



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

Research, Development and Manufacturing of Precision Measuring Systems

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**CALIBRATION/ MASTERING INSTRUCTIONS FOR THE LMI 200-SF  
TO INTERFACE WITH LMI 440**

**REQUIRED EQUIPMENT:**

- LMI 200-SF Transducer
- LMI 214 Master block
- LMI 6009 4 pin – 4 pin cable
- LMI 440

1. Connect the transducer to Gage Port 4 of the data collector.
2. Press Menu to turn on.
3. Move the cursor to “Gage”.
4. Press Enter.
5. From the list displayed use the arrow keys on the data collector to choose which gage designation to configure, (i.e., G4, G4A) and press “Enter”.
6. Type the unique gage name, (i.e.: LMI-PROBE) and press “Enter”.
7. Move the cursor to “Configure” and set up as follows:
  - Type: Read at Enter
  - Master Type: (Three point)
  - Scale: 22
  - Zero Master: 0
  - Zero at Enter: (No)
8. Move the cursor to ‘Master’.
9. Place the transducer into the top or “Lo” step of LMI 214 Master Block.
10. Place the transducer into the bottom or “Hi” step of the LMI 214 Master Block.
11. Position the transducer into the calibration block’s center or Master. Select “Master Zero” and press “Enter”.
12. The Calibration/ Mastering for the LMI 200-SF Series is now complete.

**NOTES:**

- \* The current configuration produces a positive reading when retracted beyond the nominal. To reverse the signs change the scale value in the configuration screen to - 22.00.
  - To reverse the sign for a single check point, input – G4, or – G4a at the source code, in the part file. Refer to the 440 and/or the 441 manual for detailed instructions.
- \*\* To verify calibration and mastering use the LMI 214 Master block and the LMI200-SF in either the test gages or master gages screen.