

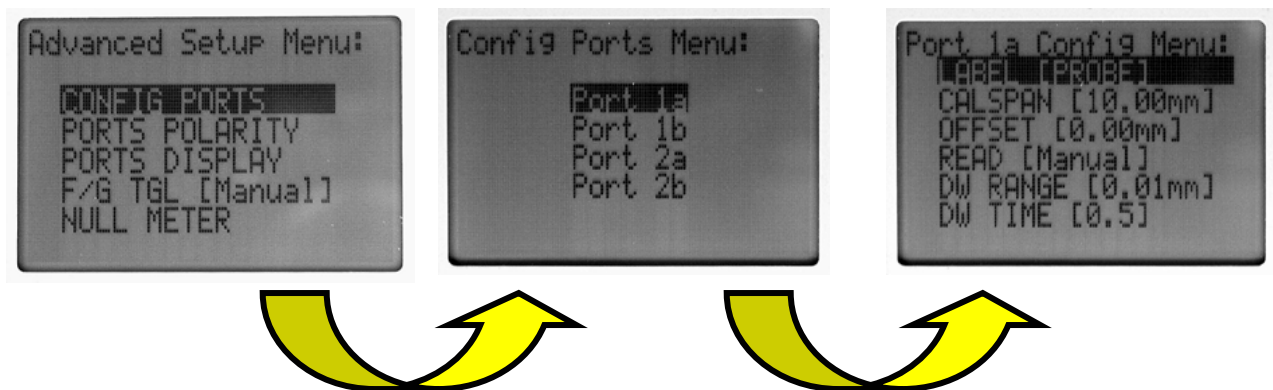
Calibrating the 237 series Seal Gap Gage to the LMI 585 “Plus”

Prior to starting calibration, make sure your gage is connected to the Gage Port #1 on the 585 “Plus” using a 6009 cable. A flat surface is required to properly master a 237. The steps below will guide you through the calibration procedure with pictures of the 585 “Plus” LCD screen.

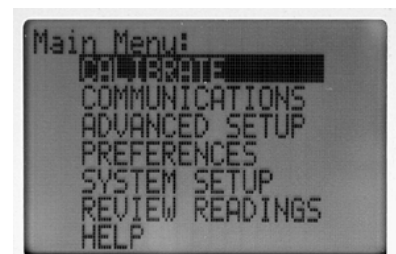
NOTE:

- 1) Under the ADVANCED SETUP/CONFIG PORTS menu, the CALSPAN of Port 1a should be set to 10.00mm
- 2) Be sure to put in the proper offset by going to “ADVANCED SETUP” / “CONFIG PORTS” / “Port 1a”. Select <OFFSET>. Using the arrow keys, scroll up or down to set to 10.000**. This is the typical offset for the 237 “minimum gap check”.

** To obtain the 237 offset, be sure to always look at the front of the 237 and use the smaller of the two numbers located there.

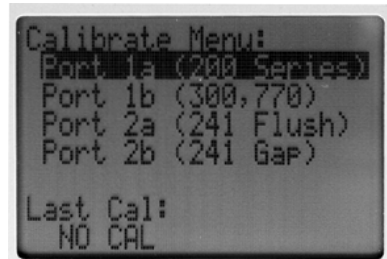


- Press <MENU> to enter the main menu
- “Calibrate” should already be highlighted like the figure below. Press <SELECT> or ►

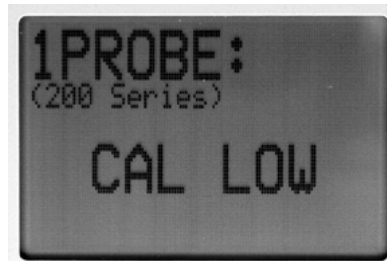


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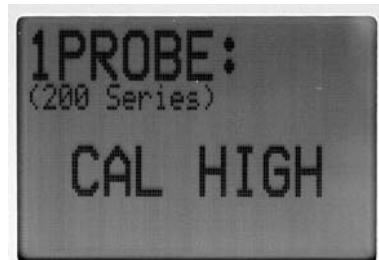
- Highlight Port 1a then press <SELECT>



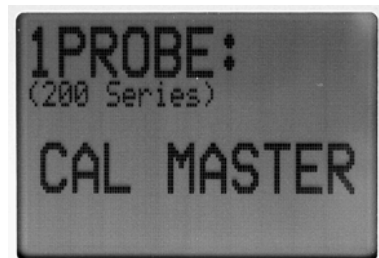
- CAL LOW will be displayed on the screen. Fully “Retract” the gage tip and press <SELECT>



- The screen will then toggle to CAL HIGH. Fully “Extend” the gage tip and press <SELECT>



- The screen will then toggle to CAL MASTER. Place the gage upside down on a certified flat surface (e.g. 3030 Master block) and press <SELECT>



- Calibration is complete and the screen takes you back to the “Calibrate Menu” screen. To exit and view your readings, press <SEND>.

- You should be able to view your readings on the screen labeled 1PROBE. Use the ► or ◀ to toggle between three gage screens if 1PROBE is not shown. The screen below shows 1PROBE with a gage reading of 0.70mm.

