



LINEAR **M**EASUREMENT **I**NSTRUMENTS, Corp.

Research, Development and Manufacturing of Precision Measuring Systems

**CALIBRATION/ MASTERING INSTRUCTIONS FOR
LMI 770 TO INTERFACE WITH LMI 440**

REQUIRED EQUIPMENT:

LMI 770 Transducer
LMI 720 Master block
LMI 6009 4 pin – 4 pin cable
LMI 440

SETUP FOR FLUSH:

1. Connect the transducer to Gage Port 4 of the data collector.
2. Press <menu> to turn on the LMI 440
3. Press ▼ to highlight “Gage”.
4. Press <enter>.
5. Setup for Flush
6. From the list displayed, use the ▲ or ▼ keys on the data collector to choose which gage designation to configure, (i.e., G4, G4A) and press <enter>.
7. Type the unique gage name, (i.e.: LMI-FLUSH) and press ► when complete.
8. Press the ► to highlight “Configure” and set up as follows using the ▼ and ▲ buttons to highlight the different selections. Use the <enter> button to toggle the choices.
 - Type: Read at Enter
 - Master Type: (Three point)
 - Scale: 10*
 - Zero Master: 0
 - Zero at Enter: (No)
9. Press the ► to highlight “Master”.
10. Fully extend the transducer; highlight ‘Master Lo’ and press <enter>.
11. Fully retract the transducer; highlight ‘Master Hi’ and press <enter>.
12. Place the LMI 770 into the LMI 720 block in the flush master position, highlight ‘Master Zero’ and press <enter>

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SETUP FOR GAP:

1. Connect the transducer to Gage Port 4 or 5 of the data collector.
2. Press <menu> to turn on the LMI 440
3. Press ▼ to highlight “Gage”.
4. Press <enter>.
5. From the list displayed, use the ▲ or ▼ keys on the data collector to choose which gage designation to configure, (i.e., G4a, G4b) and press <enter>.
6. Type the unique gage name, (i.e.: LMI-GAP) and press ► when complete.
7. Press the ► to highlight “Configure” and set up as follows using the ▼ and ▼ buttons to highlight the different selections. Use the <enter> button to toggle the choices.
 - Type: Read at Enter
 - Master Type: (Three point)
 - Scale: 10*
 - Zero Master: 0**
 - Zero at Enter: (No)
8. Press the ► to highlight “Master”.
9. Fully extend the transducer; highlight ‘Master Lo’ and press <enter>.
10. Fully retract the transducer; highlight ‘Master Hi’ and press <enter>.
11. Place the LMI 770 into the LMI 720 block in the gap master position highlight ‘Master Zero’ and press <enter>
12. Calibration is now complete***

NOTES:

- * This configuration will produce a positive reading when retracted beyond the nominal. To reverse the signs change the scale value in the configuration screen to -10.00.
- ** This configuration will produce deviation from nominal, if the actual gap reading is desired, change the ‘Zero Master’ to 3 and reverse steps 9 and 10 for Gap.
- *** To verify calibration and mastering use the LMI 770 with the 720 master block in the appropriate “Test” screen, i.e., G4 for flush and G4a for gap.