

## **CALIBRATION INSTRUCTIONS** **ALL GAUGE MODELS**

Calibrate your gauge every month and after each transfer to a new work location.

Clean all dust and foreign material from the junction of the glass surface and the 2 inch/5 centimeter wide registration bar, and the glass surface and the small squareness block.

Gently place the calibration plate on the photo glass plate so that the bottom edge of the calibration plate rests on the registration bar.

All gauge readings should be made 12 inches/30 millimeters directly above the intersection of the calibration plate and the photo glass plate.

Each gauge has a different and specific calibration plate length, and all have the beveled areas "C", "A", and "B" on them. The beveled areas at letters "A" and "B" are used in establishing dimensional calibration. The beveled area at letter "C" is used to establish squareness calibration, and it's value is 0.00, as this represents perfect squareness or 90 degrees.

For the beveled areas "A" and "B", the length of the calibration plates are as follows:

Model F is 17.000 inches  
Model G is 27.000 inches  
Model L is 540.00 centimeters  
Model K is 740.00 centimeters

To calibrate the dimensional measurement function of your gauge, place the calibration plate on the gauge so that the area "B" on the calibration plate is situated on the far side of the gauge with the bottom of the calibration plate up against the registration bar, and the area "B" corresponding with the appropriate dimensional number on the gauge itself. Repeat this for "A" on the near side of the gauge.

If the above steps indicate that an adjustment is required, loosen the five socket head bolts securing the registration bar ONE HALF TURN - NO MORE! Adjust the registration bar so that the "A" and "B" areas on the calibration plate cross through their appropriate dimensional increment on the glass plate. Tighten bolts securely in sequence 3, 1, 5, 2, 4 (far left is 1, far right is 5). Recheck to verify correct calibration.

Squareness Calibration - Models E825, N, F, L, G, K

Calibrate the squareness block function on your gauge as follows: Position the calibration plate so the base rests against the registration bar and the lower left edge rests against the right side of the squareness block. The beveled area "C" should read 0.0 along the squareness scale.

If the above step indicates that an adjustment is required, slightly loosen the two bolts securing the squareness block and reposition the squareness block up against the calibration plate so that the beveled area "C" reads 0.0. Tighten the two bolts securely. Recheck to verify calibration.

Squareness Calibration - Models C-2, D, and M

The Quick Skan Models C-2, D, and M have a fixed calibration. And since the squareness block is securely and exactly positioned at the Quick Skan facility when the "A" and "B" measurements are established, to verify squareness calibration in the field, the squareness beveled area "C" will read 0.0 when the calibration plate is placed up against the squareness block and the registration bar.