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LMI ™

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

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Research, Development and Manufacturing of Precision Measuring Systems

CALIBRATION/ MASTERING INSTRUCTIONS FOR SEAL GAP USING THE LMI 200 SB PROBE TRANSDUCER WITH THE DATAMYTE 3053

REQUIRED EQUIPMENT FROM DATAMYTE: DataMyte 3053

REQUIRED EQUIPMENT FROM LMI: LMI 200-SB Probe

LMI 210 Master Block

LMI 234 Probe adaptor

LMI 6100 Interface which includes:

LMI 6009 4 pin – 4 pin cable

LMI 6011 6 pin – 8 pin cable

LMI 6007 Interface Control Unit

LMI 6002 DataMyte Adapter

1. Connect the transducer to Gage Port 1 of the data collector.
2. Turn on the data collector.
3. Move the cursor to "Options".
4. Select the "Configure Gages" and press "Enter".
5. From the list displayed use the arrow keys on the data collector to choose which gage designation to configure, (i.e.: G1B G1C) and press "Enter".
6. Type the unique gage name, (i.e.: LMI-200) and press "Enter".
7. Move the cursor to "Configure" and setup as follows:
   ➢ Type: Gap & Flush
   ➢ Scale: 10mm (.394)
   ➢ Zero Master: 10*
   ➢ Transducer: Low level gap gage
   ➢ Switch: (Read)
   ➢ Master Type: (Three Point)
   ➢ Show Additional Parameters: (No)
8. Press the right arrow key. a "Save Gage Configuration" window will pop-up. Select "Save to Current Gages" and press "Enter".
9. Move the cursor to "Master".
10. Place the LMI 200-SB, with the flat tip assembly attached, in the top step of the 210 mastering block. Select "Master Lo". Press "Enter".
11. Place Probe in the lowest step of the 210 mastering block. Select "Master Hi". Press "Enter".
12. Place the Probe in the top step of the 210 mastering block. Select "Master Zero" and press "Enter". the value should read 10.000.
13. Attach the LMI 234 onto the 200-SB until it bottoms out on the shoulder of the barrel.
1 Transducer is now ready to send data to the DataMyte 3053

NOTE:
* This configuration will produce a 10 to 20mm reading which is the standard dimension for the LMI 235 and 236.