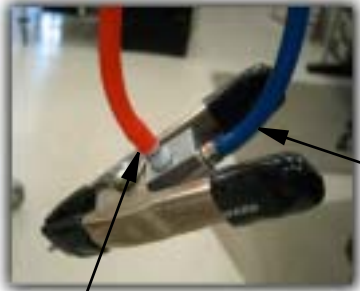


Step 1

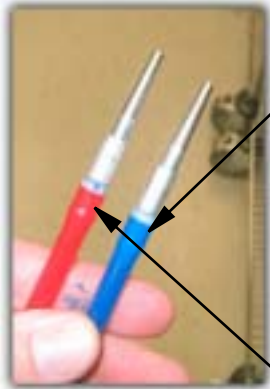
1-hole Clamp in free air



Blue hose (OUT)

Red hose (IN)

2-hole Lances in free air



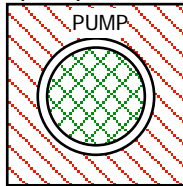
Blue hose (OUT)

Red hose (IN)

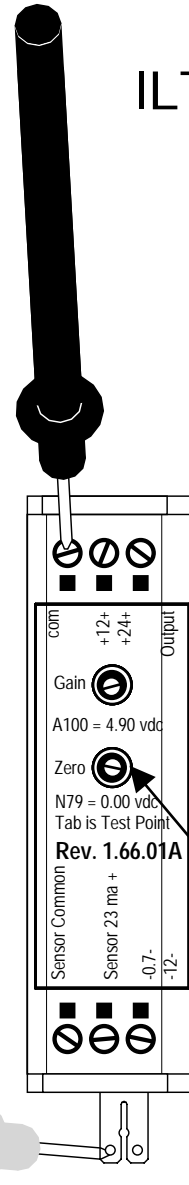
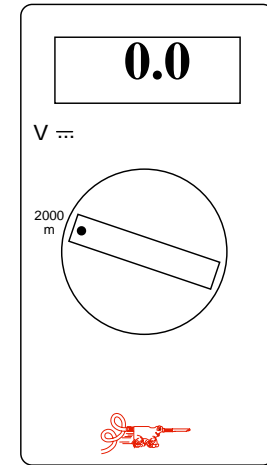
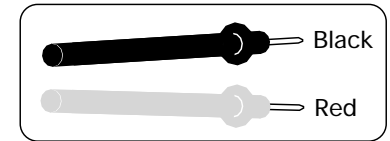
Stage 1 Air
Stage 2 Argon

Step 2

Press and release pump button

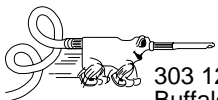


ILT-C Air calibration



Step 3

After running for 3 minutes adjust zero to read 0.4mv to 0.0 mv (0.0004 to 0.0000 volts dc)



FDR Design, Inc.

303 12th Ave. South Buffalo, MN 55313
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ILT-C Setup Calibration
Stage 1 Air

Created: 06/18/04 rle
Last Modified: 06/25/04 CG

Scale: 2/1

Sheet 2 of 7
Drawing Number: 11670-A

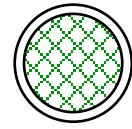
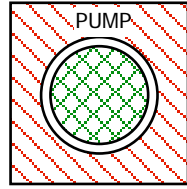
Step 1

1-hole Clamp in calibration port



Step 2

Press and release pump button



Press and release gas button

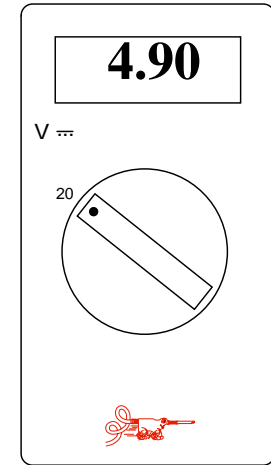
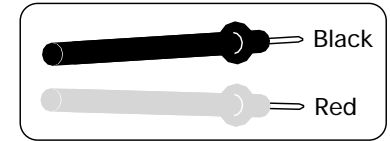
2-hole Red Lance in calibration port

Tight seal



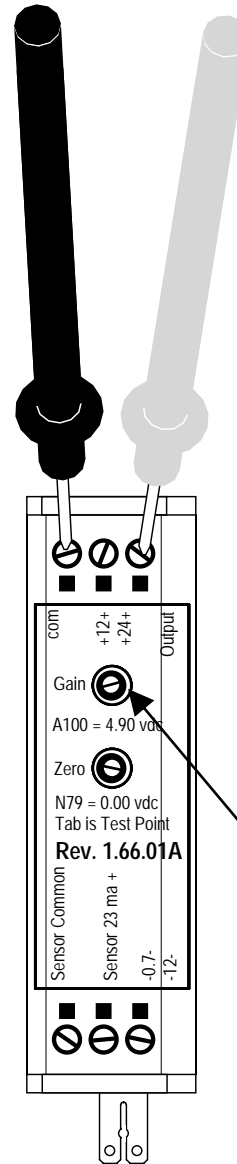
Red hose (IN)

ILT-C Argon calibration



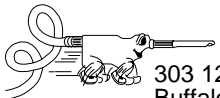
Step 3

After running for 3 minutes adjust gain to read 4.90 volts dc



Black to "com" (common)
Red to "Out 1"

Stage 1 Air
Stage 2 Argon



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ILT-C Setup Calibration
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rlc
CG

Scale: 2/1

Sheet 3 of 7
Drawing Number:
11670-A