



Allen Lead Gage Calibration Reference Card



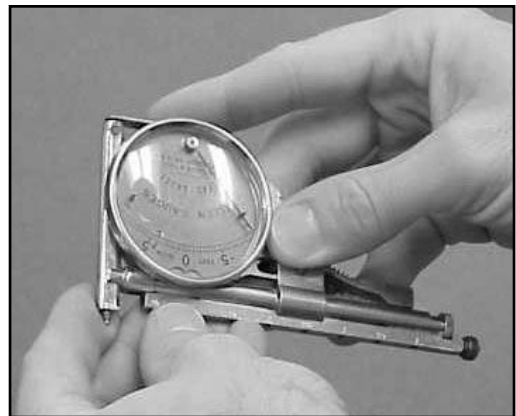
Setup

Materials Needed:

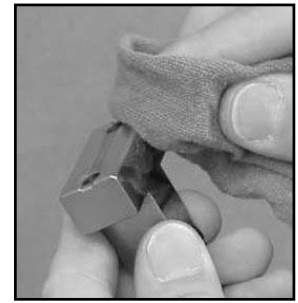
- MIC TRAC MT-3000 base unit
- Allen lead gage
- Allen lead gage fixture (TF-ALG Block) and cap screws
- Flat face anvil (TF-1F Block) and cap screws
- 5/32" hex wrench
- 1/16" hex wrench
- 30 in/lb torque wrench
- Cloth
- ZEP I.D. Red cleaner

1. Inspect the lead gage visually as follows:

- Check for damage and excessive wear.
- Check for clear bezel, legible dial face.
- Inspect for proper function of the bezel adjustment and lock.
- Inspect for missing or loose screws or worn contact point.
- Check for smoothness of travel by depressing the indicator shaft throughout the entire travel range. Any indicators with restricted movement, must be repaired prior to calibration.



2. Clean both of the receiver pads and mounting surfaces of the flat face anvil using the cloth and ZEP I.D. Red cleaner.



3. Place the shoulder side of the flat face anvil against the left receiver pad shoulder.



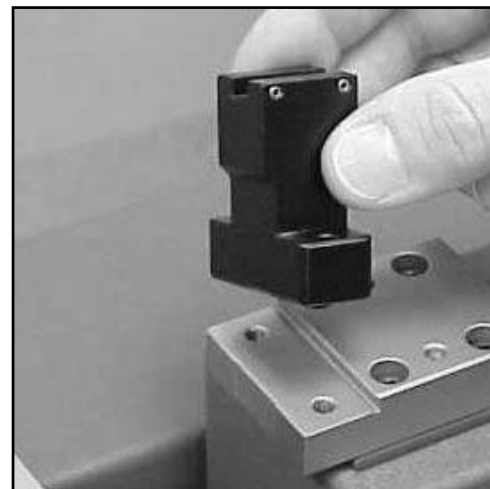
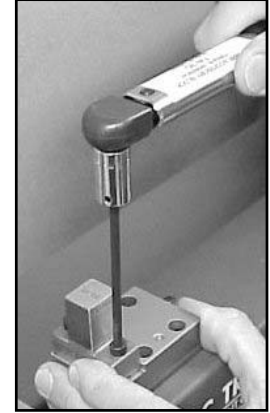
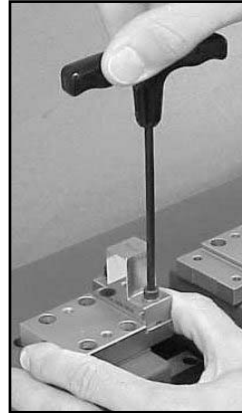


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4. While holding the anvil against the receiver pad shoulder, insert the two cap screws into the holes on either side of the anvil.
5. While applying pressure toward the receiver pad shoulder, use a 5/32" hex wrench to slightly tighten the screws.
6. Use a 30 in/lbs torque wrench to secure the cap screws.
7. Clean the mounting surfaces of the Allen lead gage fixture using the cloth and ZEP I.D. Red cleaner.
8. Place the Allen lead gage fixture against the right receiver pad shoulder.



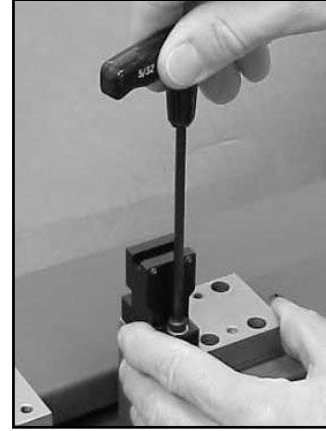


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9. Insert the two cap screws into the holes on either side of the Allen lead gage fixture.
10. While applying pressure toward the receiver pad shoulder, use a 5/32" hex wrench to tighten the screws.
11. Turn the coarse adjust knob clockwise until the Allen lead gage fixture is within 1" of the flat face anvil.
12. Clean the Allen lead gage using the cloth and ZEP I.D. Red cleaner.



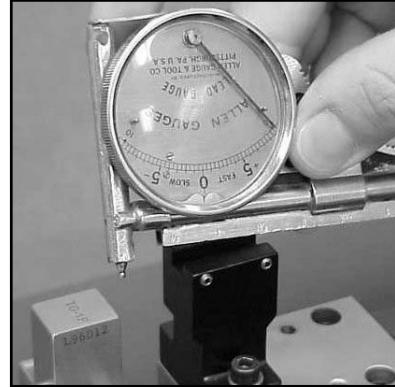


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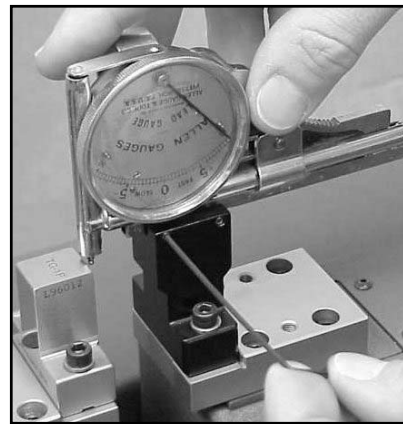


Setup

13. Insert the Allen lead gage into the slot in the top of the Allen lead gage fixture. Position the contact point on the Allen gage on the inside of the flat face anvil.



14. Secure the Allen lead gage in the slot by tightening the set screws on the side of the fixture with a 1/16" hex wrench.



15. Turn the coarse adjust knob clockwise until the indicator needle aligns with zero.





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Setup

16. Secure the coarse adjust lock.





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Calibration

Materials Needed:

- MIC TRAC MT-3000 base unit and CPU readout
- Seiko printer (optional)
- Allen lead gage
- 5/32" hex wrench
- Lightweight gage oil
- Gage Calibration Record

1. Turn the fine adjust knob clockwise to align the gage indicator needle with zero.

2. Secure the fine adjust lock.

3. On the front panel of the CPU, press the INT (internal measurement) pad.

4. Press the ZERO pad on the CPU panel twice. The readout displays 0.00000.





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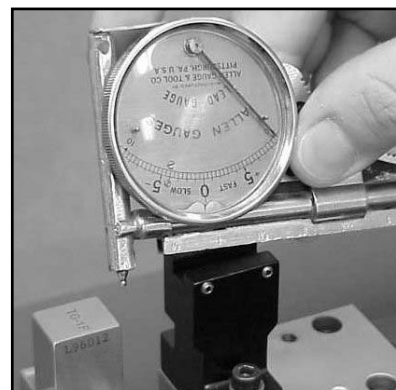
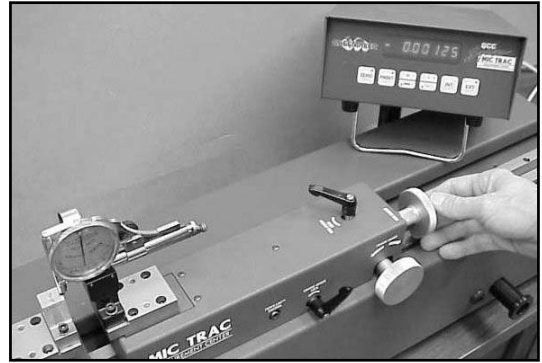


Calibration

5. Turn the fine adjust knob clockwise until the Allen lead gage indicator reads the first calibration value.

Note: If you pass the calibration value, turn the needle back and approach the value again, from the same direction. This practice will increase the accuracy of the calibration.

6. If you have a Seiko Printer attached to your MIC TRAC for printing a permanent record of calibration measurements, press the PRINT pad on the CPU panel.
7. Record any deviations on the Gage Calibration Record or in-house calibration report.
8. Continue with the remaining measurements at every .001" until .010". Return the indicator needle to zero, then calibrate the gage moving in the opposite direction.
9. After completing all measurements, remove the Allen lead gage from the MT-3000 and continue with the same calibration process for the next Allen lead gage.





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Calibration

10. After calibrating all Allen lead gages, be sure to remove the flat face anvil and the Allen lead gage fixture from the MT-3000. Oil the fixtures and return them to the storage case.

