

Configuration and Mastering Instruction for the Fishmouth Latch to Striker Measurement Gauges to the LMI 440 or ASI DataMyte 501



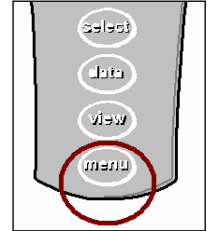
This process will outline

<u>Section</u>		<u>Pages</u>
I.	Configuration of the LMI 440 or ASI DataMyte 501	2-4
II.	Mastering the Fishmouth to Striker Adaptor	4-5
III.	How to properly use the Master Block.	6-7

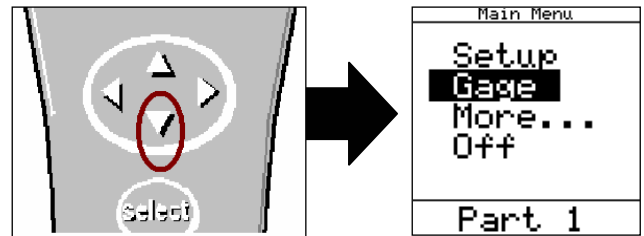
I. GAGE CONFIGURATION

Section I is a one time setup. After a successful gage configuration is finished there should be no need to repeat section I. It is recommended to store a copy of the gage files onto a personal computer or laptop. Consult the collector manual or if purchased the TransSend manual for further details.

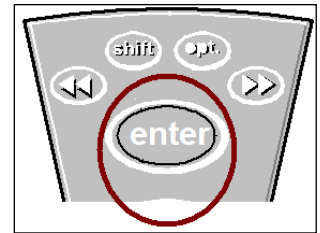
1. Press <menu> to turn on the collector.



2. Press ▼ to highlight “Gage”.

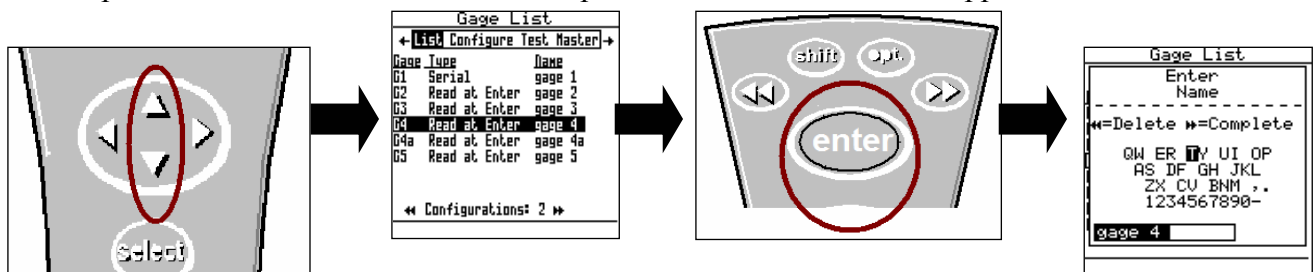


3. Press <enter>.



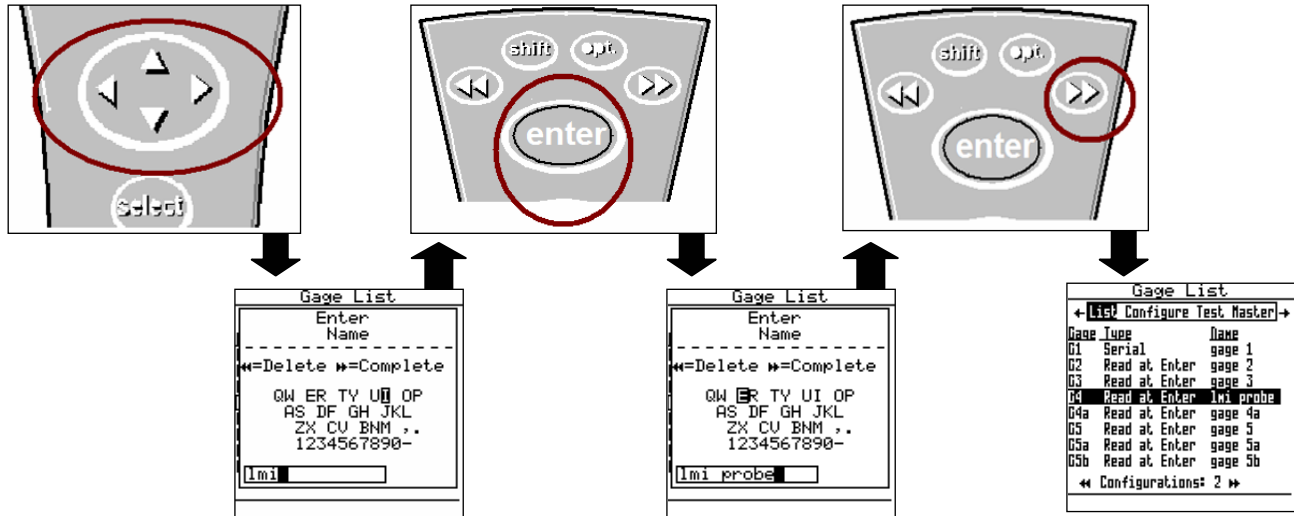
It is recommended to assign simple user name to the gage files such as; RH, LH, etc. This will help to identify different setups.

4. To assign a gage file name press the ▲ or ▼ to highlight gage “G4”* in the “Gage List”, and press <enter> on the collector. The alphanumeric screen will then appear.

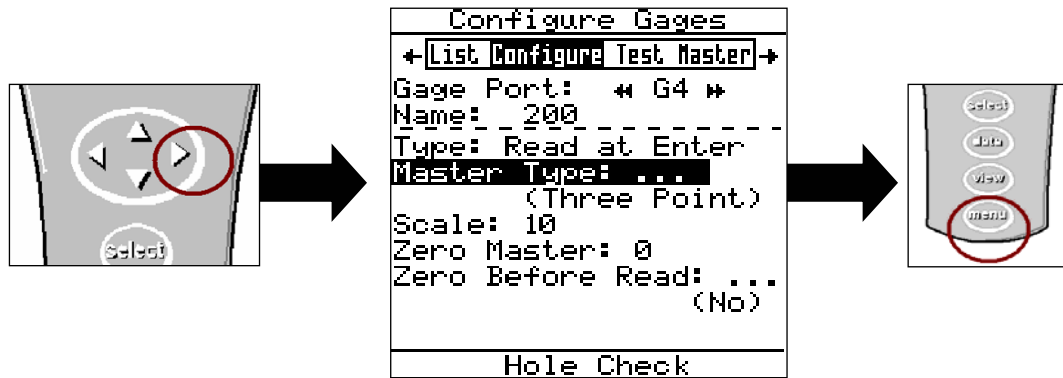


*G4 and G5 can both read the adaptor. The only rule to follow is the gage file must match the source code in part file, see collector manual for details. The balance of this instruction will be based on G4. To use G5, perform the following steps using the G5 gage file.

- Use the ▲, ►, ◀, or ▼ to highlight the desired character then press <enter>, repeat process until the gage file name is spelled out then press ►► to accept the new name.

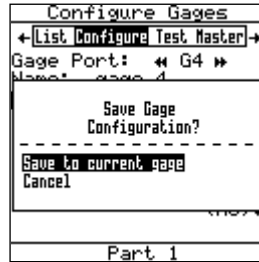


- Press the ► to “Configure”. By default the screen should read as follows. This screen determines how the collector will interpret the signal from the gage. Failure to set this screen properly may cause undesired results. If **no** changes to the screen are required, configuration is complete and press the <menu> key. If changes are required continue to step 7.



- If changes in this screen are needed, press the ▲ or ▼ to highlight the different selections then press <enter> to toggle through the choices of “Type”, “Master Type”, and “Zero Before Read”.
- To make changes to the “Scale” or “Zero Master” press ▲ or ▼ to highlight “Scale” or “Zero Master” and press <enter>. This will bring up the numeric keypad. Key in the new value and press ►► to accept.

9. Press the <menu> key to return to the “Main Menu”. If any changes were made in the “Gage Configuration” screen a save gage notification will appear. If the changes are intentional highlight “Save to current gage” and press <enter>. If changes are not intended, highlight “Cancel” and press <enter> and reset “Configure Gages” per step 6.



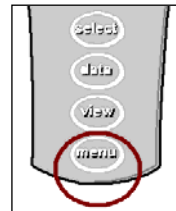
Gage configuration is complete.

II. MASTERING INSTRUCTIONS

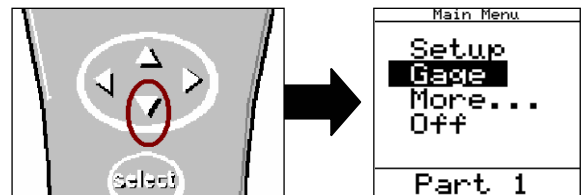
LMI suggests that this process be performed at the start of every shift.

1. Connect the transducer to Gage Port 4 of the data collector. If G5 was selected in gage configuration use Gage Port 5.

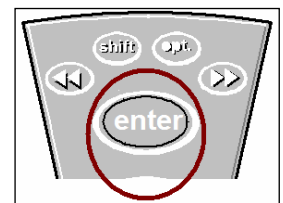
2. Press <Menu> to turn on the DATAMYTE 501.



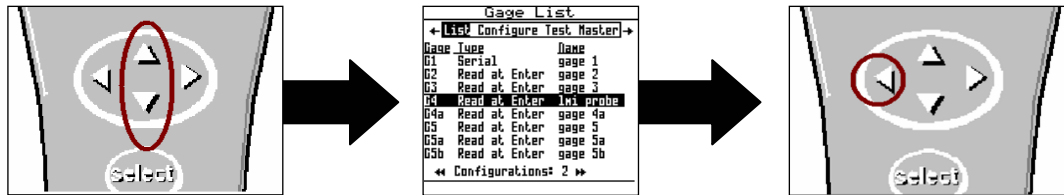
3. Press ▼ to highlight “Gage”.



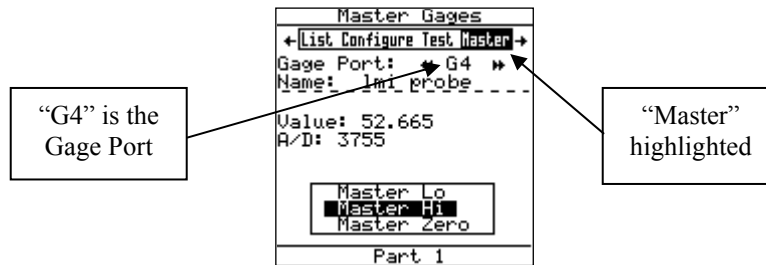
4. Press <enter>.



- 5 From the gage list use the ▲ or ▼ keys on the data collector to choose gage file G4, and press ◀ on the collector.



- 6 “Master” will be highlighted in screen header and “G4” is identified as “Gage Port”. If G4 is not the Gage Port press the ▶▶ or ◀◀ until G4 appears.



- 7 Move the “V-shaped striker pickup” of the Adaptor all the way to one end of the travel and hold. Verify “Master Lo” is highlighted on the collector, press <enter>.
- 8 Move the “V-shaped striker pickup” of the Adaptor all the way to the opposite end of the travel and hold. Verify “Master Hi” is highlighted on the collector, press <enter>.
- 9 Position the transducer into the Master Block. Verify “Master Zero” is highlighted on the collector, press <enter>.
- To correctly place the Adaptor into the Master Block, see Section III

Calibration/ Mastering for the Measurement Adaptor is now complete.

III. Placing the Adaptor in and out of the Master Block

1. Start the alignment contour of the master into the mating gauge. (See photos)
 - Slide the components together until the taper pin at the top of the master gets close to the V-shaped striker pick-up slide.



2. Slide the striker pick-up slide over enough to allow the taper pin to engage the slide.



3. Continue sliding the pieces together until the taper pin stops in the “V” of the slide.
 - Do not apply pressure once the parts make contact.
 - This will lock up the intricately matched details.



4. When the mastering steps have been completed slide the components apart.
- Once again as the pieces are intricately matched to a very close tolerance any misalignment can lock the pieces together. So use light force when pulling them apart.
 - See photos below for finger placement to un-mate the pieces.

