

LMI Corporation

7. Click on the disk icon button to save this configuration to be used for part file setups.
8. Select the “LMI\Torque Extensions” tab, click on the “+” button and configure as follows Flush.

Gage Model Name: 241 Flush (L2)

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)

9. Click on the disk icon button to save this configuration to be used with part file setups.

10. Click on the “+” button and configure as follows for Gap.

Gage Model Name: 241 Gap (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: Primary (Flush)

11. Click on the disk icon button to save this configuration to be used with part file setups.

12. 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***.

13. After the part file is sent to the Zipper, remove Zipper from the docking station and “press any key to start”

14. Select the desired part file for collecting data.

15. Connect the LMI 241 to port “LMI 2” using the LMI 6018.

16. “Select a Gage” will appear for L1. Press \blacktriangle or \blacktriangledown to select “L1:241 Gap (L1)” and press <Enter>.

17. “Select a Gage” will appear for L2. Press \blacktriangle or \blacktriangledown to select “L2:241 Flush (L2)” and press <Enter>.

18. “<Enter> to Calibrate” will appear. Press \blacktriangle or \blacktriangledown to select “L2=241 Flush (L2)” and press <Enter>.

19. On the LMI 241 retract the gap finger and leave the flush tip extended, press <Enter>.

20. On the LMI 241 retract the flush tip and leave the gap finger extended, press <Enter>.

21. Place the LMI 241 into the LMI 720 master block at the master position and press <Enter>.

22. 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 will achieve deviation from nominal. If actual value is required, change in “Gage Model” for “241 Gap (L1)” the “Zero Check (Flush)” to 3. In “LMI\Torque Extensions” change for “241 Gap (L1)” “Direction” to Forward.

*** To accept flush and gap readings at the same time, the part file must be set up with the “Auto Read” function activated. See pages 9-25 of the “Zipper PC Tools” manual for details on how to edit a part for the “Zipper”.