

LINEAR MEASUREMENT INSTRUMENTS, Corp.

Research, Development and Manufacturing of Precision Measuring Systems

Mastering Instructions for the LMI 241-BWV2 or 241-FG to the LMI 585 Plus



NOTE

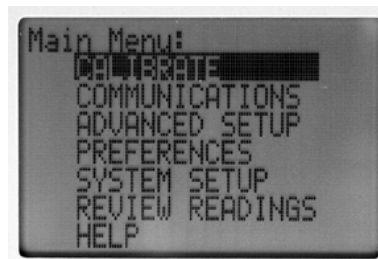
These instructions are copied from the LMI 585 *Plus* User Guide and are intended to be used as a quick reference for the mastering process. Please refer to the LMI 585 *Plus* User Guide for the setup and configuration of the LMI gages in the 585 *Plus*.

Prior to starting calibration, make sure your 241 flush/gap gage is connected to the Gage Port #2 on the 585 Plus using a 6025 cable.

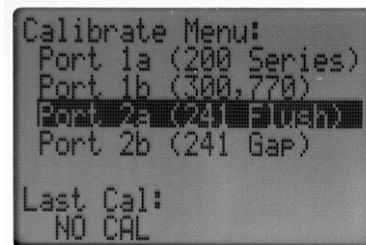


Under the ADVANCED SETUP>PORT CONFIG menu the CALSPAN of Port 2a & 2b should be set to 10.00mm

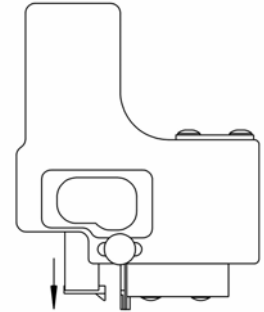
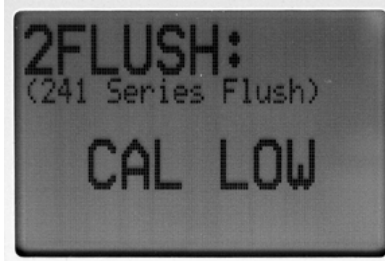
- Press <MENU> to enter the main menu
- “Calibrate” should already be highlighted like the figure below, press <SELECT> or ►



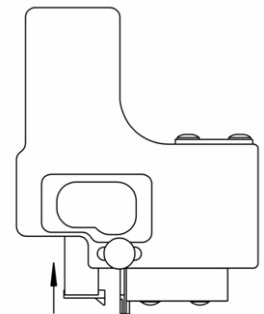
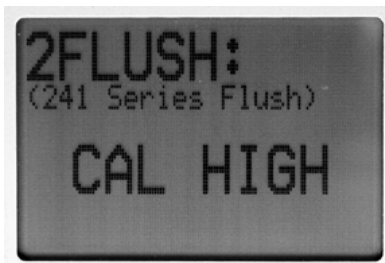
- Highlight Port 2a and press <SELECT>



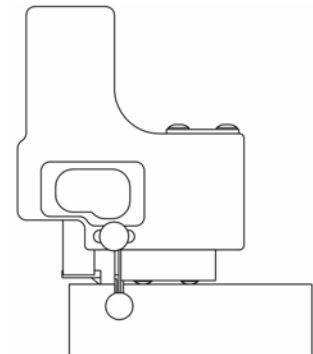
- CAL LOW will be displayed on the screen. Fully extend the flush tip and press <SELECT>



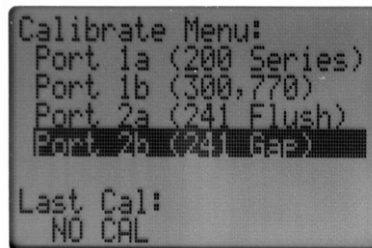
- The screen will toggle to CAL HIGH. Retract the flush tip to its fully retracted position and press <SELECT>



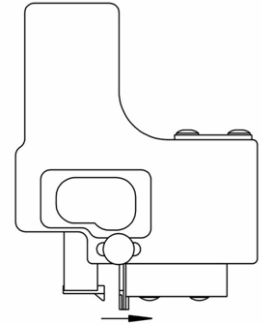
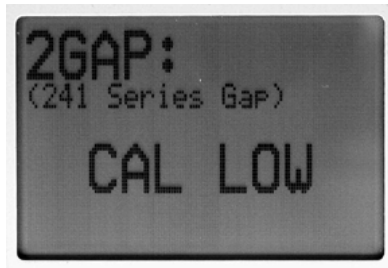
- The screen will then toggle to CAL MASTER. Place the gage in the Master Block and press <SELECT>



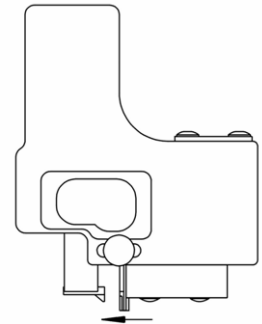
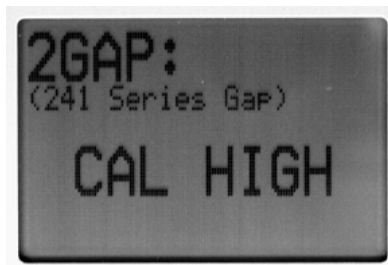
- Flush calibration for port 2 is now complete and you are taken back to the "Calibrate Menu" screen. Highlight Port 2b, press <SELECT>



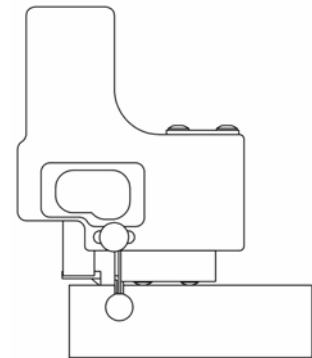
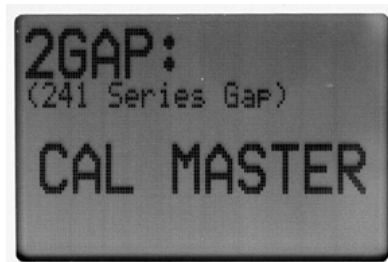
- CAL LOW will be displayed on the screen. Fully retract the gap peg and press <SELECT>



- The screen will toggle to CAL HIGH. Extend the gap peg to its fully extended position and press <SELECT>

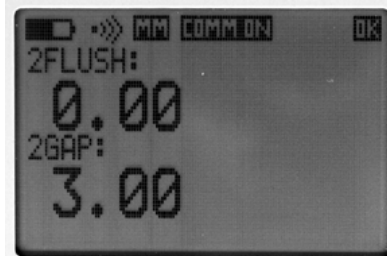


- The screen will toggle to CAL MASTER. Place the gage in the Master Block and press <SELECT>



- Gap calibration for port 2 is now complete and you are taken back to the "Calibrate Menu" screen. Press <SEND> to exit and view your readings.

- You should be able to view your readings on the screen labeled 2FLUSH over 2GAP. Use the ► or ◀ to toggle between the three gage screens if the two readings are not shown simultaneously (if the “AUTOSEL” is on, you will only view two screens). The screen below shows 2FLUSH with a gage reading of 0.00mm and the 2GAP reading of 3.00mm. Insert the gage back into the Master Block to verify the master points.



- To reverse the signs, go to the main menu. Go to Advanced setups and hit <SELECT>. Go to Ports Polarity. Press <SELECT>. Choose the port you are using and press <SELECT>...the port readings will change to “Inverted”

