
Special Probe Setup for Short Springs: (works with most gages)

- (1) Set up the probe as you normally would, using recommended procedures as described in your user manual. This would include "Zero"ing the probe and setting the "Long" and "Short" set points.
- (2) Cut off the spring and Re-zero the probe without a spring present.
- (3) Turn the micrometer in like you were going to re-set the Long set point. Note (record) the displacement as indicated by the display or meter. Do the same in the other direction for the Short set point. Again, note the displacement.
- (4) Now, coil out a spring, and set up the probe as you normally would again, except, turn the micrometer the tolerance less the amounts indicated in step 3. This accounts for the effects the machine has on the setup procedure. It's not perfect, but is easy to follow and quite close.

----- Example -----

Lets, for example, say we are setting up a 0.129" +/-0.006" long spring on a small coiler:

- (1) First coil out a spring and set the probe in front of it with a properly sized probe tip.
- (2) Zero the probe.
- (3) Turn the probe in (CW) 0.006" and set the Long sort point. Return the probe out (CCW) 0.006" to Zero.
- (4) Turn the probe out (CCW) 0.006" and set the Short sort point. Return the probe in (CW) 0.006" to Zero.
- (5) Cut off the spring and rezero the probe.
- (6) Turn the probe in (CW) 0.006" and write down the displayed value. Lets say it's 0.0015". Return the probe out (CCW) 0.006" to Zero.
- (7) Turn the probe out (CCW) 0.006" and writh down the displayed value. Lets say it's -0.0008". Return the probe in (CW) 0.006" to Zero.
- (8) Again, coil out a spring and rezero the probe.
- (9) Turn the probe in (CW) 0.0045" (0.006"- 0.0015") and set the Long sort point. Return the probe out (CCW) 0.0045" to Zero.
- (10) Turn the probe out (CCW) 0.0052" (0.006"- 0.0008") and set the Short sort point. Return the probe in (CW) 0.0052" to Zero.
- (11) Cut off the spring, measure the spring, and correct the probe position to compensate for the difference between the actual length and the desired length.
- (12) Place the gage in run mode and start coiling. Catch some springs, noting the length on the display, and measure the springs. Adjust the probe as needed to correct for error (if any).

I hope this helps. If you have any questions or comments, please feel free to call one of us at MOYER.