



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

Research, Development and Manufacturing of Precision Measuring Systems

GAGE SETUP AND CALIBRATION INSTRUCTIONS FOR THE LMI 300 WITH THE GAGETALKER “ZIPPER”

REQUIRED EQUIPMENT FROM GAGETALKER: Gagetalker “Zipper”
 “Zipper” Docking Station set up to a computer
 Zipper PC Tools (software)

REQUIRED EQUIPMENT FROM LMI: LMI 300 Flush and Gap Transducer
 LMI 3030 master block
 LMI 6009 4 pin-4 pin cable

GAGE SETUP:

1. From the program “Zipper Administration”, verify setup as follows for a LMI 300 series transducer.
2. Select the “Gages” tab.
3. In Gages, select the “Gage Model” tab.
4. Configure the “Gage Model” screen as follows:
 - Gage Model Name: 300 F & G (L1)
 - Gage Type: LMI/Torque
 - Calibration Method: 300: Min; Max; Zero F; Zero Gap
 - Zero Check Method: 300: Zero Flush; Zero Gap
 - Zero Check (Flush): 0 Secondary (Gap) Zero: -3**
 - Min: 0
 - Max: 10 Linear Range: 10
5. Click on the disk icon button to save this configuration to be used for part file setups.
6. Select the “LMI\Torque Extensions” tab, click on the “+” button and configure as follows for Flush: *
 - Gage Model Name: 300 F & G (L1)
 - Extension Name: (anything to identify this configuration, suggest “Flush Standard”)
 - Mode: Force Starting Threshold: 0 Stopping Threshold: 0
 - Direction: Forward Speed: 125 Hz Time Filter: 0
 - Offset: Primary (Flush)*

LMI Corporation

7. Click on the disk icon button to save this configuration to be used with part file setups.
8. Click on the “+” button and configure as follows for Gap:**
 - Gage Model Name: 300 F & G (L1)
 - Extension Name: (anything to identify this configuration, suggest “Gap Standard”)
 - Mode: Force Starting Threshold: 0 Stopping Threshold: 0
 - Direction: Reverse Speed: 125 Hz Time Filter: 0
 - Offset: Secondary (Gap)
9. Click on the disk icon button to save this configuration to be used with part file setups.
10. At this point the gage is set up and a part file needs to be created and sent to the Zipper. See page 47 of the “Zipper PC Tools” manual for further details on part files.
11. After the part file is sent to the Zipper remove the Zipper from the docking station, “press any key to start”.
12. Select the desired part file for collecting data.
13. Connect the LMI 300 to port “LMI 1” using the LMI 6009.
14. “Select a Gage” will appear for L1. Press \blacktriangle or \blacktriangledown to select “L1: 300 F & G (L1)” and press <Enter>.
15. “<Enter> to Calibrate” will appear. Press \blacktriangle or \blacktriangledown to select “L1=300 F & G (L1)” and press <Enter>.
16. Extend the LMI 300 and press <Enter>.
17. Retract the LMI 300 and press <Enter>.
18. Place the LMI 300 into the Flush Master position on the LMI 3030 Master block and press <Enter>.
19. Place the LMI 300 into the Gap Master position on the LMI 3030 Master block and press <Enter>.
20. Calibration is complete.

NOTE:

* To change the polarity of the gage readings, select a new name for the extension and change the “Direction” to “Reverse”.

** This configuration is to achieve actual gap readings. If deviation from nominal is desired, change in “Gage Model” for “300 F & G (L1)” the “Secondary Gap Zero” to 0. In “LMI\Torque Extensions” change for “300 F & G (L1) Standard Gap” the “Direction” to “Forward”.