Inductive Barrel Sensors

Mounting

Turck inductive proximity sensors are manufactured with a shielded coil, designated by "Bi" in the part number, and a nonshielded coil, designated by "Ni" in the part number. Embeddable (shielded) units may be safely flush-mounted in metal. Nonembeddable (nonshielded) units require a metal free area around the sensing face. Because of possible interference of the electromagnetic fields generated by the oscillators, minimum spacing is required between adjacent or opposing sensors.

It is good engineering practice to mount sensors horizontally or with the sensing face looking down. Avoid sensors that look up wherever considered, especially if metal filings and chips are present.

Maximum Locknut Torque Specifications

The locknut torque should be considered for all threaded sensors to prevent the housing from being over stressed. The values below pertain to the locknut provided with each sensor. Liquid thread sealants of an anaerobic base, such as Loctite, are recommended if strong vibrations are likely.

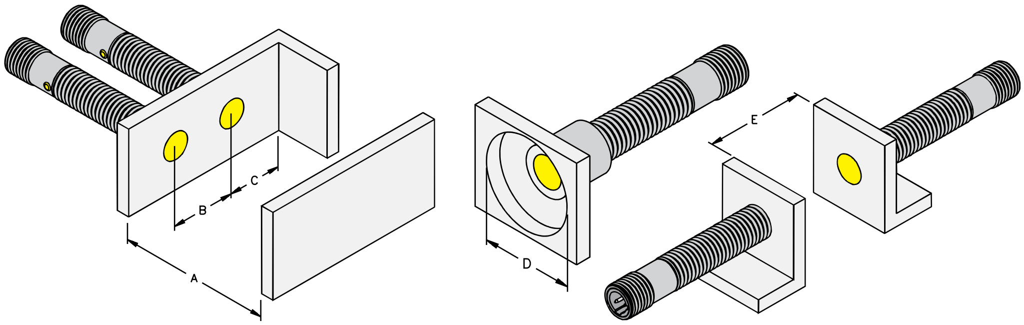
Caution: Sensor barrels are typically brass. Consider break torque when selecting grade of thread sealant.

Barrel Size	Metal Barrel	Plastic Barrel
5 mm	5 Nm (3.7 ft-lb)	- - - -
8 mm	5 Nm (3.7 ft-lb)	- - - -
8 mm (M08 Ferrite)	7 Nm (5.2 ft-lb)	- - - -
12 mm	10 Nm (7.4 ft-lb)	1 Nm (0.7 ft-lb)
18 mm	25 Nm (18 ft-lb)	2 Nm (1.4 ft-lb)
30 mm	75 Nm (55 ft-lb)	5 Nm (3.7 ft-lb)
47 mm	90 Nm (66 ft-lb)	- - - -

Drill Hole Sizes for Metric Threads

Thread Size	Pitch	Thru Hole (mm)	Tap Hole Dia. (mm)	Thru Hole (in)	Tap Hole Dia. (in)
M5 x 0.5	0.5	5.0	4.5	13/64	5/32
M8 x 1	1.0	8.0	7	21/64	1/4
M12 x 1	1.0	12.0	11	31/64	13/32
M18 x 1	1.0	18.0	17	23/32	41/64
M30 x 1.5	1.5	30.0	28	1-3/16	1-5/64
PG 9	1.41	15.2	14	5/8	1/2
PG 13.5	1.41	20.4	19	13/16	23/32
PG 36	1.59	47.0	45.5	1-7/8	1-47/64

Embeddable Mounting Considerations



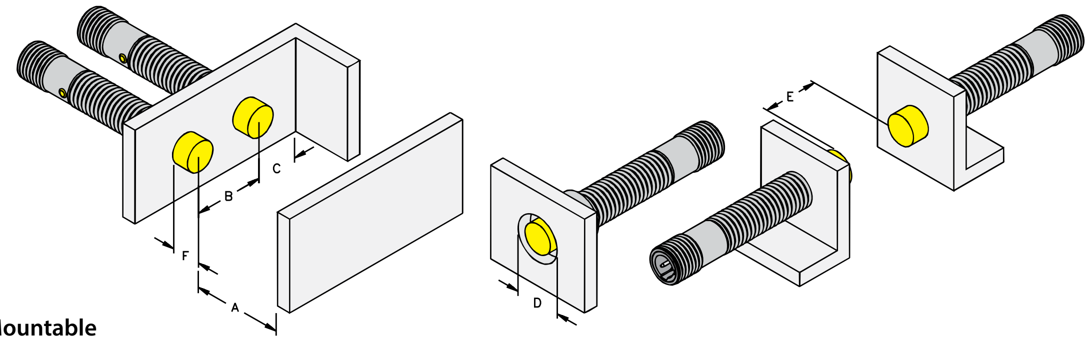
Flush Mountable

Sensor Type	Barrel Diameter	A	B	C	D	E
Bi1	3.00	3.00	6.00	4.50	9.00	9.00
Bi1U	4.00	3.00	8.00	6.00	12.00	6.00
Bi1	4.00	3.00	8.00	6.00	12.00	6.00
Bi1	5.00	3.00	10.00	8.00	15.00	6.00
Bi1U	5.00	3.00	10.00	7.50	15.00	6.00
Bi1.5U	6.50	5.00	13.00	10.00	20.00	9.00
Bi1.5	6.50	5.00	13.00	10.00	20.00	9.00
Bi2	6.50	6.00	13.00	10.00	20.00	12.00
Bi1.5U	8.00	5.00	16.00	12.00	24.00	9.00
Bi1.5	8.00	5.00	16.00	12.00	24.00	9.00
Bi2	8.00	6.00	16.00	12.00	24.00	12.00
Bi2U	8.00	6.00	16.00	12.00	24.00	12.00
Bi3U	8.00	9.00	16.00	12.00	24.00	18.00
Bi2	11.00	6.00	22.00	17.00	33.00	12.00
Bi2	12.00	6.00	24.00	18.00	36.00	12.00
Bi3U	12.00	9.00	24.00	18.00	36.00	18.00
Bi3	12.00	9.00	24.00	18.00	36.00	18.00
Bi4	12.00	12.00	24.00	18.00	36.00	24.00
Bi4U	12.00	12.00	24.00	18.00	36.00	24.00
Bi6U	12.00	18.00	24.00	18.00	36.00	36.00
Bi5U	18.00	15.00	36.00	27.00	54.00	30.00
Bi5	18.00	15.00	36.00	27.00	54.00	30.00
Bi7	18.00	21.00	36.00	27.00	54.00	42.00
Bi8U	18.00	24.00	36.00	27.00	54.00	48.00
Bi8	18.00	24.00	36.00	27.00	54.00	48.00
Bi10U	18.00	30.00	36.00	27.00	54.00	60.00
Bi10U	30.00	27.00	60.00	45.00	90.00	54.00
Bi10	30.00	30.00	60.00	45.00	90.00	60.00
Bi12	30.00	36.00	60.00	45.00	90.00	72.00
Bi15	30.00	45.00	60.00	45.00	90.00	90.00
Bi15U	30.00	45.00	60.00	45.00	90.00	90.00
Bi 20U	30.00	60.00	60.00	45.00	90.00	120.00
Bi 20	47.00	60.00	94.00	71.00	141.00	120.00
Bi 25	47.00	75.00	94.00	71.00	141.00	150.00

Dimensions are in mm.

Inductive Barrel Sensors

Nonembeddable Mounting Characteristics

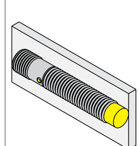
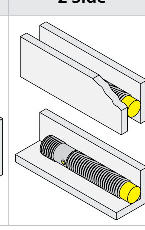
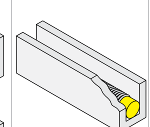


Non-Flush Mountable

Sensor Type	Barrel Diameter	A	B	C	D	E	F	1 Side	2 Side	3 Side
Ni3	6.50	9.00	20.00	10.00	20.00	18.00	6.00			
Ni3	8.00	9.00	24.00	12.00	24.00	18.00	6.00			
Ni4U	8.00	12.00	32.00	12.00	32.00	24.00	8.00			
Ni4	8.00	12.00	24.00	12.00	24.00	24.00	8.00			
Ni6U	8.00	18.00	32.00	12.00	36.00	36.00	12.00			
Ni5	11.00	15.00	33.00	17.00	33.00	30.00	10.00			
Ni4	12.00	12.00	36.00	18.00	36.00	24.00	8.00			
Ni5	12.00	15.00	36.00	18.00	36.00	30.00	10.00			
Ni8U	12.00	24.00	48.00	18.00	45.00	48.00	16.00	Sr=6 mm*		
Ni8	12.00	24.00	36.00	18.00	36.00	48.00	16.00			
Ni10U	12.00	30.00	48.00	18.00	36.00	60.00	20.00			
Ni8	18.00	24.00	54.00	27.00	54.00	48.00	16.00			
Ni10	18.00	30.00	54.00	27.00	54.00	60.00	20.00			
Ni12U	18.00	36.00	70.00	27.00	54.00	72.00	24.00			
Ni14	18.00	42.00	54.00	27.00	54.00	84.00	20.00			
Ni15U	18.00	45.00	70.00	27.00	54.00	90.00	30.00			
Ni10	20.00	30.00	60.00	30.00	60.00	60.00	20.00			
Ni15	30.00	45.00	90.00	45.00	90.00	90.00	20.00			
Ni20U	30.00	60.00	90.00	45.00	90.00	120.00	40.00	Sr=15 mm*	Sr=12 mm*	Sr=11 mm*
Ni20	30.00	60.00	90.00	45.00	90.00	120.00	20.00			
Ni30U	30.00	135.00	90.00	45.00	90.00	180.00	60.00			
Ni20	40.00	60.00	120.00	60.00	120.00	120.00	40.00			
Ni30	40.00	90.00	120.00	60.00	120.00	180.00	40.00			
Ni25	47.00	75.00	141.00	71.00	141.00	150.00	40.00			
Ni40	47.00	120.00	141.00	71.00	141.00	240.00	40.00			

Dimensions are in mm.

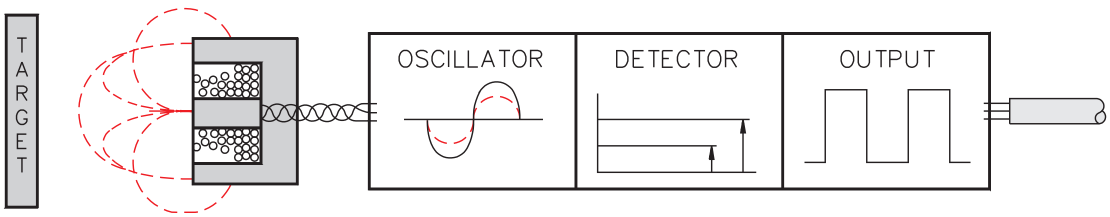
* The above Uprox Ni sensors with DC outputs and Stainless barrels can be flush mounted because the sensor automatically compensates for metal alongside its sensing face by decreasing the sensing range, preventing the output from locking on.

1 Side	2 Side	3 Side
		

Technical Reference | Inductive

Operating Principle Ferrite Core

Figure 1



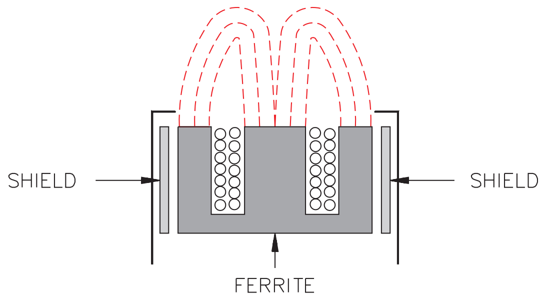
An inductive proximity sensor consists of a coil and ferrite core arrangement, an oscillator and detector circuit, and a solid-state output (**Figure 1**). The oscillator creates a high frequency field radiating from the coil in front of the sensor, centered around the axis of the coil. The ferrite core bundles and directs the electro-magnetic field to the front.

When a metal object enters the high-frequency field, eddy currents are induced on the surface of the target. This results in a loss of energy in the oscillator circuit and, consequently, a smaller amplitude of oscillation. The detector circuit recognizes a specific change in amplitude and generates a signal which will turn the solid-state output "ON" or "OFF". When the metal object leaves the sensing area, the oscillator regenerates, allowing the sensor to return to its normal state.

Mounting

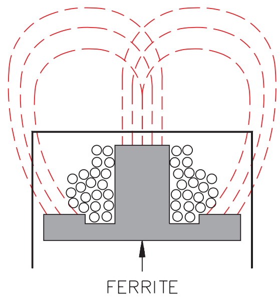
Turck inductive proximity sensors are available with either a shielded coil, designated by "Bi" in the part number, or a unshielded coil, designated by "Ni" in the part number. Embeddable (shielded) sensors may be safely flush-mounted in ferrous metal. Nonembeddable (unshielded) sensors require a metal free area around the sensing face. Due to the possible interference of the electromagnetic fields generated by the oscillators, minimum spacing is required between adjacent or opposing sensors. See mounting characteristics at the front of each section.

It is good engineering practice to mount sensors horizontally or with the sensing face looking down. Avoid mounting sensors with the sensing face looking up wherever possible, especially if metal filings or chips are present.



Embeddable (Shielded Sensor)

Embeddable construction includes a metal band that surrounds the ferrite core and coil arrangement. This helps to "bundle" or direct the electromagnetic field to the front of the sensor, allowing the sensor to be mounted fully surrounded by metal (flush mounting).



Nonembeddable (Nonshielded Sensor)

Nonembeddable sensors do not have this metal band; therefore, they have a longer operating distance and are side sensitive.

Operating Distance (Sensing Range) Considerations

The operating distance (S) of inductive proximity sensors is basically a function of the diameter of the sensing coil. The maximum operating distance is achieved with the use of a standard or larger target. The rated operating distance (Sn) for each model is given in the manual. When using a proximity sensor the target should be within the assured range (Sa).

Standard Target

A square piece of mild steel having a thickness of 1 mm (0.04 in) is used as a standard target to determine the following operating tolerances. The length and width of the square is equal to either the diameter of the circle inscribed on the active surface of the sensing face or three times the rated operating distance Sn, whichever is greater.

Operating Distance = S

The operating distance is the distance at which the target approaching the sensing face along the reference axis causes the output signal to change.

Rated Operating Distance = Sn

The rated operating distance is a conventional quantity used to designate the nominal operating distance. It does not take into account either manufacturing tolerances or variations due to external conditions such as voltage and temperature.

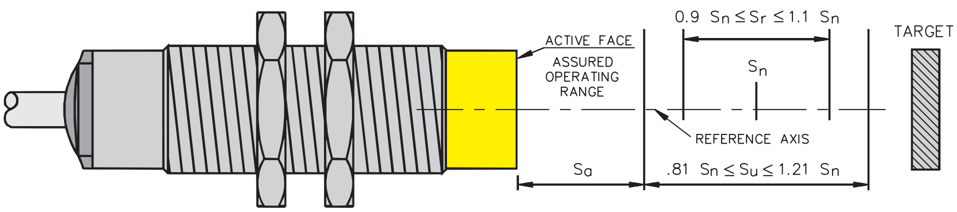
Effective Operating Distance = Sr 0.9 Sn ≤ Sr ≤ 1.1 Sn

The effective operating distance is the operating distance of an individual proximity sensor at constant rated voltage and 23°C (73°F). It allows for manufacturing tolerances.

Usable Operating Distance = Su 0.81 Sn ≤ Su ≤ 1.21 Sn

The usable operating distance is the operating distance of an individual proximity sensor measured over the operating temperature range at 85% to 110% of its rated voltage. It allows for external conditions and for manufacturing tolerances.

Assured Operating Range = Sa 0 ≤ Sa ≤ 0.81 Sn



The assured operating range is between 0 and 81% of the rated operating distance. It is the range within which the correct operation of the proximity sensor under specified voltage and temperature ranges is guaranteed.

Operating Distance (Sensing Range) Considerations

Turck standard inductive sensors use a single coil wound around a ferrite core. This coil induces eddy currents on the metal target, which results in energy loss in the oscillator circuit, enabling the detection of metal objects. The energy loss is greatly depended on the magnetic properties of the metal target. Ferrous and nonferrous metals affect the sensor differently, resulting in a different operating distance to different metals.

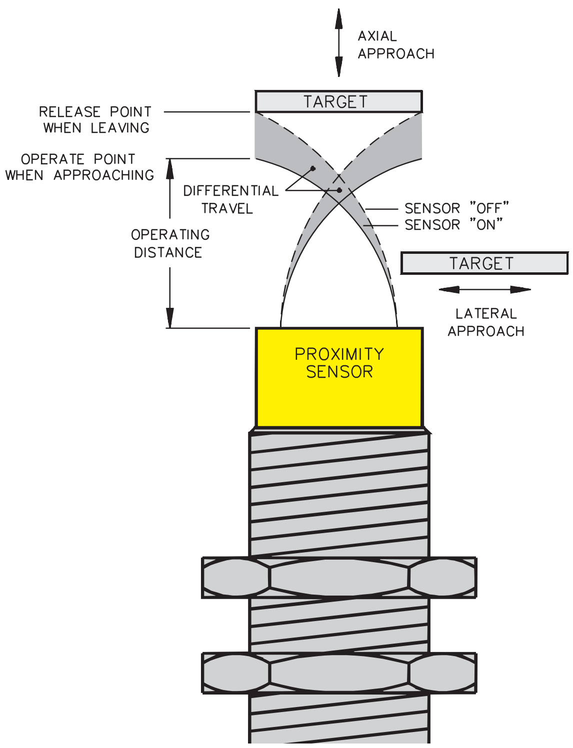
These correction factors apply to standard inductive sensors when a nonferrous target is being detected. The correction factors are nominal values. Deviations may be due to variations in oscillator frequency, alloy composition, purity and target geometry.

Aluminum foil	1.00
Stainless steel	0.60 to 1.00
Mercury	0.65 to 0.85
Lead	0.50 to 0.75
Brass	0.35 to 0.50
Aluminum (massive)	0.35 to 0.50
Copper	0.25 to 0.45

- Correction factors do not apply to Turck Uprox ® sensors. These sensors detect all metals at the same range.
- Turck also manufactures "nonferrous only" sensors. These sensors will selectively detect nonferrous targets at the rated operating distance. They will not detect ferrous targets; however, ferrous targets positioned between them and a nonferrous target may mask the nonferrous target. The rated operating distance of these sensors is not subject to the correction factors that apply to standard inductive sensors.

Differential Travel (Hysteresis)

Figure 2



Actuation Mode

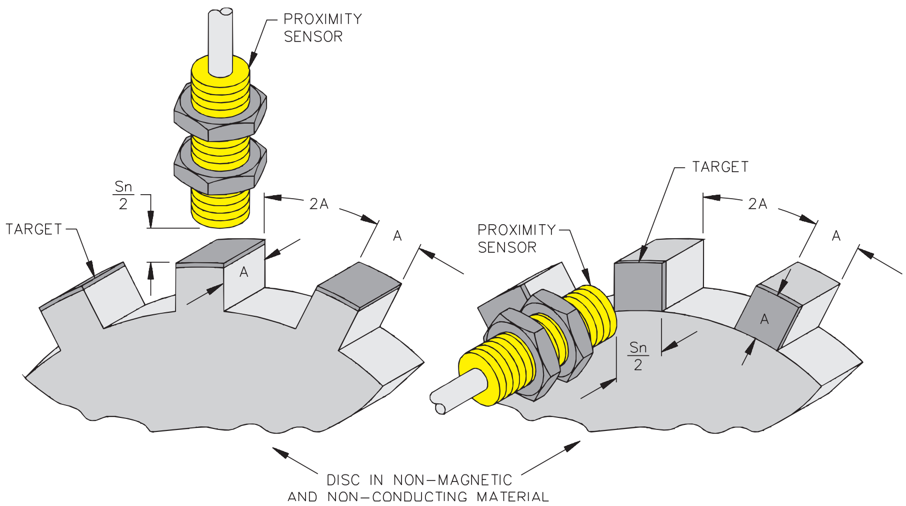
Inductive sensors can be actuated in an axial or lateral approach (**Figure 2**). It is important to maintain an air gap between the target and the sensing face to prevent physically damaging the sensors.

The difference between the "operate" and "release" points is called differential travel (See shaded area in Figure 7). It is factory set at less than 15% of the effective operating distance.

Differential travel is needed to keep proximity sensors from "chattering" when subjected to shock and vibration, slow moving targets, or minor disturbances such as electrical noise and temperature drift.

Maximum Switching Frequency

Figure 3



When using inductive sensors in high speed application, the maximum rated switching frequency is only guaranteed when using optimal target dimensions and sensor spacing. The minimum recommended parameters to use are shown in **Figure 3**. Using smaller targets, target spacing or increasing the sensor to target air gap may result in a reduction of the actual achievable maximum switching frequency. See page J4 for determining dimension "A" of a standard target.

Weld Field Immunity

Many critical applications for proximity sensors involve their use in welding environments. AC and DC resistance welders used in assembly equipment and other construction machines often require in excess of 20 kA to perform their weld function. Magnetic fields generated by these currents can cause false outputs in standard sensors.

Turck has pioneered the design and development of inductive proximity sensors that not only survive such environments, but remain fully operative in them.

The limit of the weld field immunity depends on the kind of field (AC or DC), the housing size of the sensor and its location in the field. For example, in an AC or DC weld field, the "/S34" inductive sensors can be positioned one inch from a 20 kA current carrying bus.

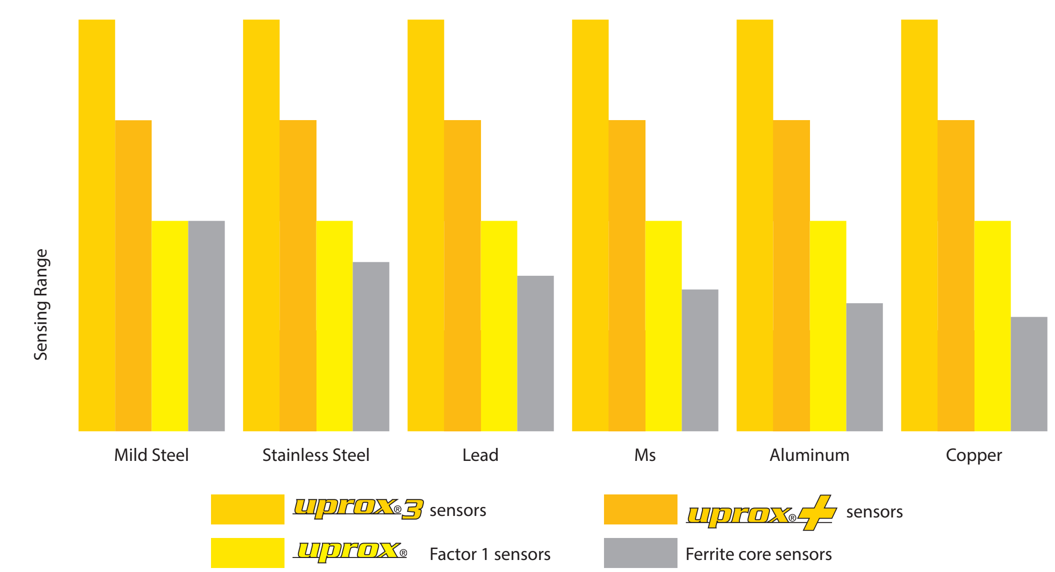
Reference Values for Magnetic Induction:

I [kA]	12.5 mm	25 mm	50 mm	100 mm
5	80 mT	40 mT	20 mT	10 mT
10	160 mT	80 mT	40 mT	20 mT
20	320 mT	160 mT	80 mT	40 mT
50	800 mT	400 mT	200 mT	100 mT
100	1600 mT	800 mT	400 mT	200 mT

Gauss = 10 x mT

Technical Reference | Inductive

Operating Principle Uprox®

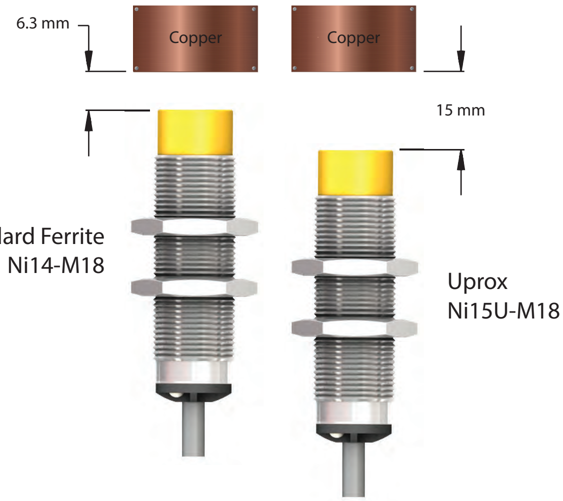


Operating distances comparison of Uprox sensors and standard inductive sensors.

Turck Uprox is a patented next generation development of inductive sensors that uses a multi-coil system. Active coil(s) induces eddy currents on the metal target and passive coil(s) are affected by these eddy currents. Ferrous and nonferrous metals have the same effect on the two coils. Therefore, all metals, including galvanized metals, have the same rated operating distance.

Uprox Advantage

Figure 4



- No Correction Factor - Same rated operating distance for all metals.
- Extended Operating Distance - Up to 400% greater than standard inductive sensors when using non-ferrous targets (**Figure 4**).
- Weld Field Immunity - Uprox is unaffected by strong electromagnetic AC or DC fields because of its unique patented design.
- High Switching Frequencies - Up to 10 times faster than standard inductive sensors.
- Extended Temperature Range - Uprox+ can withstand temperatures up to 85 °C (+185 °F) with a ±15% temperature drift.
- Select Uprox3 sensors are IO-Link compatible.