



**Model 080A127**

**Spotface tool, 1.0" diameter spot with drill bit for a 1/4-28 tap (tap not included)**

**Installation and Operating Manual**

**For assistance with the operation of this product,  
contact the PCB Piezotronics, Inc.**

**Toll-free: 800-959-4464**

**24-hour SensorLine: 716-684-0001**

**Fax: 716-684-3823**

**E-mail: [imi@pcb.com](mailto:imi@pcb.com)**

**Web: [www.imi-sensors.com](http://www.imi-sensors.com)**





*INDUSTRIAL MONITORING INSTRUMENTATION DIVISION*

## ***Spot Face Tool User Instructions***

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### ***Operating Guide with Enclosed Warranty Information***

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***MANUAL NUMBER: 18671***  
***MANUAL REVISION: A***

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## ***introduction***

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Spot face tools are used to create a flat circular surface to mount an accelerometer. Each model has an installed center drill that is the correct tap drill for tapping a ¼-28 UNF-2B thread.

## ***installation***

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Obtain a hand drill motor and install the shank end of the spot face tool into the chuck of the drill motor. Tighten the chuck and check the direction of rotation. The rotation should be counter clockwise when looking at the chuck end of the drill motor.

## ***operation***

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Choose the area on the surface where the accelerometer is to be installed. Using a center punch, mark the spot of the center of the accelerometer. Apply a small amount of light oil to the surface to be used as a cutting fluid.

Apply the point of the center drill on the spot face tool to the center punch mark, grip the drill motor firmly and begin drilling.

The drill motor should be kept as perpendicular to the axis that is going to be measured as possible. Often on castings and molded parts the axis is not necessarily perpendicular to the surface being prepared. A cross-check or torpedo level is very helpful in determining perpendicularity.

The revolution speed of the drill motor should be kept between 150 and 350 RPM to optimize the life of the tool. Allow the tool to do the cutting. Do not apply excessive pressure while drilling, this will accelerate tool wear. The addition of a lubricant or cutting fluid during the cutting process will also greatly increase tool life.

***operation continued . . .***

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The depth of the cut is determined by the perpendicularity of the surface to the axis being measured. Remove enough material so that the entire bottom surface of the accelerometer is in contact with the spot face. The maximum depth of cut should not exceed .040”.

The position of the center drill in the spot face tool can also be adjusted for different drill depths to accommodate for the wall thickness and the material of the unit to be monitored.

***tool maintenance***

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After extended use the spot face tools may wear and become dull. The tool can be sharpened using standard sharpening techniques. Refer to your local machine shop for sharpening.





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### **return procedure**

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To expedite returned instrumentation, contact a factory IMI applications engineer for a **RETURN MATERIAL AUTHORIZATION (RMA) NUMBER**. Please have information available such as model and serial number. Also, to insure efficient service, provide a written description of the symptoms and problems with the equipment to a local sales representative or distributor, or contact IMI if none are located in your area.

Customers outside the U.S. should consult their local IMI distributor for information on returning equipment. For exceptions, please contact the International Sales department at IMI to request shipping instructions and an RMA. For assistance, please call (716) 684-0003, or fax us at (716) 684-3823. You may also receive assistance via e-mail at [imi@pcb.com](mailto:imi@pcb.com) or visit our web site at [www.pcb.com](http://www.pcb.com).

### **customer service**

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IMI, a division of PCB Piezotronics, guarantees **Total Customer Satisfaction**. If, at any time, for any reason, you are not completely satisfied with any IMI product, IMI will repair, replace, or exchange it at no charge. You may also choose, within the warranty period, to have your purchase price refunded.

IMI offers to all customers, at no charge, 24-hour phone support. This service makes product or application support available to our customers, day or night, seven days a week. When unforeseen problems or emergency situations arise, call the **IMI Hot Line at (716) 684-0003**, and an application specialist will assist you.



# **IMI SENSORS**

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