

FDR Design, Inc.

303 12th Ave. South phone 612-682-6096
Buffalo, MN 55313 fax 612-682-6197

RSGh Calibration
100% argon
Component Location

Created:
3/24/00

rle

Last Modified:
10/22/00

rle

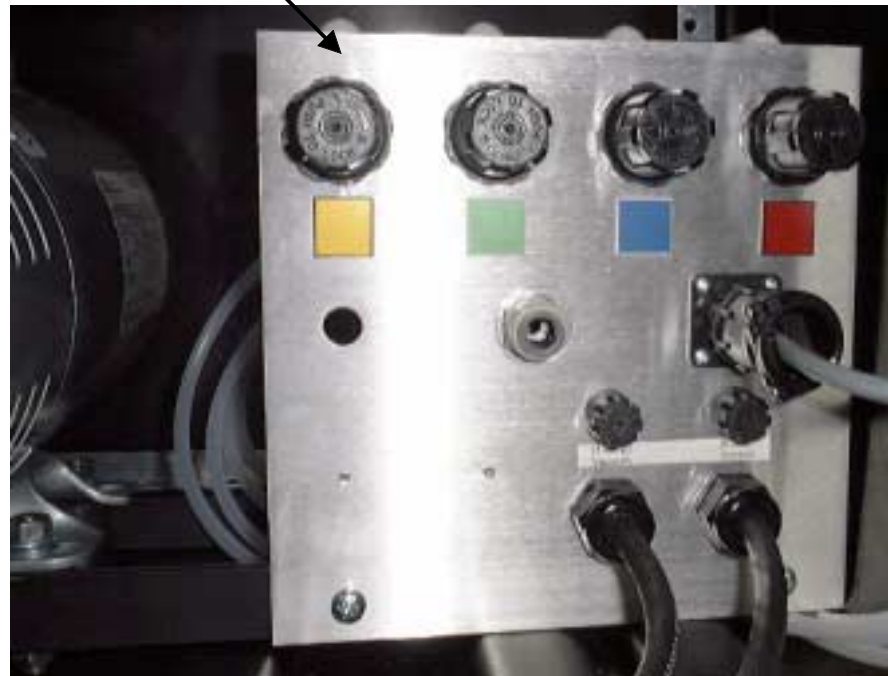
Scale:
na
Sheet 1 of 4
Drawing Number:

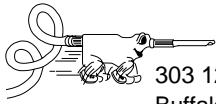
11541-A

Gas Sensor Amplifier Boards

Sensor Override switch turn up or on
to override sensor and keep machine
running.
Turn off when done with calibration

Flow regulators





FDR Design, Inc.

303 12th Ave. South phone 612-682-6096
Buffalo, MN 55313 fax 612-682-6197

**RSGh Calibration
100% argon
Flow Setting**

Created: 3/24/00
Last Modified: 10/22/00

re
re

Scale:
na

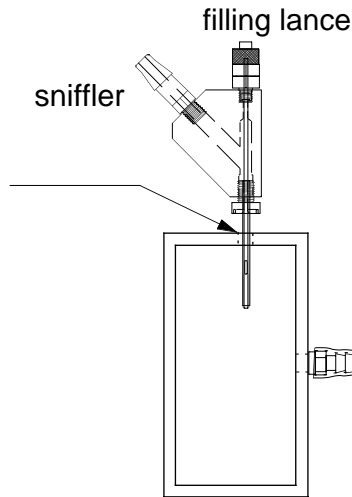
Sheet 2 of 4
Drawing Number:

11541-A

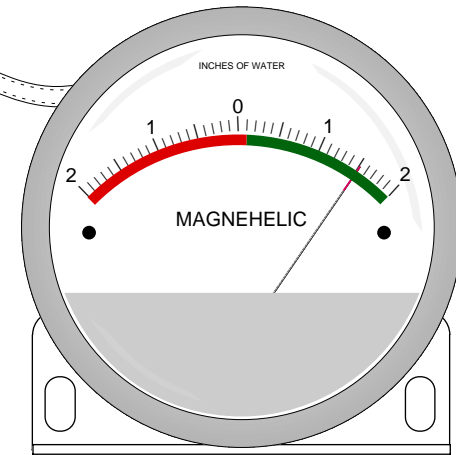
Gas Filler Flow Rate set

Step 1

Drill holes in "can"
the same size and spacing as the
holes in the spacer
Place sniffer/filling lance in can

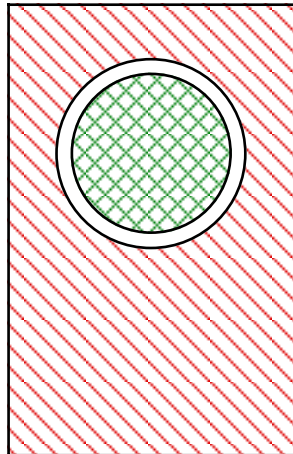


Cavity pressure is between +0.1"
and +2" of water



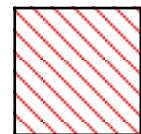
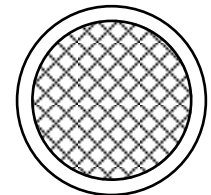
Step 2

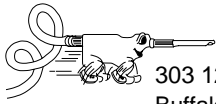
Press and hold cycle start button



Step 3

Adjust flow regulator on back
of machine Each line has it's own
regulator, red, blue, green, yellow





FDR Design, Inc.

303 12th Ave. South phone 612-682-6096
Buffalo, MN 55313 fax 612-682-6197

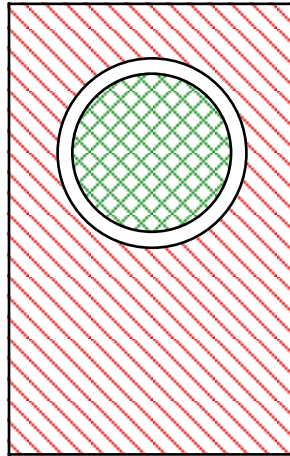
RSGh Calibration
100% argon
Gas Sensor Air Setting

Created: 3/24/00 rle
Last Modified: 10/22/00 rle

Scale: na
Sheet 3 of 4
Drawing Number:
11541-A

Step 2

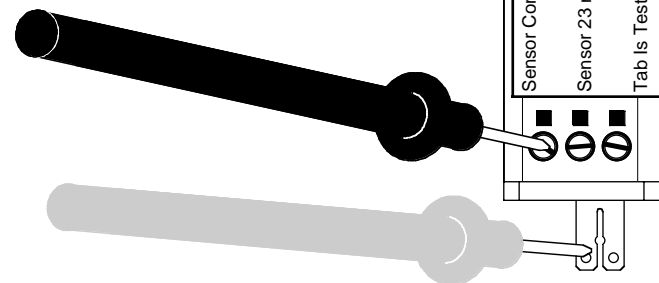
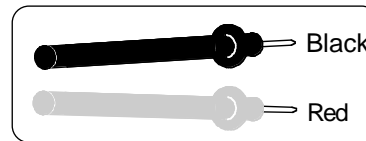
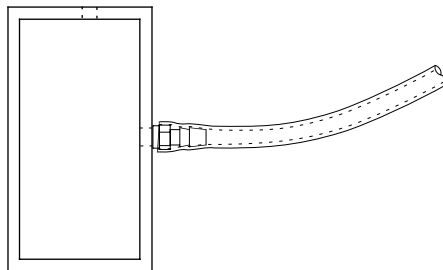
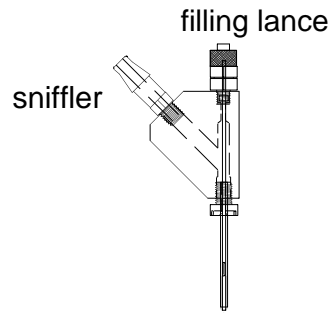
Press cycle start button



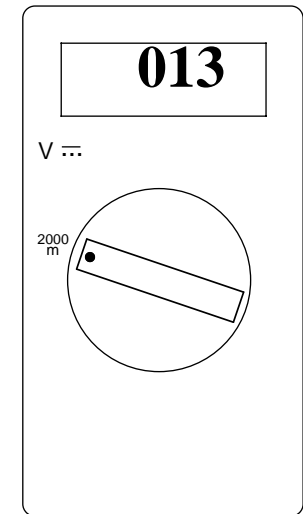
Gas Filler air or zero calibration

Step 1

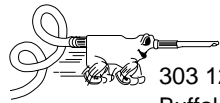
Lance in free air not in test can



Step 3



With lance hanging free in the air adjust zero to 13 mv (0.013 vdc)



FDR Design, Inc.

303 12th Ave. South phone 612-682-6096
Buffalo, MN 55313 fax 612-682-6197

RSGh Calibration
100% argon
Gas Sensor Argon Setting

Created: 3/24/00
Last Modified: 10/22/00

rle
rle

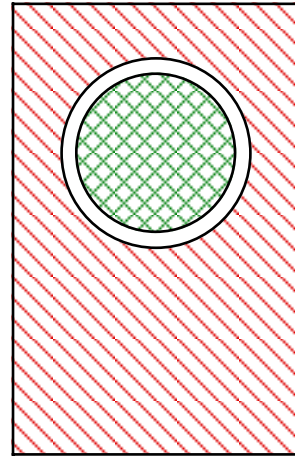
Scale: na

Sheet 4 of 4
Drawing Number:

11541-A

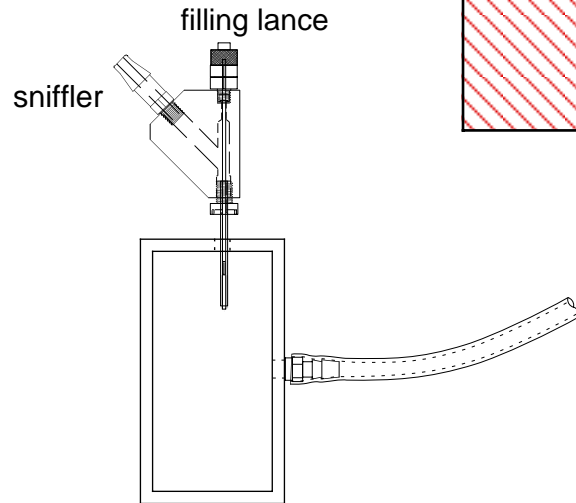
Step 2

Press and hold cycle start button



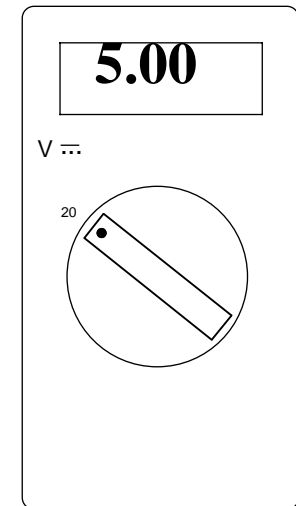
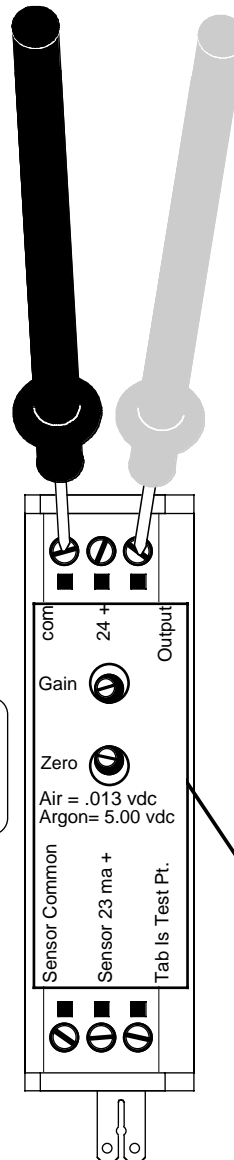
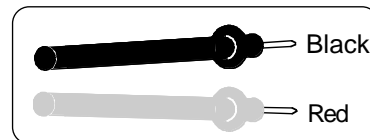
Step 1

Lance in test can



Gas Filler argon or gain calibration

Step 3



With lance in the test can
adjust gain to 5.00 volts dc
hold start button or turn on
sensor o-ride switch