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Research, Development and Manufacturing of Precision Measuring Systems

GAGE SETUP AND CALIBRATION INSTRUCTIONS FOR THE LMI 238-S WITH THE GAGETALKER "ZIPPER"

REQUIRED EQUIPMENT FROM GAGETALKER: Gagetalker "Zipper"

Docking Station set up to a computer

PC Tools (software)

REQUIRED EQUIPMENT FROM LMI: LMI 238-S Quick attach door seal gap transducer

LMI 6009 4 pin to 4 pin cable

GAGE SETUP:

1. From the program "Zipper Administration", verify setup as follows for LMI 238-S

2. Select the "Gages" tab.

3. In Gages, select the "Gage Model" tab.

4. Configure the "Gage Model" screen as follows:

    ➢ Gage Model Name: 238 (L1)

    ➢ Gage Type: LMI/Torque

    ➢ Calibration Method: 200: Min; Max; Zero

    ➢ Zero Check Method: 200: Zero check

    ➢ Zero Check (Flush):   10*

    ➢ Secondary (Gap) Zero: 0

    ➢ 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, press the "+" button and configure as follows:

    ➢ Gage Model Name: 238 (L1)

    ➢ Extension Name: (anything to identify this configuration, suggest "Standard" or "Nor")

    ➢ Mode: Force

    ➢ Starting Threshold: 0

    ➢ Stopping Threshold: 0

    ➢ Direction: Forward

    ➢ Speed: 125 Hz

    ➢ Time Filter: 0

    ➢ Offset: Primary (Flush)

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

8. 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.

9. After the part file is sent to the Zipper remove the Zipper from the docking station, "press any key to start".

10. Select the desired part file for collecting data.

11. Connect the LMI 238-S to port "LMI 1" using the LMI 6009.

12. "Select a Gage" will appear for L1. Press ▲ or ▼ to select "L1:238 (L1)" and press <Enter>.

13. Retract the LMI 238-S at the "Set 238 (L1) at Lo, take reading" prompt, and press <Enter>.

14. Extend the LMI 238-S at the "Set 238 (L1) at Hi, take reading" prompt, and press <Enter>.

15. Place the LMI 238-S on a flat surface at the "Set 238 (L1) at Zero ,take reading" prompt, and press <Enter>.

16. Calibration is complete.

* This sets the base for the range for the transducer. Verify the range of the 238 by looking at the front of the transducer, a range should be visible. If the 238 has a 9.0 - 19.0 range, the "Zero Check (Flush)" needs to be 9.