Calibration of the inner SAPE gauge arm and the AutoStopSystem	C80

Options : None
Special function : ASS, Auto Stop System not to be done if IBP version

Description

The calibration positions and the associated voltages may depend on brand and model, therefore we give here only a general specification of operations. For specific positions please refer to the table further below.

1D SAPE:

Step 1 : Move gauge arm to calibration position 1 and adjust extraction potentiometer mechanically. Press acknowledge key to confirm step 1.
Step 2: Move gauge arm to calibration position 2. Press acknowledge key to confirm step 2.

2D SAPE:

Step 1: Move gauge arm to calibration position 1 and adjust the potentiometers mechanically (The voltage of the diameter potentiometer is indicated in the left 3-digit display). (The voltage of the distance potentiometer is indicated in the right 3-digit display).
Step 2: Move gauge arm to calibration position 2: Press acknowledge key to confirm step 2.
Step 3: Move gauge head to calibration position 4. Press acknowledge key to confirm step 4.
Step 4: Move gauge head to calibration position 5. Press acknowledge key to confirm step 5.

If ASS is available and Kernel (BK) is previous than 2.0, continue calibration as stated below.
Note: For BK 2.x or higher, ASS Calibration is NOT PRESENT. Calibration is completed at Step 4.

GEODATA:

Step 1: Move gauge arm to calibration position 1 and adjust potentiometers mechanically
(The voltage of the diameter potentiometer is indicated in the left 3-digit display
The voltage of the distance potentiometer is indicated in the right 3-digit display)
Re-place gauge arm in home position (if necessary fit the weight box).
Press acknowledge key to confirm step 1.
Step 2: Move gauge arm to calibration position 2. Press acknowledge key to confirm step 2.
Step 3: Move gauge head to calibration position 3 (notch in vibratory system).
Press acknowledge key to confirm step 3.
Step 4: Move gauge head to calibration position 4 (with calibration bar).
Press acknowledge key to confirm step 4.

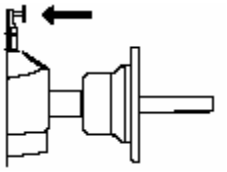
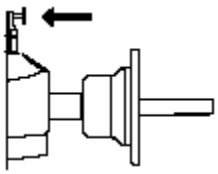
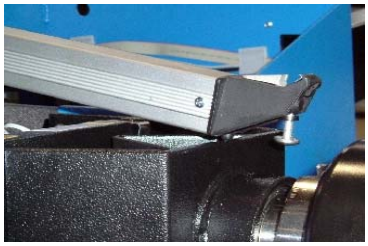
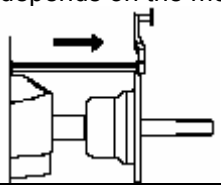
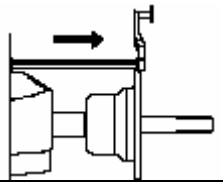
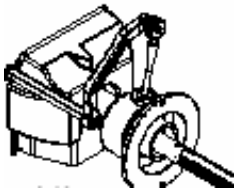
Continue with ASS calibration as stated below.

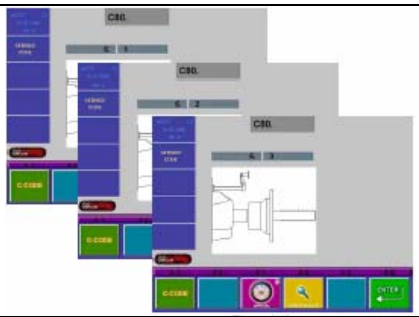
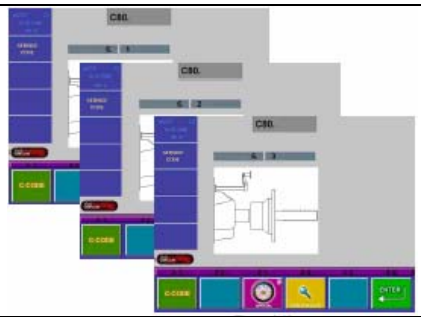
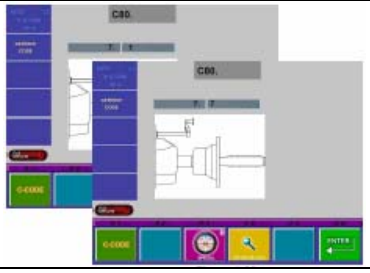
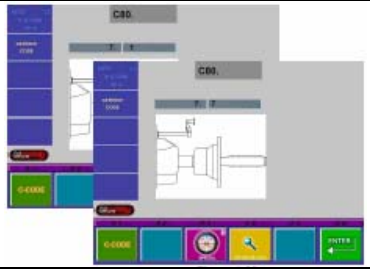
ASS calibration:

Step 5: No function, just skip
Step 6: At first reads out 0 on right display.
Slowly extend gauge arm until the AutoStopSystem brake responds.
Maintain the gauge arm until the brake cuts off.
Re-place the gauge arm in home position.
The reading in the right display is increased by 1.
If the brake does not respond, the gauge arm was moved too fast.
After a third repetition the left display changes to step 7.
Step 7: At first reads out 0 on right display.
Quickly extend gauge arm at constant speed until the AutoStopSystem brake responds.
Maintain the gauge arm until the brake cuts off.
Re-place the gauge arm in home position.
The reading in the right display is increased by 1.
If the brake does not respond, the gauge arm was moved too fast, or too slowly.
After the sixth repetition calibration is completed and the service mode is quit.

Comments

The calibration data can be saved in the permanent memory using C90 code.

CAL STEP	1D SAPE	2D SAPE	GEODATA
1	Gauge arm fully returned to home position. The reading for **distance sape** must be: • 3.99 – 4.01V for Y2K • 2.92 – 2.93V for IBP 	Gauge arm fully returned to home position. The reading for **– distance sape** must be: • 4.25 – 4.30V for Y2K • 3.11 – 3.15V for IBP **– diameter sape** must be: • 3.55 – 3.60V for Y2K • 2.60 – 2.63V for IBP 	Halfcone tip under gauge head applied to calibration groove in vibratory system. The reading must be: • 0.15 – 0.20V for Y2K • 0.10 – 0.14V for IBP  Gauge arm fully returned to home position. The reading must be: • 0.15 – 0.20V for Y2K • 0.10 – 0.14V for IBP 
2	Gauge arm extended to max extension. This depends on the model. 	Gauge arm extended to max extension. This depends on the model. 	Gauge arm extended to 300mm. The reading must be: • 4.15 – 4.20V for Y2K • 3.04 – 3.0V7 for IBP 
3		Position 1 of calibration template, or head of calibration weight 	Reference notch in vibratory system 
4		Position 2 of calibration template, or tip (screw) of calibration weight 	Using calibration bar 
5		No function. Just skip	No function. Just skip

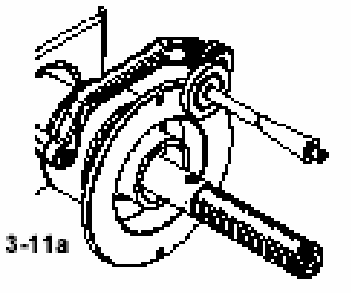
7			
8			

Measuring the adaptor flange and the zero plane	C81

Options : None
Special function : None

Description

To keep the machine operative and to allow width measurement in case the gauge arm is defective, the distance SAPE will be calibrated relative to the clamping surface of the adaptor on the condition that the gauge arm has already been calibrated. Having applied the gauge arm to the outer edge of the adaptor flange, press the Acknowledgment key to acknowledge the input. No further inputs are necessary.





Comments

The calibration data can be saved in the permanent memory using code C90.