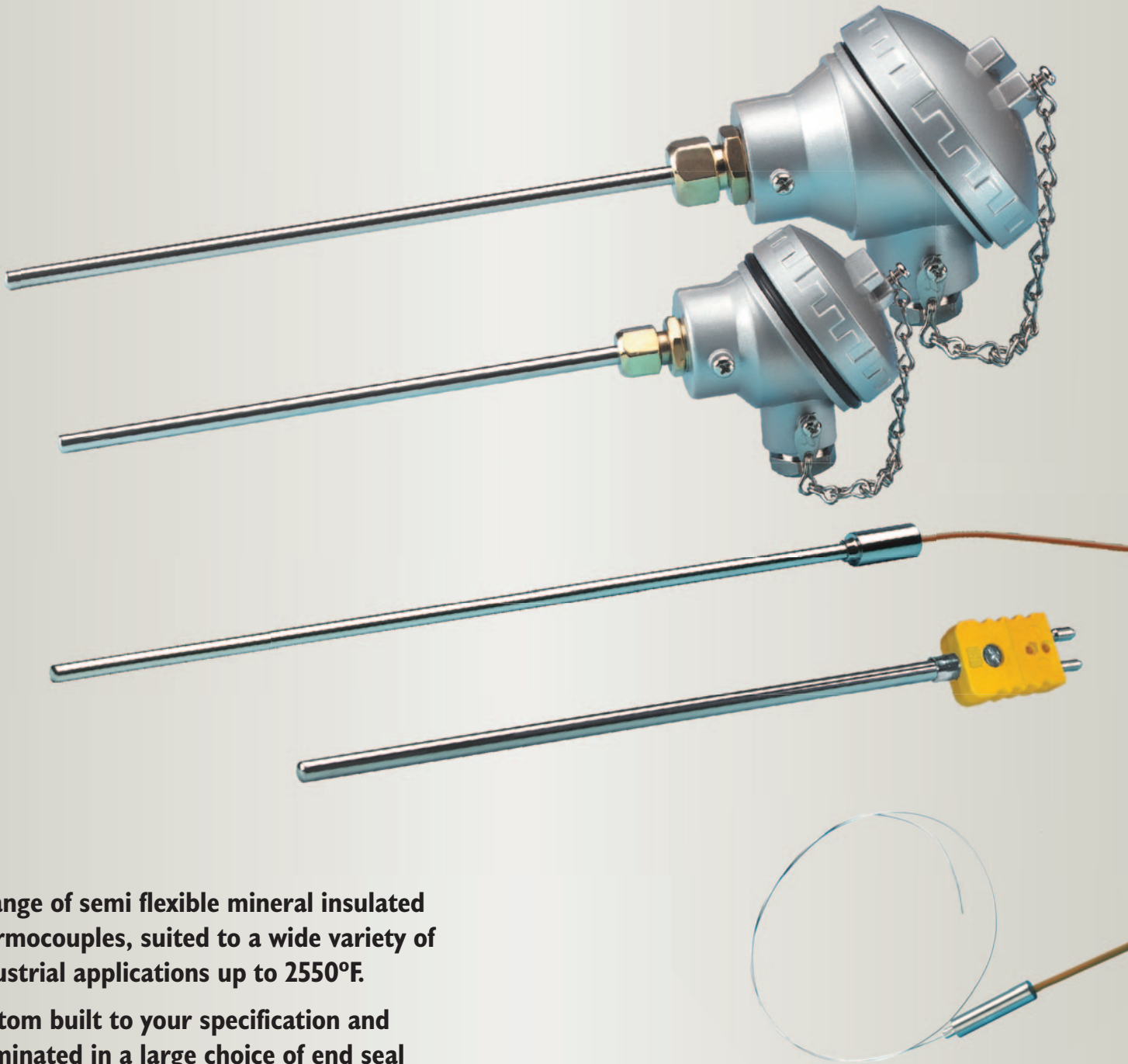




Mineral Insulated Thermocouples - Type 12



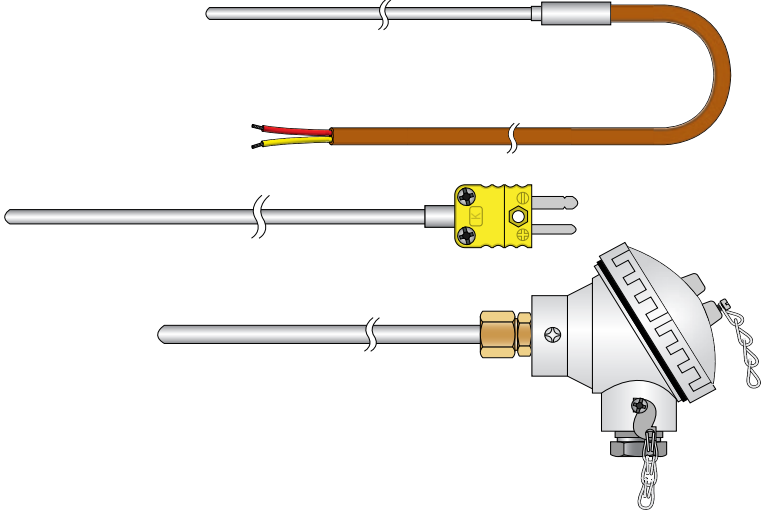
A range of semi flexible mineral insulated thermocouples, suited to a wide variety of industrial applications up to 2550°F.

Custom built to your specification and terminated in a large choice of end seal terminations and sheath materials from 0.010" to 0.425" diameter.

Type 12 Mineral Insulated Thermocouples

- High integrity construction suited to arduous operating conditions at temperatures from -330°F to +2550°F
- High accuracy and stability maintained throughout operating life
- Fast response and high insulation resistance
- NIST* traceable calibration is available for our range of Mineral Insulated thermocouple assemblies (our equipment and standards are traceable to NIST via the Mutual Recognition Arrangement)
- The wire used to manufacture these assemblies conforms to ASTM-E230 Standard Limits of error, other tolerances available upon request
- Available in K, T, J, N, E, R, S, & B with sheath diameters from 0.010" to 0.425" and lengths from a few inches to 200 feet or more dependent on the sheath diameter selected
- Sheaths can generally be bent, twisted and flattened to suit particular installations without impairing performance
- Swaged end assemblies are available where fast response high strength sheaths or low displacement are a necessity

*traceable to the SI (International System of Units) via a signatory of the CIPM Mutual Recognition Arrangement



Typical Construction

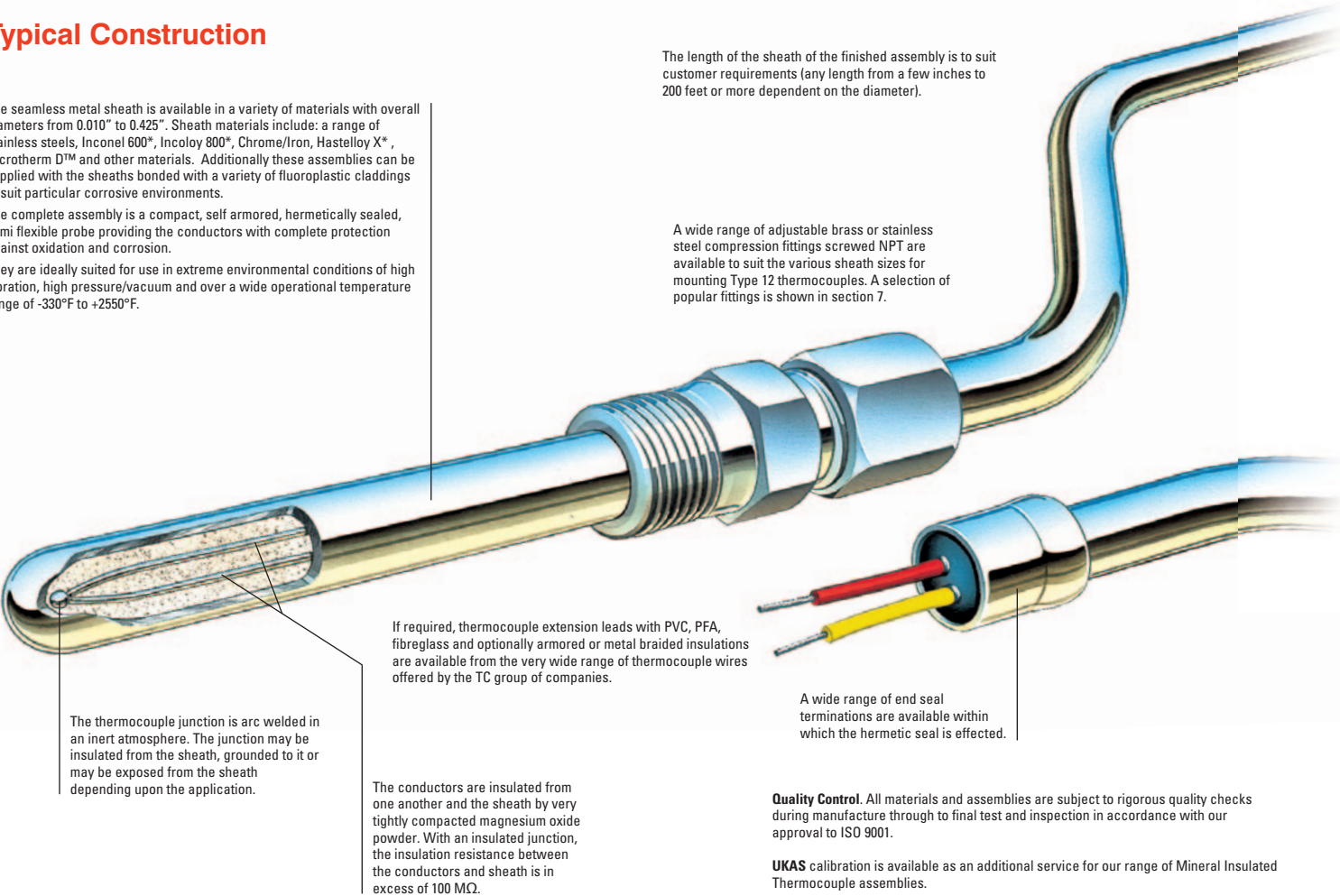
The seamless metal sheath is available in a variety of materials with overall diameters from 0.010" to 0.425". Sheath materials include: a range of stainless steels, Inconel 600*, Incoloy 800*, Chrome/Iron, Hastelloy X*, Microtherm D™ and other materials. Additionally these assemblies can be supplied with the sheaths bonded with a variety of fluoroplastic claddings to suit particular corrosive environments.

The complete assembly is a compact, self armored, hermetically sealed, semi flexible probe providing the conductors with complete protection against oxidation and corrosion.

They are ideally suited for use in extreme environmental conditions of high vibration, high pressure/vacuum and over a wide operational temperature range of -330°F to +2550°F.

The length of the sheath of the finished assembly is to suit customer requirements (any length from a few inches to 200 feet or more dependent on the diameter).

A wide range of adjustable brass or stainless steel compression fittings screwed NPT are available to suit the various sheath sizes for mounting Type 12 thermocouples. A selection of popular fittings is shown in section 7.



The thermocouple junction is arc welded in an inert atmosphere. The junction may be insulated from the sheath, grounded to it or may be exposed from the sheath depending upon the application.

If required, thermocouple extension leads with PVC, PFA, fibreglass and optionally armored or metal braided insulations are available from the very wide range of thermocouple wires offered by the TC group of companies.

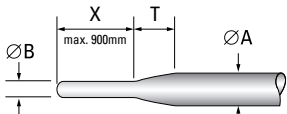
The conductors are insulated from one another and the sheath by very tightly compacted magnesium oxide powder. With an insulated junction, the insulation resistance between the conductors and sheath is in excess of 100 MΩ.

A wide range of end seal terminations are available within which the hermetic seal is effected.

Quality Control. All materials and assemblies are subject to rigorous quality checks during manufacture through to final test and inspection in accordance with our approval to ISO 9001.

UKAS calibration is available as an additional service for our range of Mineral Insulated Thermocouple assemblies.

Swaged Reduced Tip



Swaged end reduced tip temperature sensors provide a unique fast response, high strength, low displacement, homogenous solution to many problematical temperature measurement applications. The technique combines the advantages of having a rugged large diameter metal sheath over most of its length with a low thermal mass, fast response, reduced diameter tip.

The length of the reduced tip (X) can be any length up to 35" and virtually any diameter between 0.020" and 0.205" with the most popular sizes are shown in the table. Please contact us for other sizes.

ØB	Approximate Transition Lengths ('T' inches) for given Ø 'A' inches						
	0.250"	0.188"	0.125"	0.079"	0.062"	0.040"	0.020"
0.250"	—	—	—	—	—	—	—
0.188"	0.236"	—	—	—	—	—	—
0.125"	0.472"	0.236"	—	—	—	—	—
0.079"	0.630"	0.394"	0.157"	—	—	—	—
0.062"	0.709"	0.472"	0.236"	0.079"	—	—	—
0.040"	0.787"	0.551"	0.315"	0.157"	0.079"	—	—
0.020"	—	—	—	0.236"	0.157"	0.079"	—

Mineral Insulated Thermocouples Type 12

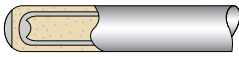
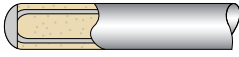

SECTION 1	Thermocouple Type	Temperature Range*	
		(continuous)	(short term)
K	Nickel Chromium vs Nickel Aluminium	+32 to +2010°F	-290 to +2460°F
T	Copper vs Constantan	-300 to +570°F	-42 to +750°F
J	Iron vs Constantan	+68 to +1290°F	-290 to +1380°F
N	Nicrosil vs Nisil	32 to +2010°F	-450 to +2370°F
E	Nickel Chromium vs Constantan	+32 to +1470°F	-40 to +1650°F
R	Platinum - 13% Rhodium vs Platinum	+32 to +2820°F	-60 to +3180°F
S	Platinum - 10% Rhodium vs Platinum	+32 to +2910°F	-60 to +3090°F
B	Platinum - 30% Rhodium vs Platinum - 6% Rhodium	+212 to +2910°F	+212 to +3310°F

*Depending on sheath material.

SECTION 3	Sheath Diameter (inches)	Sheath Diameter (mm)
Standard Sizes	0.010"	0.25mm
	0.020"	0.5mm
	0.030"	0.75mm
	0.039"	1.0mm
	0.059"	1.5mm
	0.063"	1.6mm (1/16")
	0.079"	2.0mm
	0.118"	3.0mm
	0.125"	3.2mm (1/8")
	0.177"	4.5mm
	0.216"	5.5mm*
	0.236"	6.0mm
	0.250"	6.35mm (1/4")
	0.315"	8.0mm
	0.374"	9.5mm
	0.425"	10.8mm*

For types R, S, B, C and D a more limited range of sheath diameters is available.

* 0.218" and 0.425" diameter are thick wall, heavy duty constructions.

SECTION 4	Types of Sensing Junction	
2I		Insulated Hot junction insulated from sheath. Gives floating output with typical insulation resistance in excess of 100 megohms (or 2ID if Duplex element is required and 2IT if triplex element is required).
2G		Grounded Hot junction welded to sheath tip giving earthed output and faster response to temperature changes (or 2GD if Duplex element is required and 2GT if triplex element is required).
2X		Exposed Fastest response mainly for the measurement of air temperature in ducts. Restricted to a maximum operating temperature of 1110°F (or 2XD if Duplex element is required and 2XT if Triplex element is required).

To suit particular attachment requirements thermocouples with measuring junction configurations 2I or 2G can be supplied with an extended tip or welding pad. (Contact the company for details of standard welding pad and extension tip configurations.)

Other special measuring junction configuration requirements can be met upon request.

SECTION 2	Sheath Materials		
	Sheath Specifications	Operational Properties	Max. Temp.
Standard	321 Grade 321 Stainless Steel 18/8/1 Ni/Cr/Titanium Stabilised To BS EN 10088, Werkstoff No : 1.4541	Very good corrosion resistance throughout the operating temperature range. Suited to a wide range of industrial applications. Enjoys high ductility.	1470°F
	310 Grade 310 Stainless Steel 25/20 Nickel/Chromium To BS EN 10088, Werkstoff No : 1.4845	Good high temperature corrosion resistance and suitable for use in sulphur bearing atmospheres. 310 stainless steel has high oxidation resistance.	2010°F
	600 Inconel 600* Nickel/Chromium/Iron alloy To BS EN 10095, Werkstoff No : 2.4816	Used in severely corrosive atmospheres to elevated temperatures. Has good resistance to oxidation. Not recommended for use above 800°C when used with Type R, S or B thermocouples. Do not use in sulphur bearing atmospheres above 550°C.	2010°F


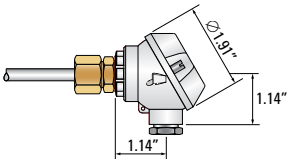
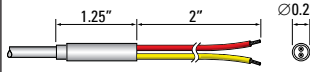
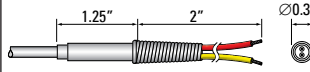
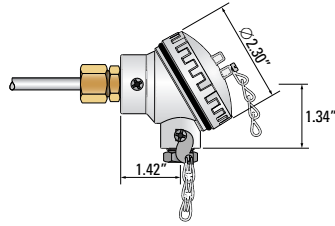
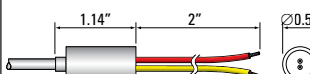
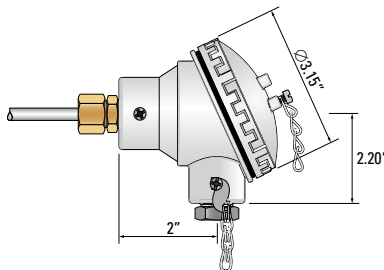
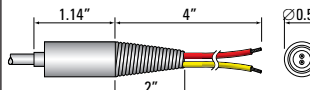
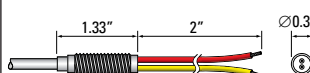
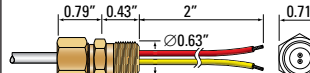
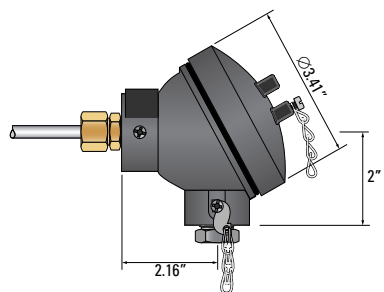
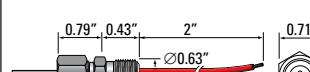
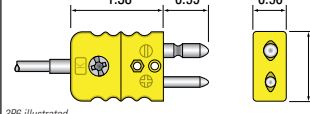
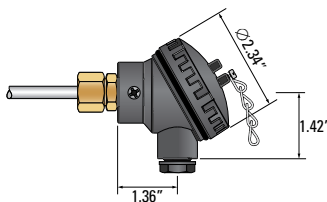
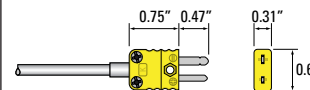
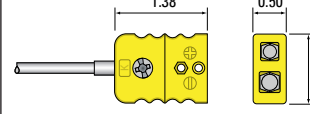
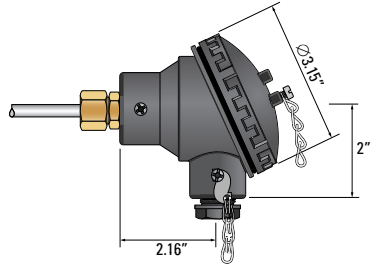
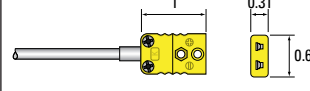
Specialized	316L	Grade 316L Stainless Steel 18/8/1 Ni/Cr/Molybdenum Stabilised To BS EN 10088, Werkstoff No : 1.4404	Good high temperature corrosion resistance and suitable for use in sulphur bearing atmospheres. 316L stainless steel has high oxidation resistance.	1470°F
	800	Incoloy 800* Iron/Nickel/Chromium alloy To BS EN 10095, Werkstoff No : 1.4876	Suitable for use in severely corrosive atmospheres to elevated temperatures. Enjoys a good resistance to oxidation and carburisation. Incoloy 800 is resistant to sulphur bearing atmospheres.	2010°F
	825	Incoloy 825* Iron/Nickel/Chromium alloy To BS EN 10204, Werkstoff No : 2.4858	Iron/Nickel/Chromium alloy with additions of molybdenum, copper, and titanium. Exceptional resistance to many corrosive environments. Resistant to chloride-ion stress-corrosion cracking.	2280°F
	446	AISI 446 Chrome/Iron ASTM TP446, AISI 446, To BS EN 10095, DIN X18CrN28, Werkstoff No : 1.4762	Suitable for use in severely corrosive atmospheres to elevated temperatures. Particularly suited for use in high concentration sulphur bearing atmospheres at high temperature. Sensor should be mounted vertically at temperatures above 700°C.	2100°F
	156	Hastelloy X* Nickel/Chromium/Iron/Molybdenum 51/22/18/9 Werkstoff No : 2.4665	For use in reducing, neutral and inert atmospheres. Has improved high temperature resistance to oxidation and attack by sulphur. At high temperature it has excellent tensile strength and develops a tightly adherent oxide film which does not spall.	2230°F
	276	Hastelloy C276* Nickel/Chromium/Iron/Molybdenum To ASTM B574, Werkstoff No : 2.4819	Excellent corrosion resistance to both oxidizing and reducing media and excellent resistance to localized corrosion attack. Excellent resistance to sulphur compounds and chloride ions.	2280°F
	114	Nicrotherm D™ Nickel/Chromium/Silicon/Molybdenum 73/22/1.4/3	For high temperature Type 'K' and almost all Type 'N' applications (optimum benefits with Type 'N'). Very good high temperature strength. Excellent in oxidising, carburising, reducing and vacuum atmospheres. Do not use in sulphur containing atmospheres.	2280°F
	160	Haynes HR160 Solid solution strengthened Nickel/Cobalt/Chromium-Silicon alloy ASTM B626, Werkstoff No : 2.4880	Resistant to various forms of high temperature corrosion attack. Excellent resistance to sulphur and chloride attack. Resistant to oxidation, hot corrosion, carburization, metal dusting, nitridation, and corrosion attack by low melting point compounds.	2190°F
	P10R	Platinum 10% Rhodium	Primarily for use with thermocouple types R, S and B. Suitable for high temperature oxidizing atmospheres and inert atmospheres.	2550°F
	Other sheath materials are available upon request.			* Trade Names

Typical Response Times			
Øinches	Time	Øinches	Time
0.010"	0.015 seconds	0.125"	0.880 seconds
0.020"	0.030 seconds	0.177"	1.400 seconds
0.030"	0.090 seconds	0.217"	4.000 seconds
0.040"	0.150 seconds	0.236"	3.000 seconds
0.060"	0.300 seconds	0.250"	3.450 seconds
0.062"	0.320 seconds	0.313"	5.500 seconds
0.079"	0.400 seconds	0.375"	6.750 seconds
0.118"	0.800 seconds	0.425"	9.000 seconds

Response times for these assemblies are governed by and vary with the environmental conditions of particular applications. The information above refers to typical response times for assemblies with insulated Type 2I junctions being plunged into boiling water from air at 20°C. The figures refer to the times taken for the thermocouple junctions to achieve 63.2% of this instantaneous step change. For assemblies with grounded Type 2G junctions the response times are approximately 50% of those listed.

* thick wall







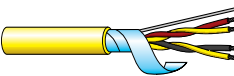

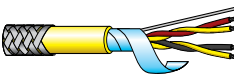

Type 12 Mineral Insulated Thermocouples

SECTION 5	Types of End Seal Configuration				
	Diagram	Specification		Diagram	Specification
3P1		Internal Seal with Bare Conductors for all sheath diameters 3P1 Maximum end seal temperature 275°F 3P1B Maximum end seal temperature 570°F 3P1C Maximum end seal temperature 1200°F <i>Note: Only suitable as a temporary seal for applications adding an alternative seal later</i>	MAA		Micro Die Cast Alloy Head for diameters 0.118" to 0.250" Weatherproof die cast alloy, epoxy coated, screw down terminal head with tube entry and cable entry at a right angle to each other, with a ceramic terminal block. Suitable for simplex and duplex assemblies. Supplied with a metal pinch gland on the cable entry for wires from 0.157" to 0.374" diameter. cable entry thread is M16x1.5mm, process entry thread is M10x1.0mm.
3P2L		Crimp on Stainless Steel Pot Seal for sheath diameters up to 0.118" 3P2L Pot Seal rated to 275°F 3P2LA Pot Seal rated to 455°F 3P2LB Pot Seal rated to 570°F <i>see section 6 if extension leads are required</i>			
3P2 TRL	 <small>* It is unlikely that any benefit would be derived from specifying this type of pot seal with the standard 4" tails.</small>	Stainless Steel Pot Seal with Anti Chafe Spring for sheath diameters up to 0.118" 3P2TRL Pot Seal rated to 275°F 3P2TRLA Pot Seal rated to 455°F 3P2TRLB Pot Seal rated to 570°F <i>see section 6 if extension leads are required</i>	3P10/ 12NPT		Miniature Die Cast Alloy Head for diameters 0.118" to 0.313" Weatherproof die cast alloy, epoxy coated, screw top terminal head with the tube entry and cable entry at a right angle to each other, with a ceramic terminal block. Suitable for simplex and duplex assemblies. Supplied with a metal pinch gland on the cable entry for wires from 0.118" to 0.315" diameter. cable entry thread is M16x1.5mm, process entry thread is 1/2" NPT.
3P4CL		Crimp on Stainless Steel Pot Seal for sheath diameters between 0.118" & 0.313" 3P4CL Pot Seal rated to 275°F 3P4CLA Pot Seal rated to 455°F 3P4CLB Pot Seal rated to 570°F <i>see section 6 if extension leads are required</i>	3P11/ 12NPT		Standard Die Cast Alloy Head for diameters 0.177" to 0.425" Weatherproof die cast alloy, epoxy coated, screw top terminal head with the tube entry and cable entry at a right angle to each other, with a ceramic terminal block. Suitable for simplex, duplex and triplex assemblies. Supplied with a metal pinch gland on wire entry for wires from 0.236" to 0.551" diameter. Wire entry thread is M20x1.5mm, process entry thread is 1/2" NPT.
3P4 CTRL	 <small>* It is unlikely that any benefit would be derived from specifying this type of pot seal with the standard 4" tails.</small>	Stainless Steel Pot Seal with Anti Chafe Spring for sheath diameters between 0.118" & 0.313" 3P4CTRL Pot Seal rated to 275°F 3P4CTRLA Pot Seal rated to 455°F 3P4CTRLB Pot Seal rated to 570°F <i>see section 6 if extension leads are required</i>			
3P3L	 <small>Lock nuts are available in stainless steel to suit the 3P3L series and should be ordered separately as LND05.</small>	8mm ISO x 1mm Threaded Stainless Steel Pot Seal for sheath diameters up to 0.313" 3P3L Pot Seal rated to 275°F 3P3LA Pot Seal rated to 455°F 3P3LB Pot Seal rated to 570°F <i>see section 6 if extension leads are required</i>			
3P5		16mm ISO x 1.5mm Brass Compression Gland Pot Seal for sheath diameters up to 0.313" 3P5 Pot Seal rated to 275°F 3P5A Pot Seal rated to 455°F <i>see section 6 if extension leads are required</i>	3P12		Heavy Duty Cast Iron Head for diameters 0.177" to 0.425" Weatherproof cast iron, screw top terminal head with the tube entry and cable entry at a right angle to each other, with ceramic terminal block. Suitable for simplex, duplex and triplex assemblies. Supplied with a metal pinch gland on cable entry for wires from 0.236" to 0.551" diameter. cable entry thread is M20x1.5mm, process entry thread is 1/2" BSP.
3P5S		16mm ISO x 1.5mm St. Steel Compression Gland Pot Seal for sheath diameters up to 0.313" 3P5S Pot Seal rated to 275°F 3P5SA Pot Seal rated to 455°F 3P5SB Pot Seal rated to 570°F <i>see section 6 if extension leads are required</i>			
3P6	 <small>3P6 illustrated</small>	Standard 2-pin (round) Plug for sheath diameters between 0.040" & 0.315" 3P6 Plug rated to 430°F 3P6H Plug rated to 570°F 3P6UH Plug rated to 790°F 3P6C Plug rated to 1110°F	3P16		Miniature Plastic Head for diameters 0.118" to 0.313" Weatherproof plastic, screw top terminal head with the tube entry and cable entry at a right angle to each other, with a plastic terminal block. Suitable for simplex and duplex assemblies. Supplied with a plastic pinch gland on wire entry for wires from 0.118" to 0.315" diameter. Wire entry thread is M16x1.5mm, process entry thread is 3/8" BSP.
3P6M	 <small>3P6M illustrated</small>	Miniature 2-pin (flat) Plug for sheath diameters between 0.010" & 0.125" 3P6M Plug rated to 430°F 3P6MH Plug rated to 570°F 3P6MUH Plug rated to 790°F 3P6MC Plug rated to 1110°F			
3P7	 <small>3P7 illustrated</small>	Standard 2-pin (round) Socket for sheath diameters between 0.040" & 0.315" 3P7 Socket rated to 430°F 3P7H Socket rated to 570°F 3P7UH Socket rated to 790°F 3P7C Socket rated to 1110°F	3P17		Standard Plastic Head for diameters 0.177" to 0.425" Weatherproof plastic, screw top terminal head with the tube entry and cable entry at a right angle to each other, with a plastic terminal block. Suitable for simplex, duplex and triplex assemblies. Supplied complete with a plastic pinch gland on the cable entry for wires from 0.236" to 0.551" diameter. Wire entry thread is 1/2" BSP, process entry thread is 1/2" BSP.
3P7M	 <small>3P7M illustrated</small>	Miniature 2-pin (flat) Socket for sheath diameters between 0.010" & 0.125" 3P7M Socket rated to 430°F 3P7MH Socket rated to 570°F 3P7MUH Socket rated to 790°F 3P7MC Socket rated to 1110°F			

continued

Mineral Insulated Thermocouples Type 12

SECTION 5	Types of End Seal Configuration (continued)				
	Diagram	Specification		Diagram	Specification
3P18		Alloy Straight Through Head for diameters 0.177" to 0.425" Die cast alloy straight through terminal head with a bakelite terminal block. Suitable for simplex or duplex assemblies. Supplied with a pinch gland on the cable entry for wires from 0.236" to 0.551" diameter. cable entry thread is M20x1.5mm, process entry thread is 1/2" BSP. <i>*If supported at fixing holes, suitable for diameters of 0.039" and above.</i>	3P20		Spring Loaded Terminal Block for diameters 0.118" to 0.315" Spring loaded insert assemblies. The end seal is incorporated into a terminal block suitable for mounting into a 3P11, 3P12, 3P17 or any other standard terminal head. Suitable for use with 0.118" to 0.315" sheaths only. The ceramic terminal block has 2 x 1.30" spaced mounting holes. Suitable for simplex, duplex and triplex assemblies.
3P19		Stainless Steel Head for diameters 0.177" to 0.425" Weatherproof stainless steel, screw top terminal head with the tube entry and cable entry at a right angle to each other, with a ceramic terminal block. Suitable for simplex, duplex and triplex assemblies. Supplied with a metal pinch gland on cable entry for wires from 0.236" to 0.551" diameter. cable entry thread is M20x1.5mm, process entry thread is 1/2" BSP.	3P20/ BP		DIN Mounting Plate for diameters 0.118" to 0.315" Spring loaded mounting plate assemblies. The end seal is incorporated into a mounting plate suitable for mounting into a 3P11, 3P12, 3P17 or any other standard terminal head. Suitable for use with 0.118" 0.315" sheaths only. 4" tails allows for connection to a head mounting transmitter or other suitable terminal block.

SECTION 6	Extension Wires					
	Diagram	Specification		Diagram	Specification	
A30		HR PVC Flat Twin (220°F) One pair of 24 AWG stranded (7x32 AWG) conductors HR PVC insulated. Pair laid flat and HR PVC sheathed overall.	B80		PFA Twisted Pair with Screen (480°F) One pair of 24 AWG stranded (7x32 AWG) conductors PFA insulated. Pair twisted, screened with Mylar® aluminium tape and drain wire. PFA sheathed overall.	
A27		HR PVC Twisted Pair with Screen (220°F) One pair of 24 AWG stranded (7x32 AWG) conductors HR PVC insulated. Pair twisted, screened with Mylar® aluminium tape and drain wire. HR PVC sheathed overall.	B40		PFA Twisted with Ni Plated Cu Braid (480°F) One pair of 24 AWG stranded (7x32 AWG) conductors PFA insulated. Pair twisted with overall nickel plated copper braid and PFA sheathed.	
B50		PFA Flat Twin (480°F) One pair of 24 AWG stranded (7x32 AWG) conductors PFA insulated. Pair laid flat. PFA sheathed overall.	SR30		Silicone Rubber, Twisted Pair (390°F) One pair of 24 AWG stranded (7x32 AWG) conductors PFA insulated. Silicone rubber sheathed.	
BM 0702		PFA 2-pair for duplex sensors (480°F) Two pairs of 24 AWG stranded (7x32 AWG) conductors PFA insulated. Pairs twisted and bunched and screened with Mylar® aluminium tape with a drainwire. PFA sheathed.	C40		Fibreglass Flat Twin (896°F) One pair of 24 AWG stranded (7x32 AWG) conductors double glass fibre lapped, braided and varnished. Pair laid flat, glass fibre braided and varnished.	
BM 0702/ SSB		PFA 2-pair for duplex sensors with Stainless Steel braid (480°F) Two pairs of 24 AWG stranded (7x32 AWG) conductors PFA insulated. Pairs twisted and bunched and screened with Mylar® aluminium tape with a drainwire. PFA sheathed with overall stainless steel braid.	C60		Fibreglass Flat Twin with Steel Braid (896°F) One pair of 24 AWG stranded (7x32 AWG) conductors double glass fibre lapped, braided and varnished. Pair laid flat, glass fibre braided and varnished. Stainless steel wire braided overall.	

If no wire is required, leave this section of the order code blank and the sensor will be supplied with PFA tails. Other wires are available on request.

'HR' = Heat Resistant

SECTION 7	Optional Stainless Steel Compression Fittings							
	Dia.	1/8" NPT	1/4" NPT	1/2" NPT	Dia.	1/8" NPT	1/4" NPT	1/2" NPT
	0.020"	SFS18N05	—	—	0.125"	SFS18N32	SFS14N32	SFS12N32
	0.030"	SFS18N75	—	—	0.188"	SFS18N47	SFS14N47	SFS12N47
	0.040"	SFS18N10	SFS14N10	SFS12N10	0.250"	SFS18N64	SFS14N64	SFS12N64
	0.062"	SFS18N16	SFS14N16	SFS12N16	0.313"	—	SFS14N80	SFS12N80

Other sizes and materials are available, please contact us for details.

SECTION 8	Optional 4 to 20mA Head Mounted Transmitter (please specify range in °F)	
	Diagram	Specification
TXLTC		Suitable for use with the following terminal heads: 3P11, 3P12, 3P17, 3P18 and 3P19 and other standard heads with 33mm fixing. Typical Order Code: TXLTC (0/300°F)

Order Code - Example										
Style No.	Thermocouple Type (see section 1)	Sheath Length	Sheath Material (see section 2)	Sheath Diameter (see section 3)	Sensing Junction (see section 4)	End Seal Termination (see section 5)	Extension Wire (see section 6)	Optional Compression Fitting (see section 7)	Reduced Tip Dimensions (if required)	Optional Transmitter (see section 8)
12	- K	- 12"	- 310	- 0.250"	- 2I	- 3P4CL	- 2 FT A30KX	- SFS18N32	- REDUCED TIP: 0.118" x 2" LONG	-



TC Measurement and Control Inc
PO Box 685
Hillside , IL 60162
Tel: 708-449-0700
Toll Free: 877 244 1777
Fax: 708-449-0777
Email: info@tc-inc.com
Web: www.tc-inc.com

© 2019 TC Measurement and Control, Inc.
Issue Number: 0421

TC Inc for Temperature Sensing, Measurement and Control