



**L**INEAR **M**EASUREMENT **I**NSTRUMENTS, Corp.

Research, Development and Manufacturing of Precision Measuring Systems

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**CALIBRATION INSTRUCTION FOR THE LMI 200-SF TO THE LMI 585**  
**(ADJUSTMENT PROCEDURE FOR LMI 200-SF TO LMI 585)**

**NOTE:**

The default conditions for the LMI 585 at port 1 are for surface checks at a 10mm span. It is imperative to change the Calspan on the LMI 585 to 22mm. The following procedure will prepare the LMI 585 to be calibrated with a LMI 200-SF.

1. Turn on the LMI 585 by pressing the I/O button
2. When the LMI 585 has finished with the start up function press the **▲** to \*MENU\* ADVNCED
3. Press the **▶** to \*ADVNCED PORT 1a>
4. Press the **▶** to \*PORT 1a READ >
5. Press the **▲** to \*PORT 1a CALSPAN>
6. Press the **▶** to \*CALSPAN 10.000
7. Press the **▲** to adjust the CALSPAN to 22.000. One press of the **▲** will equal 1mm of adjustment.
8. When the \*CALSPAN reads 22.000 press the <SELECT> button
9. The LMI 585 is now ready to be calibrated with the LMI 200-SF\*

**NOTE:**

\* This changes the CALSPAN for port 1 to 22mm and will stay at 22mm until the CALSPAN is adjusted again or the LMI 585 reverts back to default setting i.e. changing a battery

# LMI Corporation

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**LMI EQUIPMENT REQUIRED:**

- LMI 200-SF 22mm Surface Probe
- LMI 585 Digital Transmitter
- LMI 6009 4 pin – 4 pin modular cable
- LMI 214 Master Block for the LMI 200-SF

1. Turn on the LMI 585 by pressing the I/O button
2. When the LMI 585 has finished with the start up function, press the ▲ to \*MENU\* CAL >
3. Press the ▶ to \*CAL PORT 1P>
4. Press the ▶ to \*PORT 1P LOW CAL
5. Place the LMI 200-SF into the tallest step of the LMI 214 Master Block and press <SELECT>\*
6. The LMI 585 will change to \*PORT 1P HI CAL
7. Place the LMI 200-SF into the shortest step of the LMI 214 Master Block and press <SELECT>
8. The LMI 585 will change to \*PORT 1P MASTER
9. Place the LMI 200-SF into the middle step of the LMI 214 Master Block and press <SELECT>
10. The LMI 585 will change to \*CAL PORT 1P>
11. Press <SEND> to change the LMI 585 to the gage reading screens
12. The appropriate screen to view the readings will have 1P in the lower left corner. To toggle to this screen press the ◀ until 1P appears on the screen.
13. To verify calibration place the LMI 200-SF into the middle step of the LMI 214 Master Block, the reading should be 0.00 +/- 0.02. Place the LMI 200-SF into the low step and tall step, the sum should be 22.00 +/- 0.02.

**NOTE:**

\*This procedure will produce a negative reading when extended beyond the nominal 0.00. To reverse the sign switch steps 5 and 7.