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Free Length Probe Calibration

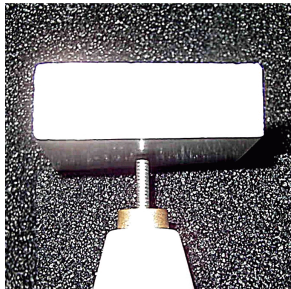
PRELIMINARY INSPECTION

- Remove all foreign materials such as dirt, grit, oil, paint, etc. that might impair the accuracy and operability during the calibration process.
- Carefully inspect for damage due to wear or improper handling. If no excessive wear or damage is present, proceed to next step.
- Correct any visual or mechanical damage prior to calibration process.

EQUIPMENT REQUIRED

- Moyer Free Length Gage Box (Mean Machine, Eurogages, Merlin)
- Printer and Moyer printer cable
- Moyer Temperature Stabilized Probe with 1/8" probe tip
- Probe Holder
- Simulated Read switch

CALIBRATION PROCESS

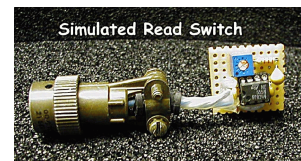


Using the probe holder, target the 1/8" probe tip against a flat spot on the coiler to simulate a spring. Make sure the tip is flush on the spot. Back the micrometer out .065" as the standoff distance.

Configure the gage for MSC at 30 seconds and SPC at 3 minutes.

Set the gage as if for normal production using a tolerance of +/- .010".

Plug the simulated read switch in place of the regular read switch. This switch will signal the gage to take readings while the coiler is not running. Place the gage in the run mode.



Start the MSC study. After this has been completed. The gage will automatically generate the SPC study. Continue the study for one MSC and two SPC charts (appx 2hrs and 10 min).

36 data should stay within +/- .001" for newer equipment and +/- .002" for older equipment.