connector
- Versions without connector for connection to temperature amplifier Type 2205A...
- Mounting compatibility with standard mold cavity pressure sensors Types 6157B..., 6159A..., 6182B..., 6183B...

Description
Temperature sensor Types 6192B..., 6193B..., 6194B... and 6195B... are compatible for mounting purposes with the standard mold cavity pressure sensors with 4 mm, 2,5 mm and 1 mm front diameters. The rugged high-temperature cable is integrated in the sensor and can be used in temperatures up to 450 °C. The measuring principle is based on Type K thermocouples. Two thermocouple leads are fed separately to the front of the sensor, where they are welded to a thermocouple. On the sensor Type 6192BF... and 6193BF... the sensor front can be machined to a depth of 0,5 mm. On all other sensor types and variants the front must not be machined in any way.

The Type K thermocouple is used because of its technical advantages such as corrosion resistance.

Application
The sensors measure the contact temperature at the surface of the solidified surface layer of the plastic melt in the cavity. This temperature can be used for monitoring and control purposes, for example for adjusting the mold temperature during the process. In addition, this temperature can be used to calculate the melt temperature in the molded part. The contact temperature also provides information on the surface of a plastic part and can be used to optimize the strength at the weldline. The sensor can not be machined at the front.

For multicavity molds, Types 6192BG..., 6193BG..., 6194BG... and 6195BG... (sensor cable without connector) can be directly connected to the temperature amplifier Type 2205A.... For this purpose, the temperature amplifier is built into the mold and supplies voltage signals of 0 to 10 V to appropriate evaluation units. Further details must be obtained from the data sheet 2205A... (2205A_000-591).

Technical Data

<table>
<thead>
<tr>
<th>Thermocouple</th>
<th>Type</th>
<th>K (NiCr-Ni)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Measuring accuracy</td>
<td>Norm</td>
<td>IEC548 K1</td>
</tr>
<tr>
<td>Operating temperature range</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Mold (sensor and cable) °C</td>
<td>0 ... 450</td>
<td></td>
</tr>
<tr>
<td>Mold (connector) °C</td>
<td>0 ... 200</td>
<td></td>
</tr>
<tr>
<td>Melt (at the front of the sensor) °C</td>
<td>≤450</td>
<td></td>
</tr>
<tr>
<td>Pressure range bar</td>
<td>0 ... 2 000</td>
<td></td>
</tr>
<tr>
<td>Cable</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Positive</td>
<td>+</td>
<td>green</td>
</tr>
<tr>
<td>Negative</td>
<td>–</td>
<td>white</td>
</tr>
</tbody>
</table>

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Temperature Sensors for Injection Molding, Type 6192B..., 6193B..., 6194B... and 6195B...

Cable and Amplifier for Measuring Chain with Temperature Sensors Type 6192B ..., 6193B..., 6194B... and 6195B...

Fig. 1: Temperature sensor with charge and temperature amplifier Type 5159A

Compensation Cable Type 2295A...
Type 5159A3
(2 channels pressure, 2 channel temperature)

Extension Cable Type 1491A...
on Temperature Amplifier Type 2205A... (in Mold)
Type 5887A...

Fig. 2: Temperature sensor with temperature amplifier Type 2205A... in mold and connection to ComoNeo Type 5887A

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Fig. 3: Temperature sensor with temperature amplifier Type 2205A... in mold and connection to CoMo Injection Type 2869B

Dimensions

Fig. 4: Type 6193B... (ø1 mm)

Fig. 5: Type 6195B... (ø2,5 mm, shoulder 4 mm)

Fig. 6: Type 6194B... (ø2,5 mm, shoulder 7 mm)

Fig. 7: Type 6192B... (ø4 mm)
Fig. 8: Mounting Type 6193B... with spacer sleeve Type 6464A3

Fig. 9: Mounting Type 6195B... with spacer sleeve Type 6464A3

Fig. 10: Mounting Type 6194B... with mounting nut Type 6457

Fig. 11: Mounting Type 6194B... with spacer sleeve Type 6459
Mounting

The sensor Types 6192B... and 6194B... are fixed in the mounting bore with the mounting nut Type 6457 (or with the spacer sleeve Type 6459). Types 6193B... and 6195B... are exclusively mounted with spacer sleeve Type 6464A3.

After mounting, the sensor front forms part of the cavity wall. The sensor must therefore be fitted so that its front comes exactly flush. Fix the connector to a protected part of the mold with the mounting plate (Art. No. 3.520.328) supplied. Secure the protective cap with a mounting plate screw and cover the open connector.
Temperature Sensors for Injection Molding, Type 6192B..., 6193B..., 6194B... and 6195B...

Accessories Included
- Mounting nut for Types 6192B... and 6194B...
- Spacer sleeve for Type 6193B..., 6195B...
- Mounting plate

Optional Accessories
- Compensating cable one end without connector
  - L = 2 m
  - L = 5 m
  - Custom length (L_{min} = 0,1 / L_{max} = 30 m)
- Compensating cable with connectors both ends
  - L = 2 m
  - L = 5 m
  - Custom length (L_{min} = 0,1 / L_{max} = 30 m)
- Temperauter amplifier (2 channel) with measuring range up to 200 °C
- Temperauter amplifier (4 channel) with measuring range up to 200 °C
- Temperauter amplifier (2 channel) with measuring range up to 400 °C
- Temperauter amplifier (4 channel) with measuring range up to 400 °C

Ordering Key

<table>
<thead>
<tr>
<th>Type 619□ □ □</th>
<th>Type /Art.No.</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 mm front diameter temperature sensor</td>
<td>3</td>
</tr>
<tr>
<td>2 mm front diameter temperature sensor (shoulder ø7 mm)</td>
<td>4</td>
</tr>
<tr>
<td>2,5 mm front diameter temperature sensor (shoulder ø4 mm)</td>
<td>5</td>
</tr>
<tr>
<td>4 mm front diameter temperature sensor</td>
<td>2</td>
</tr>
<tr>
<td>0.4 m cable length</td>
<td>0.4</td>
</tr>
<tr>
<td>Cable with special length, specify cable length L in m (L_{min} = 0.1 m / L_{max} = 5 m) not available for 6193BF</td>
<td>sp</td>
</tr>
<tr>
<td>Sensor without connector with cable length L = 2 m</td>
<td>G</td>
</tr>
<tr>
<td>Sensor without connector with cable length L = 5 m</td>
<td>G1</td>
</tr>
</tbody>
</table>

Optional Accessories

- Extraction tool for Type 6193B... and 6195B...
- Mounting nut for Types 6193B... and 6195B...
- Tubular socket wrench for Types 6193B... and 6195B... and mounting nut 6458
- Extraction tool for Types 6192B... and 6194B...
- Tubular socket wrench or Types 6192B... and 6194B...
- Spacer sleeve for Types 6192B... and 6194B...

Optional Accessories ComoNeo

- 4-channel extension cable for Type 2205A...

Optional Accessories CoMo Injection

- 4-channel extension cable for Type 2205A...

 Dummy sensor
- Type 6192B...
- Type 6193B...
- Type 6194B...
- Type 6195B...