

# E710

---



 **MANUAL**  
*English*





# CONTENT

<b>INTRODUCTION</b>	<b>1</b>	<b>PROGRAM VALUES</b>	<b>25</b>
Service and calibration	3	Tolerance	26
Travelling with your measurement system	4	Zoom	26
<b>DISPLAY UNIT</b>	<b>5</b>	Halve or Zero set value	27
Reset the Display unit	5	Live values – colours	27
Navigation buttons	6	Automatic recording	28
OK buttons	6	Precision level E290 (Optional equipment)	28
Function buttons	6	Streaming values	29
Status bar	7	Calibration check	30
Screen dump	8	<b>HORIZONTAL</b>	<b>31</b>
LED lights	8	Adjust measuring units	32
Battery	9	Select machines	33
Charge the Display unit	9	Enter distances	34
A PC via USB cable	9	Measure using Easy Turn™	35
Dry cell batteries	9	Measure using Multipoint	36
Charge the Detector/Measuring units	9	Quality assessment	37
Calculator	10	Measure using 9-12-3	38
Measurement file handling	11	Result and adjust	39
Save file	11	Thermal compensation	43
File manager	11	RefLock™	44
Favourites	12	Tolerance	45
Open file as template	13	<b>SOFTFOOT</b>	<b>47</b>
Copy file to USB memory	13	<b>MACHINE TRAIN</b>	<b>49</b>
Barcode	13	Build machine train	50
Print file (Optional)	14	Enter distances	52
Report	14	Measure using EasyTurn™	53
Download file to PC	14	Measure using Multipoint	54
Control panel	15	Measure using 9-12-3	55
Filter	15	Result	56
Unit and resolution	16	Result Machine view	56
Detector rotation	16	Result Table view	57
Date and time	16	Result Graph view	58
Language	17	Lock feet pair	59
User	17	Best fit and Manual fit	59
Backlight	17	Uncertain coupling	59
Automatic power off	18	Adjust	60
VGA	18	Tolerance	62
System update	19	<b>VERTICAL</b>	<b>63</b>
License	20	Preparations	63
Set up wireless connection	21	Measure	64
<b>CHOOSE PROGRAM</b>	<b>23</b>	Result	65
Preparations	23	Adjust machine	66

<b>CARDAN</b>	<b>67</b>
Mount the units	67
Cone laser beam	68
Rough alignment	69
Measure	69
Result	70
Adjustment	70
<b>STRAIGHTNESS</b>	<b>71</b>
Show target	72
Show reference target	72
Measure	73
Quickmode	74
Add and delete points	75
Result	76
Tolerance	79
Calculation settings	80
Reference points	80
Best fit operations	82
Waviness	83
Straightness settings	84
<b>FLATNESS</b>	<b>87</b>
Preparation	87
Enter distances	87
Measure	89
Result table	90
Result grid	91
Result 3D	91
Calculation settings	92
Reference points	92
Best fit	92
<b>TWIST</b>	<b>93</b>
Measure	93
Result	94
<b>FLANGE FLATNESS</b>	<b>95</b>
Preparations	95
Measure	97
Result	98
Reference points	100
Custom reference points	100
Three reference points	100
Best fit	101
Taper result	103
Tolerance	104

<b>PARTIAL FLANGE FLATNESS</b>	<b>105</b>
Measure	107
Result	108
<b>FLANGE FLATNESS SECTION</b>	<b>109</b>
Preparations	110
Measure	111
Rotate flange	111
<b>PARALLELISM A</b>	<b>113</b>
Align the D46 prism	114
Precision level	115
Calibrate the precision level	115
Measure	116
Measure vertical position	117
Measure horizontal position	118
Adjust roll live	119
Detector angle	119
Result	120
<b>PARALLELISM B</b>	<b>123</b>
Preparations	124
Calibrate the precision level	124
Calibrate E2 detector	125
Laser setup	126
Measure	127
Measure vertical value	127
Measure horizontal value	128
Switch measurement direction	128
Result	129
Move laser	132
<b>BTA</b>	<b>133</b>
Measure using Display unit	135
Measure without Display unit	138
<b>VIBROMETER</b>	<b>139</b>
Measure	140
Vibration level	141
Bearing condition value	142
<b>OFFSET AND ANGLE</b>	<b>143</b>
<b>BATTERY PACKS</b>	<b>145</b>
<b>TECHNICAL DATA</b>	<b>147</b>
Display unit E51	148
Measuring units	149
BTA E180 (Optional)	150
Vibrometer (Optional)	151
Precision level E290	152



# INTRODUCTION

## Easy-Laser AB

Easy-Laser AB develops, manufactures and markets Easy-Laser® measurement and alignment equipment based on laser technology.

We have more than 25 years of experience from measurement tasks in the field and product development. We also provide measurement service, which means that we ourselves use the equipment we develop, and continuously improve it. Because of this we dare to call ourselves measurement specialists.

Do not hesitate to contact us about your measurement problems. Our expertise will help you solve it in an easy way.

## Declaration of conformity

Equipment: Easy-Laser® product range

Easy-Laser AB declares that the Easy-Laser® product range is manufactured in conformity with national and international regulations.

The system complies with, and has been tested according to the following requirements:



EMC Directive	2014/30/EU
Low Voltage Directive	2014/35/EU
Laser Classification	Europe: SS_EN 60825-1 USA: CFR 1040.10/11
RoHs Directive	2011/65/EU
WEEE Directive	2012/19/EU
R&TTE Directive	1999/5/EC

The calibration of the equipment fully complies with ISO9001:2008 #7.6

For wireless devices: This device complies with Part 15 of the FCC Rules.

Operation is subject to the following two conditions:

(1) this device may not cause harmful interference

(2) this device must accept any interference received, including interference that may cause undesired operation.



Disposal of old electrical and electronic equipment (Applicable throughout the European Union and other European countries with separate collection programs)



This symbol, found on product or on its packing, indicates that this product should not be treated as household waste when disposed of.

It should be handed over to an applicable collection point for the recycling of electrical and electronic equipment. By ensuring this product is disposed correctly, you will help to prevent potential negative consequences to the environment and human health. For more detailed information about the recycling of this product, please contact your local city office, household waste disposal service or the retail store where you purchased this product.

## Quality certificate

Easy-Laser AB is ISO 9001:2008 certified. Certificate number 900958.

Easy-Laser AB confirm, that our products are produced according to applicable national and international regulations and standards. All components are checked before assembly and final products are tested in functionality and visually checked before delivery

The calibration of the equipment fully complies with ISO9001: 2008 #7.6

## Limited warranty

This product is manufactured under Easy-Laser's strict quality control system. Should the product fail within three (3) years from the date of purchase under normal usage conditions, Easy-Laser will repair or replace the product free of charge.

1. Using new or refurbished replacement parts.
2. Exchange the product with a product that is new or which has been manufactured from new or serviceable used parts and is at least functionally equivalent to the original product.

Proof of purchase date should be confirmed, and sent together with a copy of the original purchase document.

Warranty is valid under normal usage described in the user's manual appended with the product. The warranty comprises failure on Easy-Laser® product that could be related to material and/or fabrication errors. The warranty is valid only in the country of purchase.

The warranty is not valid in the following cases:

- If the product is broken due to mishandling or incorrect operation
- If the product has been exposed to extreme temperature, calamity, chock or high voltage.
- If the product has been modified, repaired or disassembled by unauthorized personnel.

Compensation for possible damage due to failure on Easy-Laser® product is not included in the warranty. Freight cost to Easy-Laser is not included in the warranty.

---

### ***Note!***

*Before delivery of the product for warranty repair, it is the responsibility of the buyer to backup all data. Data recovery is not included in the warranty service and Easy-Laser is not responsible for data that may be lost or damaged during transit or repair.*

---

## **Lithium Ion battery limited warranty**

Lithium ion batteries inevitably lose power during their lifetimes, depending on usage temperatures and the number of charging cycles. Therefore, the internal rechargeable batteries used in the E-series are not included in our general 2-year warranty. There is a 1 year warranty for the battery capacity not to fall below 70 % (a normal change means that the battery must have more than 70 % capacity after more than 300 charging cycles). A 2 year warranty applies if the battery becomes unusable because of a manufacturing fault or factors that Easy-Laser AB could be expected to have control of, or if the battery displays abnormal loss of capacity in relation to use.

## Safety precautions

Easy-Laser® is a laser instrument in laser class 2 with an output power normally less than 1 mW, which requires the following safety precautions:

- Never stare directly into the laser beam
- Never aim the laser beam at anyone else's eyes.



---

### **Note!**

*Opening the laser units can result in hazardous radiation, and will invalidate the manufacturer warranty.*

---

If starting the machine to be measured would result in injuries, the possibility to unintentionally start it must be disabled before mounting the equipment, for example by locking the switch in the off position or removing the fuses. These safety precautions should remain in place until the measurement equipment has been removed from the machine.

---

### **Note!**

*The system should not be used in explosive risk areas.*

---

## Service and calibration

Our Service centres will quickly assist you if your measurement system need to be repaired or when it is time for calibration.

Our main Service centre is located in Sweden. There are several local Service centres that are certified to carry out limited service and repair. Contact your local Service centre first before sending your equipment for service or repair. All Service centres are listed on our web site under Service and Calibration.

Before sending your measuring system to our main Service centre, please fill in the online Service and Repair report.

## Manuals as PDF

You can download our manuals in pdf format from our website. The pdf's are also available on the USB memory stick that is delivered with most systems.

## EasyLink

The new version of our database program EasyLink is available on the USB memory stick that is delivered with most systems. You can always download the latest version from [easylaser.com>download>software](http://easylaser.com>download>software).

## Travelling with your measurement system

When travelling by airplane with your measurement system we strongly recommend that you check which rules apply for each airline company. Some companies/countries have limitations for checked baggage when it comes to items including batteries. For information about Easy-Laser® batteries, please see system unit details in the end of this manual. It is also good practice to remove the batteries from the equipment, when possible, e.g. D22, D23 and D75.

## Specifications for built-in rechargeable batteries

Easy-Laser Part No.	Type	Voltage	Output	Capacity	Included in Part No.
03-0757	Li-Ion	3.7 V	39.22 Wh	11600 mAh	12-0418, 12-0700, 12-0748
03-0765	Li-Ion	3.7 V	2.5 Wh	660 mAh	12-0433, 12-0434, 12-0509, 12-0688, 12-0702, 12-0738, 12-0752, 12-0759, 12-0758, 12-0799, 12-0846
03-0971	Li-Ion	3.6 V	9.36 Wh	2600 mAh	12-0617, 12-0618, 12-0823, 12-0845
03-1052	Li-Ion	3.7 V	1.22 Wh	330 mAh	12-0746, 12-0747, 12-0776, 12-0777, 12-0791, 12-1054
12-0953	Li-Ion	3.7 V	7.4 Wh	2000 mAh	12-0944, 12-0943, 12-1028, 12-1029
12-0952	Li-Ion	7.4 V	39.22 Wh	5300 mAh	12-0961 (2 pcs)

## Compatibility

The E-series is not compatible with previous analogue units from the D-series. You can however continue to use previous brackets.

## Disclaimer

Easy-Laser AB and our authorized dealers will take no responsibility for damage to machines and plant as a result of the use of Easy-Laser® measurement and alignment systems.

## Copyright

© Easy-Laser 2017

We might change and correct the manual in later issues without further information. Changes to the Easy-Laser® equipment may also affect the accuracy of the information.

*December 2017*



Fredrik Eriksson

Quality Manager, Easy-Laser AB

Easy-Laser AB, PO Box 149, SE-431 22 Mölndal, Sweden

Phone: +46 31 708 63 00, E-mail: [info@easylaser.com](mailto:info@easylaser.com)

Web: [www.easylaser.com](http://www.easylaser.com)

# DISPLAY UNIT



- A** Connection for external power.
- B** Network connection. (Not available on all systems.)
- C** External connection. Use for projector for example. (Not available on all systems.)
- D** USB A (master). Use for USB memory.
- E** USB B (slave). Use for connecting to a PC.
- F** Connection for Easy-Laser® equipment.
- G** Protective cover.

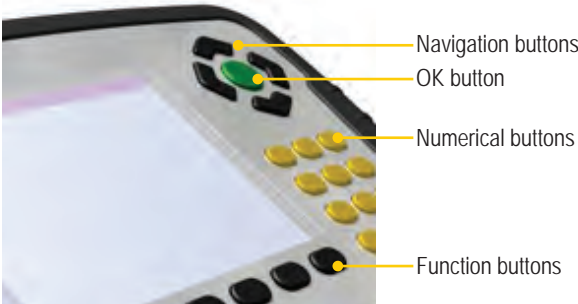


## Reset the Display unit


Press and hold the On/Off button to reset the Display unit.

## Navigation buttons

To navigate on the screen, use the navigation buttons. The selected icon is marked with a yellow frame. The navigation buttons are also used to move between the icons in a submenu and to change the values in the fields.








## OK buttons

There are two green **OK** buttons and they both work in the same way. Press  to select the currently selected icon for example.


## Function buttons

The icons above the function buttons change depending on which view is currently displayed on screen.

Below is a list of the most common icons.

	<b>Back</b> to previous view. Press and hold to leave current program.
	<b>Back.</b> There is no “previous view”. Leave the current program.
	<b>More.</b> Contains a submenu with general functions, such as  (Control panel) and  (Save file).

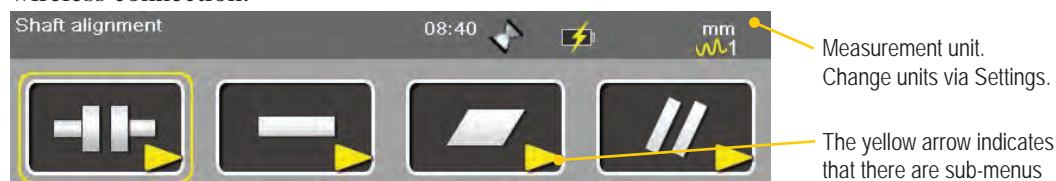
## Submenus

The icons formed as an arrow contain a submenu. Use the navigation buttons to navigate in a submenu. Press  to select.



## Status bar

The Status bar contains additional information such as warning icon, current time and wireless connection.



There are also text messages regarding:

- The selected icon.
- Hints on what information you are expected to fill in.


### Status bar icons

	<b>Warning.</b> Select the function button  to get additional information regarding the warning.
	<b>Warning.</b> Displayed when the coordinates has been rotated in the detector. Go to Control panel to rotate coordinates.
	<b>Hourglass.</b> The Display unit is in the middle of a task.
	<b>Display unit charging.</b> Indicating that a power adaptor is plugged in.
	Display unit is low in battery.
	Measurement progress. Time depending on which filter you have selected.
	Selected filter.
	<b>Peripheral.</b> Indicates that a peripheral device is plugged in, such as a projector.
	Indicates that the wireless functionality is activated. The number beside indicates the number of wireless units connected.
	Printing report on thermal printer. The thermal printer is optional equipment.
	Printing performed OK.
	Printing problem.

## Screen dump

It is possible to take screen dumps of what is currently displayed on screen. You can e-mail the screen dump or use it for reports.

### Take a screen dump

1. Press and hold the numeric button period (.) for 5 seconds.
2. An hour glass is displayed on the status bar.
3. The screen dump is saved in the file system as a .jpg file. It is named with current date and time. Select  to open saved files. See “Measurement file handling” on page 11.

## LED lights

### Right indicator

<b>Yellow</b>	Flashing: The internal battery in the Display unit is charging.
---------------	-----------------------------------------------------------------

### Left indicator

Left indicator has several functions and colours:

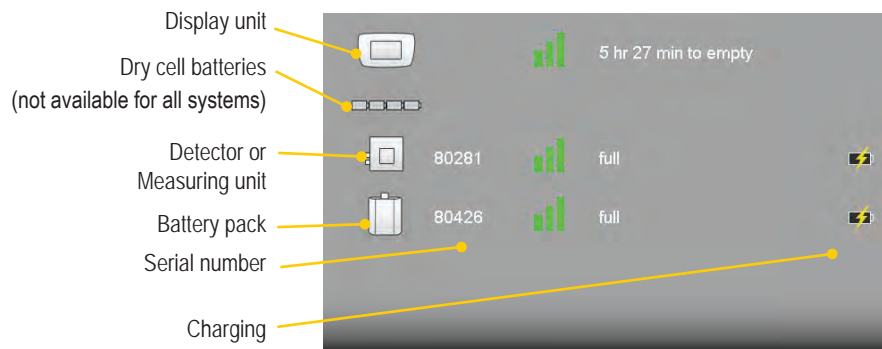
<b>Red/Blue</b>	Quick flashing: Reprogramming the system.
<b>Red</b>	Flashing: Warning, for example low battery.
<b>Blue</b>	Flashing: Searching for detectors equipped with wireless functionality. Fixed light: Connected to detectors equipped with wireless functionality.
<b>Green</b>	Flashing: Display unit is starting. Fixed light: The internal battery in the Display unit is fully charged.
<b>Light blue</b>	Flashing: Backlight is off, but the Display unit is still on. Press any button to activate the Display unit.



# Battery

Select  to display the Battery view.

When finished working for the day, charge the whole system. Plug in the power adaptor to the Display unit and connect the measuring units (**maximum two**) by using cable. If you use a split box, it is possible to charge up to eight units at a time.



The E-series is **not** compatible with units from the D-series.

## Charge the Display unit

The Display unit can be used from -10°C to +50°C. Charge the Display unit within the temperature range of ±0°C to +40°C.

### **Note!**

*If you shut the Display unit off while charging, it will charge faster.*

## Power adaptor

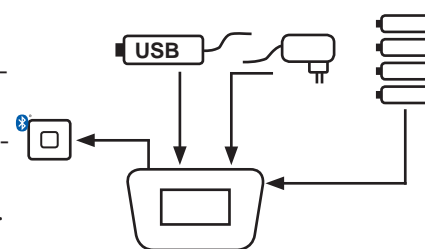
With the power adaptor plugged in, you can keep on working.

## A PC via USB cable

While you have this connection, you can open the files in the Display unit via the explorer in your PC. However, the Display unit is locked.

## Dry cell batteries

When you get a battery warning, insert four R14 dry cell batteries in the battery compartment. This will prolong the power of the Display unit so that you can finish your measurement. However, if the internal battery is completely empty, the dry cell batteries do not have enough power to start up the Display unit.



## Charge the Detector/Measuring units

The Detectors and Measuring units are charged by the Display unit when connected by cable. If you are using wireless units, switch to cable when the battery in the Detector/Measuring unit is low.




## Charge the wireless units

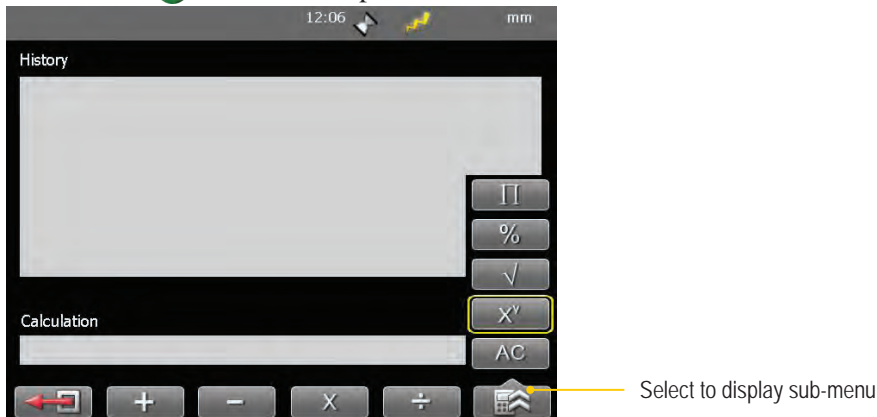
The wireless units are powered by the Detector/Measuring units. To save energy, the wireless units will only connect when you are using a measurement program. There is no power switch on the unit. To switch off, simply unplug the unit.

See “Charge the Display unit” on page 9.

# Calculator



The calculator is found on the Start view and Control panel (  ).

1. Select  and  to open the calculator.
2. Use the numerical buttons and function buttons to enter values.
3. Use the  button to compute.

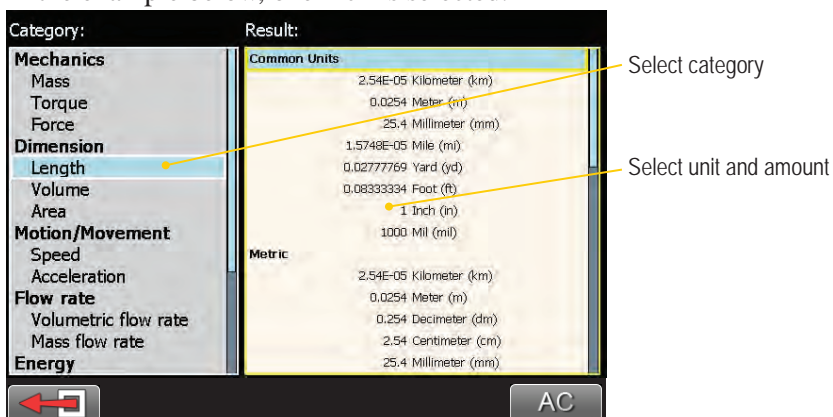


# Unit converter

The unit converter is found on the Start view and Control panel (  ).




1. Select  and  to open Unit converter.
2. Select a category. Move using the navigation buttons up and down.
3. Press navigation button right. The result column is activated.
4. Select a unit to convert from.
5. Enter an amount. The other units are recalculated.

In the example below, one inch is selected.





# Measurement **file handling**

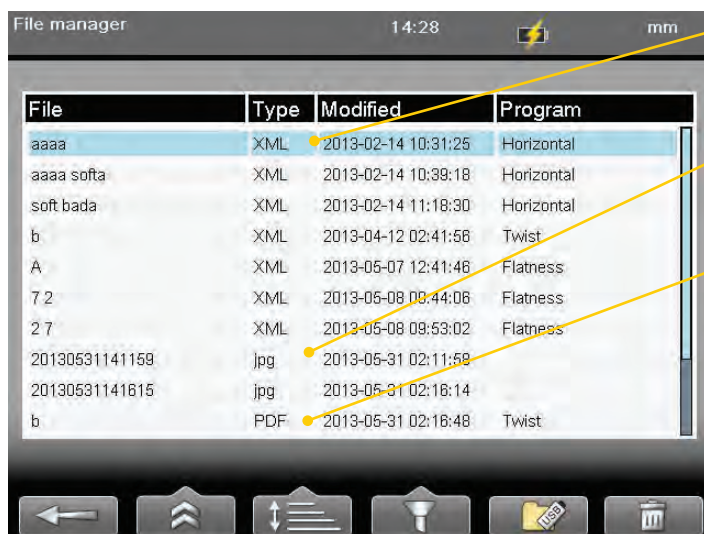
## Save file

1. Select  and  to save your measurement.
2. Enter a file name. The date and time will automatically be added to the file name.  
The measurements that you save will be available to other users as well.
3. Press  to save the file.

## File manager

Select  (found on the start view and Control panel) to open saved measurements. The File manager is displayed. Here you can easily when and from which program the file was saved.

Press  to open a measurement file.




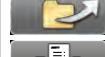


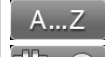



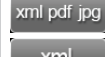

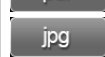






**xml**  
A measurement file.

**jpg**  
"Screen dump" on page 8

**PDF**  
A report. The PDF report can not be opened in the Display unit.  
*PDF is not available for E420.*






## Function buttons

	<b>Back to previous view.</b>
	 "Report" on page 14.  "Open file as template" on page 13.  "Print file (Optional)" on page 14.
	 Sort files alphabetically.  Sort files by measurement program.  Sort by time.
	 Show all files.  Show only xml files.  Show only pdf files.  Show only jpg files.  Show only Favourites. See "Favourites" on page 12.
	"Copy file to USB memory" on page 13.
	Delete files. Delete all <b>displayed</b> files or only selected file.

## Favourites

It is possible to save a measurement as a Favourite. A Favourite can be used for example when you have many flanges or machines with the same dimensions. This way you do not have to enter the same distances or tolerances every time. When you have saved as Favourite, a new icon is displayed on the start screen.



### Create a favourite

1. Select  to open the File manager and select a file.
2. Select  and  to save the selected file as a Favourite.
3. Go to the start screen and select  to see all favourites.
4. Press  to open a Favourite. All distances are filled in.







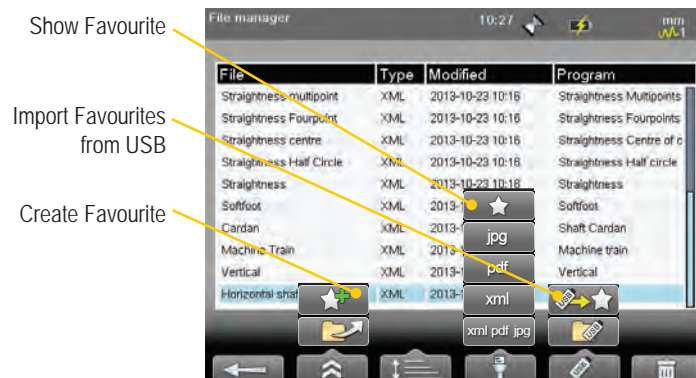
### Import favourites

The favourite files are saved in the folder Favourites in the Display unit.

1. Plug in the Display unit to a PC and open the Favourites folder.
2. Copy the .FAV (favourite) file to the root of an USB memory stick.
3. Connect the USB stick to a Display unit and select  and  to import.



### Delete favourite

1. Select  to open the File manager and select a file.
2. Select  and  to show all Favourite files.
3. Select a file and .




## Open file as template

You can open a saved measurement and use it to make a new measurement. This is very useful when you have many flanges or machines with the same dimensions for example. This way you do not have to enter the same distances every time.

1. Select  (found on the Start view and Control panel). The File manager is displayed.
2. Select a file in the list and select . The Edit distance view is displayed.
3. Change distances if needed and proceed to measuring view.

## Copy file to USB memory


You can easily copy a saved measurement or other files to a USB memory.

1. Insert a USB memory.
2. Select the file you want and select .
3. A folder is automatically created on the USB memory. The file is saved in the folder \Damalini\archive\.

## Barcode

### Save file with barcode

The barcode scanner is not included in all systems. The first time you measure a machine, you stick a barcode on the machine and save the measurement together with the scanned barcode. Next time you align the same machine, all you need to do is scan the barcode and all machine data is read.

1. Scan the barcode on the machine.
2. Enter a file name.
3. Press  to save the file. All measurement data is saved together with the barcode.




The barcode number is added to the file name.

When you connect the Display unit to a PC the whole file name is shown:

Namn	Senast ändrad	Typ	Storlek
taper.2009-10-05 01-45-05.6.bob.XML	2009-10-05 13:45	XML-dokument	22 kB
standard.2009-10-13 03-58-05.6.bob.XML	2009-10-13 15:58	XML-dokument	17 kB
Small flange.2009-10-21 02-30-09.6.bob.XML	2009-10-21 14:30	XML-dokument	40 kB
pump 1.2010-03-17 11-58-05.5.bob.EAN9789170013386.XML	2010-03-17 11:58	XML-dokument	5 kB
pump 1.2010-03-17 11-57-17.5.bob.EAN9789170013386.XML	2010-03-17 11:57	XML-dokument	5 kB

File name      Date and time      User      Barcode number




Barcode reader

### Open file with barcode

- Start the Display unit and scan the barcode. The **latest** measurement that was made and saved with this barcode is automatically opened.



**OR**




- Select  to open File view. Scan the barcode on the machine. **All** measurements saved with this barcode are shown.

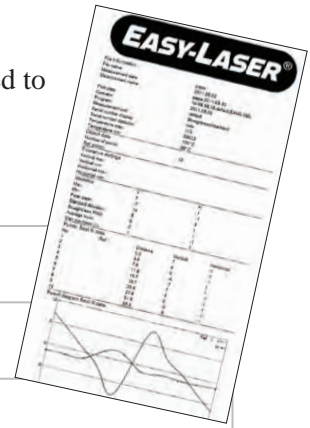
## Print file (Optional)

Part no. 03-1004

The thermal printer is optional equipment.

1. Save the measurement. To print from a Shaft program, you need to open a saved measurement before you can print a report.
2. Connect the thermal printer and select  and .
3. The progress is displayed on the status bar.

	Printing report on thermal printer.
	Printing performed OK.
	Printing problem.



You can also save a measurement, download the pdf-report to your PC and print the pdf-report.

## Report

A report is generated and saved in the filing system. You can not open an old measurement and save it again (program Machine train is an exception to this). You can however generate a new report from an opened file. This means you can for example change the language and make a new report from the opened measurement. You can download the report to a PC and print it.

### Company logo

You can replace the logo on the report with your own .jpg file.

1. Name your logo logo . jpg. The default logo has the proportions of 230x51 pixels.
2. Connect the Display unit to your PC using the USB-cable.
3. Place your image in the Display unit's folder Damalini / custom / reports / logo.

File extensions (for example .jpg) are often hidden in the Explorer window. To display file extensions do the following: Open an Explorer window and press Alt to show menu. Select Tools > Folder options. Click the View tab > Advanced settings > Clear the Hide extensions for known file types check box.

### Date format

By default, the date and time format is set to Central European Time (CET).

You can change the date and time format used in your PDF reports.

## Download file to PC



1. Start the Display unit. It is important to let it start fully before connecting the cable.
2. Connect the USB cable between the Display unit and PC.
3. While you have this connection, the Display unit is blocked.
4. View and/or copy the files to the PC.

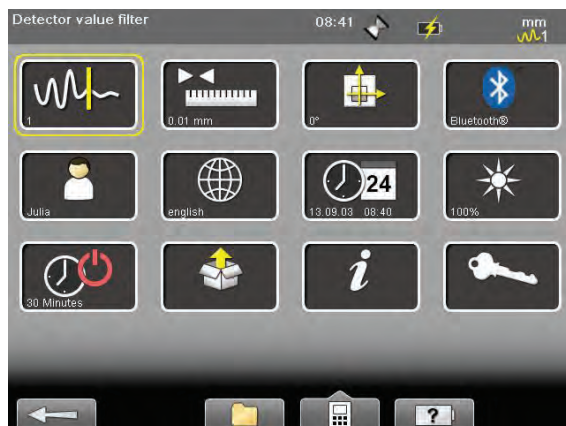
### EasyLink

You can also use our database program EasyLink to view the files on your PC. EasyLink is available on the USB memory stick that is delivered with most systems. You can always download the latest version from [easylaser.com>lifecycle support>software download](http://easylaser.com>lifecycle support>software download).



# Control panel

Select  and  to open the Control panel. Some of the settings are personal and will be default next time you start the system.



## Note!

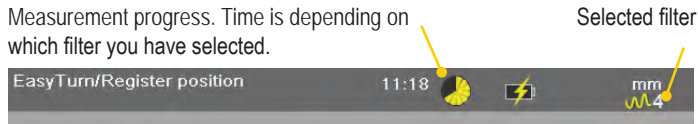
All settings are not available for all systems.

## Filter

Select  to open the Filter view.

The filter you select on the Filter view will be saved as a personal setting.

If the laser beam passes through air with varying temperature, this may influence the direction of the laser beam. If measurement values fluctuate, this could mean unstable readings. Try to reduce air movements between laser and detector by, for instance, moving heat sources, closing doors. If the readings remain unstable, increase the filter value (more samples will become available to the statistical filter).



## Select filter

Use as short a time as possible that still produces acceptable stability during the measurement. Default is set to 1. Normally you will use a filter value of 1-3. If you set the filter type to 0, no filter will be used.

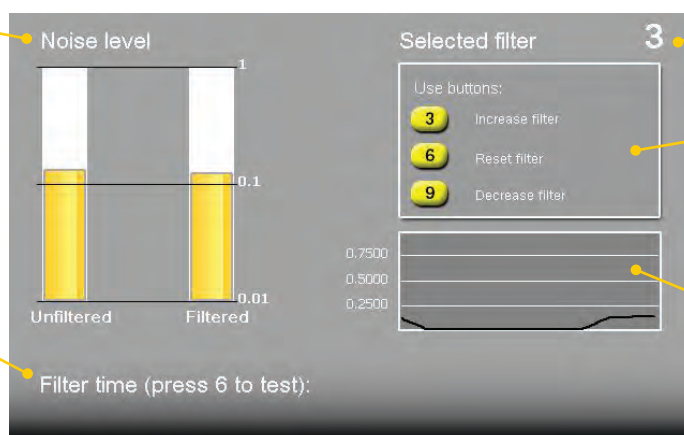
Use the numerical buttons 3, 6 and 9 to set the filter. In the Filter view but also when you are using a measuring program.



Use numerical buttons to select filter

Current noise level in the system before and after filtering

Press function button 6 to test how long the measurement progress is




Currently selected filter

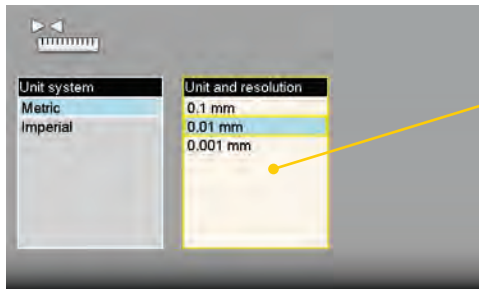
Use numerical buttons to set filter. Button 6 will restart the filter

Graph shows filtered noise level over time

## Unit and resolution

### Personal setting

Select  to open the Units and resolution view. Use the navigation buttons to move between the fields. Set Metric or Imperial and which resolution you want to use. Default is set to 0.01 mm (0.4 mil). The selected unit is shown on the Status bar.




### Note!

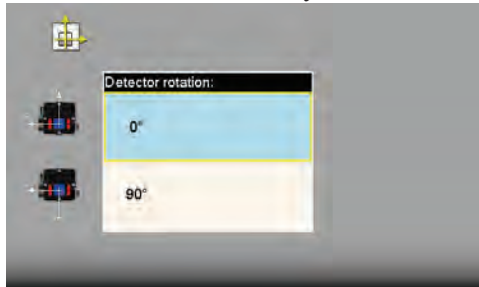
It is possible to select 0.0001mm only in the E940 system.

For E420, only 0.01mm is possible.

## Detector rotation

### Personal setting


The coordinate system can be rotated 90°. Select  to open the Detector rotation view. When you have rotated the coordinates, a warning is displayed on the Status bar. Detector rotation will only affect detectors with two axis.

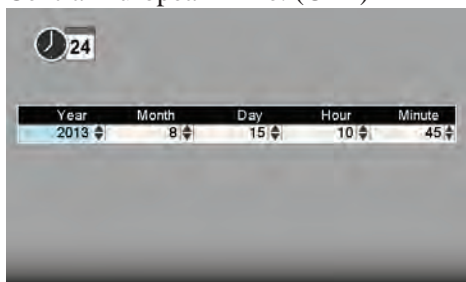


Warning displayed on Status bar

Detector rotation view

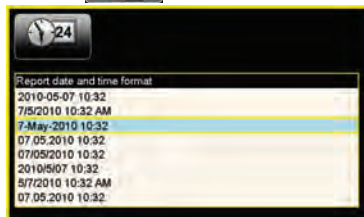
## Date and time

Select  to open the Date and Time view. Set the date and time. Default is set to Central European Time. (CET)



Date and time view

Select  to set the date format used in your PDF reports.





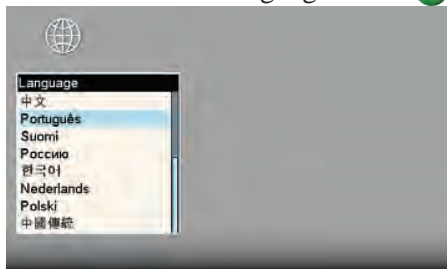
Date and time used in PDF reports



## Language

### Personal setting




Select  to open the Language view. Default is set to English. Use the navigation buttons to select a language. Press  to save changes.

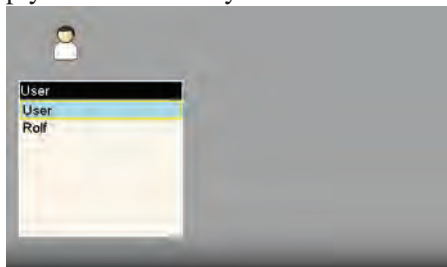


Language view

## User

Select  to open the Users view. A user account is used for storing your personal settings.



Use the function buttons   to add or remove users. To switch user, simply select the user you would like to switch to and press .



User view

## Backlight

### Personal setting

Select  to open the Backlight view. Use the navigation buttons to move between the fields. Press  to save changes. When backlight is off, the left LED signal will flash to indicate that the Display unit is still on.

#### Backlight level

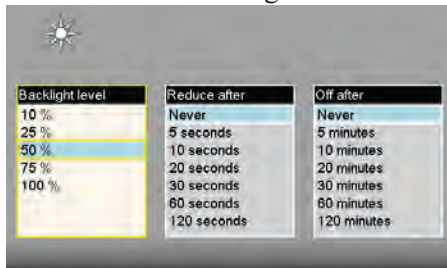
Adjust the backlight to make it easier to read in bright sunlight. Remember however that a high contrast consume more battery power. Default is set to 50%.

#### Reduce after

Set time before backlight reduction as a way to save energy. The Display unit will be dimmed, but is still on. Default is set to Never.

#### Off after



Set time before backlight off. Default is set to Never.

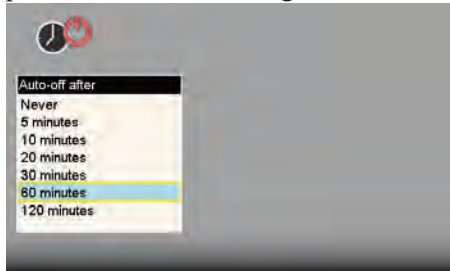


Backlight view

## Automatic power off

### Personal setting

Select  to open the Automatic off view. Select how much time before automatic power off. Use the navigation buttons to select. Press  to save changes.



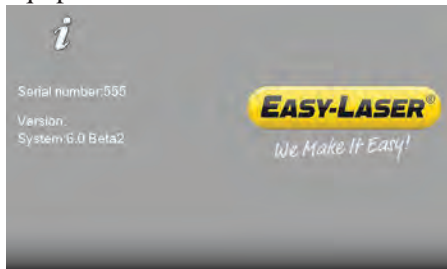
Automatic power off view

### **Note!**

*Measurements in progress will not be saved in the event of an Automatic power off.*

## Information

Select  to display the information regarding serial number and version of the equipment.



Information view

## VGA

(Not available on all systems.)

Makes it possible to show display unit screen image with a projector, for example in a training context. Must be factory installed on order.

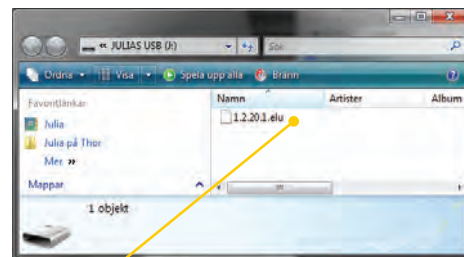
Select  to open the VGA view.



## System update





### Download update file

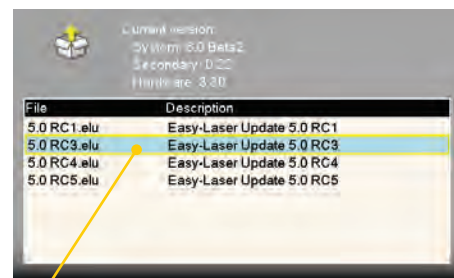
1. Go to [easylaser.com](http://easylaser.com)>lifecycle support>software download.
2. Download the update file to your PC.
3. Unzip the file.
4. Copy the .elu file to the root of a USB memory.



Save .elu file on a USB memory.

### Install update file

1. Start the Display unit. Make sure that the internal battery of the Display unit is charged. The battery symbol should be at least yellow.
2. Insert the USB memory in the Display unit. Do not remove the USB memory until the update is finished.
3. Select  and  to display the System update view.
4. Select the update file and press .
5. Select . The installation starts.
6. The Display unit will automatically restart when the installation is finished and the Main menu is displayed.



Select the .elu file.

### Note!

During restart, the screen turns black for up to one minute. When the main menu is displayed, it can "freeze" (no response when you press buttons). If this happens, press the On/Off button for at least 15 seconds to restart the Display unit.



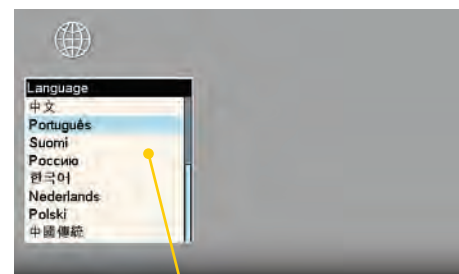
Main menu is automatically displayed after restart.

### Font package

Some of the early E-series systems was not installed with Unicode fonts. To install the latest system updates, you need to install the font package with Unicode fonts.

Check if you need to install:

1. Select  and  to display the Language view.
2. Check if you have Chinese installed. **If Chinese is installed, you already have the correct Font package.** If not, please go to [easylaser.com](http://easylaser.com)>lifecycle support>software download and follow the instructions above to install.





Chinese installed?  
No need to update with Font package.

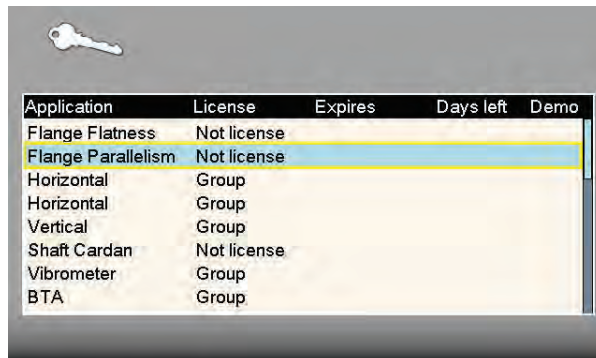
## License



It is easy to upgrade your Display unit.

1. Contact your Easy-Laser® distributor if you wish to upgrade your Display unit.
2. An e-mail will be sent to you with information on how to download the update file.
3. Save the file to the root of the file system to a USB memory stick or directly to the Display unit.

### Save file on USB

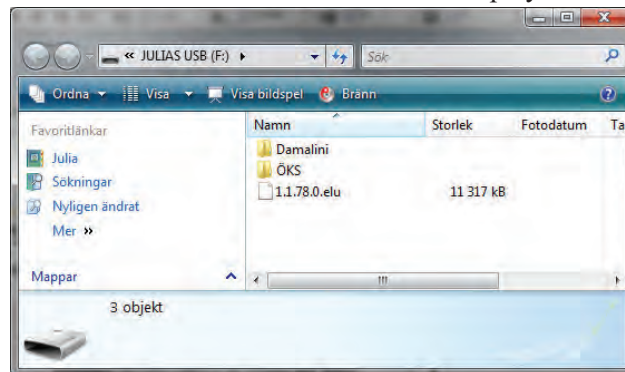
1. Save the downloaded license file to a USB memory stick.
2. Insert the USB memory stick in the Display unit.
3. Select  and  to display the License view.







4. Select  to search for licenses.
5. Press  to import license.

### Save file to Display unit

1. Connect the Display unit to a PC.
2. Save the license file to the root of the Display unit's storage.



3. Select  and  to display the License view.
4. Select  to search for the new license file. A window is displayed.
5. Disregard the text and select . The license file is installed and full functionality is achieved.

## Set up wireless connection

Wireless technology makes it possible for Display unit and Detector to exchange data without using cables.

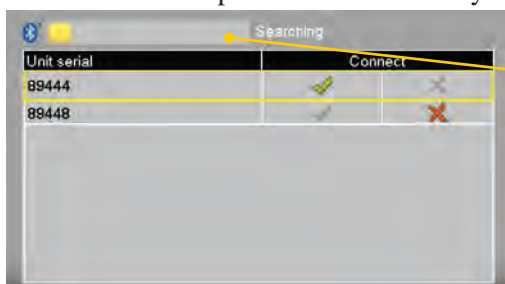


Some detectors have built-in wireless functionality, others have a separate unit that you attach to the detector. *Please see Technical data for more information.*

### Set up

This is only necessary when adding new units to the list.

1. Select to open the wireless view.
2. Select to search for units.
3. The view is updated with the units you can connect to.



Searching for wireless units

4. Select the unit you want to connect to and select . The unit will automatically be connected when you start a measurement program.
5. Press to save changes and to leave the view.
6. Enter a measurement program. The Display unit will connect to the selected units. While connecting, the left LED indicator is flashing with a blue light which will turn to a fixed blue light once connected.
7. An icon on the status bar will indicate how many wireless units that are connected.



One unit connected



### Function buttons




	Back to Control panel. Changes made in the table are saved.
	Search for wireless units.
	Cancel search. Use if your unit is already found.
	Remove a unit from the list.
	Connect the unit. The unit will automatically connect when you start a measurement program.
	Disconnect the unit. The unit will remain in the list.

### Note!

Do not use a wireless unit and a cable at the same time.

**Use only one wireless unit**

Many of our systems are delivered with two Measuring units. In some cases you might want to use only one unit together with a laser transmitter. By default both units are set to “Connect ”. If the unused unit is set to “Connect ”, the system will keep on trying to connect to it, even if it is not plugged in.

1. Attach the wireless unit to the detector.
2. Select  to open the wireless view.
3. Set the unit you want to use to .
4. Make sure that the other units are set to .
5. Enter a measuring program.

The Display unit will connect to the selected unit. This may take a couple of minutes.

---

***Note!***

*Remove the wireless unit from the Measuring unit before putting the equipment in the carrying case. If attached, it will discharge the Measuring unit.*

---

**Wireless information**

This device contains

FCC ID: PVH0925

IC: 5325A-0925

This device complies with Part 15 of the FCC Rules.

Operation is subject to the following two conditions;

- (1) this device may not cause harmful interference, and
- (2) this device must accept any interference received, including interference that may cause undesired operation.

# CHOOSE PROGRAM

## Preparations

Before starting a measurement, there are several things that are good to check to ensure a good and accurate measurement.

- Ensure a good measurement environment. Strong sunlight, warning lights, vibrations and temperature gradients can affect the readings.
- Make sure the surfaces are clean.
- Ensure that the foundation of the machine is stable.
- Check for play and clearance in the bearing.



### Values

Shows live readings from S and M units.



### Horizontal

For alignment of horizontal machines.



### Vertical

For alignment of vertically mounted machines.



### Cardan

For alignment of cardan-shaft-coupled/centre-offset machines.



### Machine train

For machine trains with two or more couplings.



### Straightness

For straightness measurement of machine bases, bearing journals, machine tools, etc.



### Flatness

Program to measure flatness of machine bases, machine tables, etc.



### Flange Flatness

Measure 1 to 5 circles on a flange.



### Partial Flange Flatness

Measure only a part of a large flange.



### Flange Section

Use for large flanges. The flange is divided into four sections.



### Twist

Measure twist on an object by taking two diagonal measurements.



### BTA

For alignment of belt and chain drives.



### Vibrometer

Shows the vibration level in "mm/s" and bearing condition value in "g".



### Offset and Angle

Shows centre offset and angular error between two shafts, for example.



### Softfoot

Check to ensure that the machine is resting evenly on all its feet.



### Parallelism A

Measure roll parallelity using a penta prism and a precision level.



### Parallelism B

Measure roll parallelity using an angle detector and a precision level.



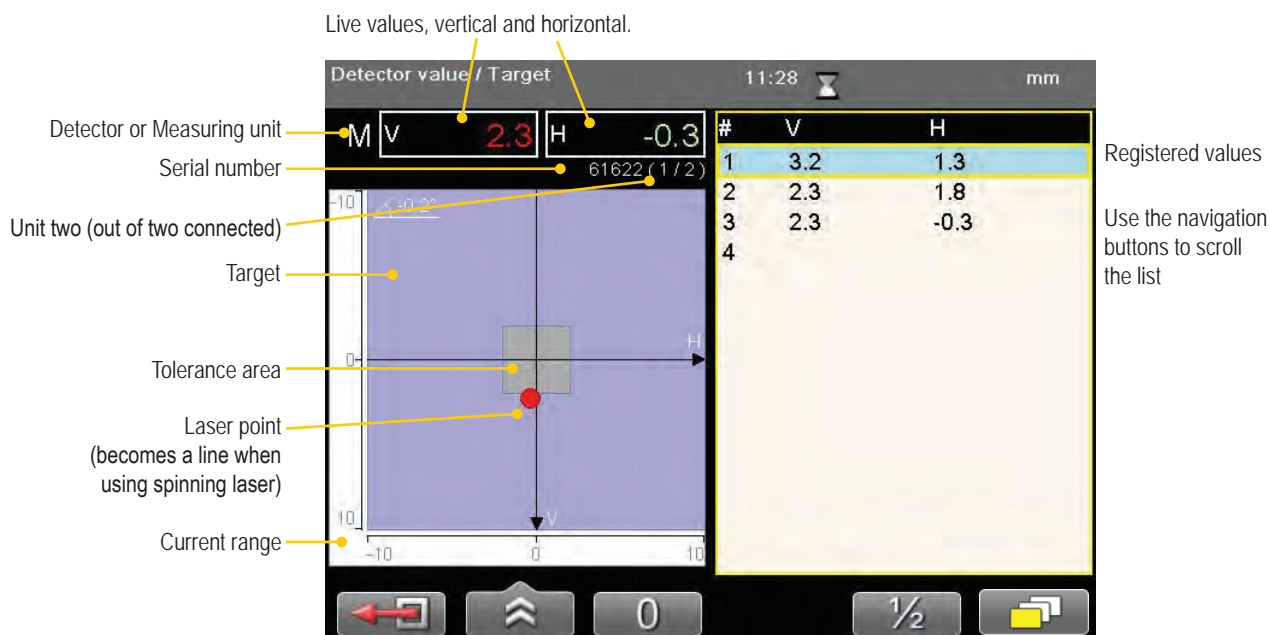


# PROGRAM VALUES

V 0.00  
H 0.00

With the program Values, you can see live readings from the detectors.  
As default, a target and a table is displayed.

Press **OK** to register values.





## Function buttons

	Back, leave program.
	See "Control panel" on page 15. See "Tolerance" on page 26. See "Zoom" on page 26. Save file. See "Measurement file handling" on page 11. See "Automatic recording" on page 28. Delete registered values. Print report on thermal printer (optional equipment). See "Streaming values" on page 29.
	Set current value to zero.
	Halve displayed value.
	Return to absolute value. Only available after zeroing or halving.
	Choose how to display values. Use left and right navigation button to switch between two or more detectors when only one target is displayed.

### Note!

The M-unit can be used as a detector together with a laser transmitter. Do not use the S-unit for this.

## Tolerance

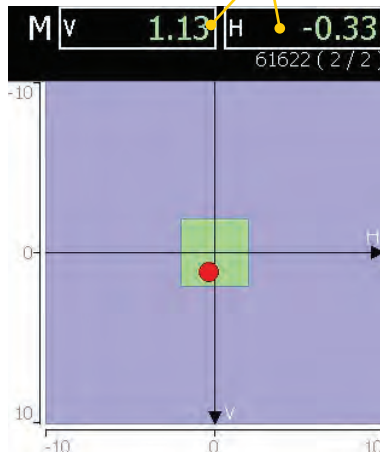
1. Select  and  to set tolerance.  
It is possible to set different tolerance in vertical and horizontal direction.
2. Use navigation buttons to move between the fields and to change the tolerance.
3. Press **OK**.

Select tolerance. Press OK to save.

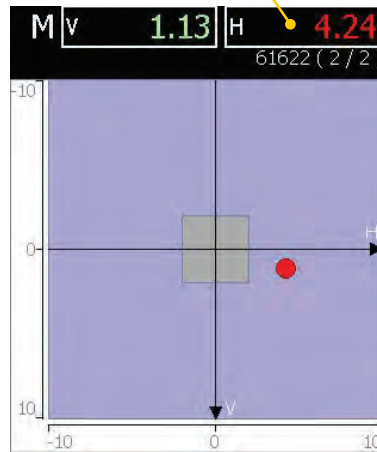
Tolerance - mm

Vertical	Horizontal
2	2



Live values and marking displayed in green when within tolerance.



Live values displayed in red when outside tolerance.

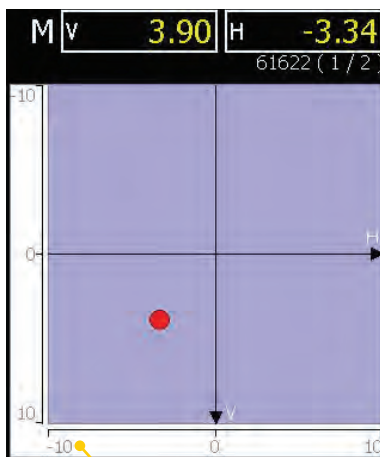


## Zoom

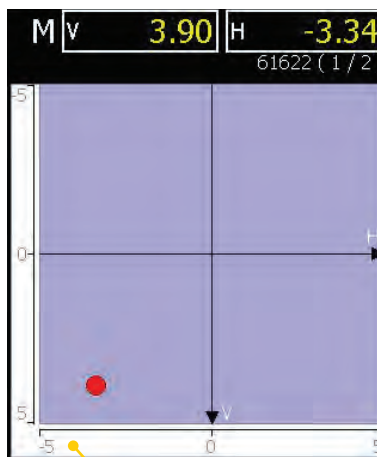
1. Select  and  to zoom.
2. Select a zoom factor between 1–5. Use navigation buttons to increase or decrease zoom factor.
3. Press **OK**.

Select zoom factor. Press OK to save.

Zoom factor: 2 x



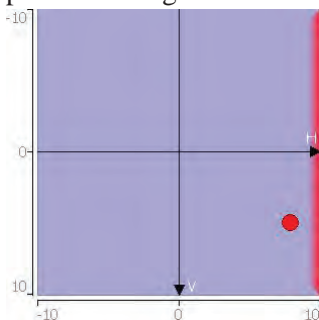
Default view



Zoom factor is set to 2

## Edge warning

When the laser beam is close to the edge, the edge is “lit up” as a warning. It is not possible to register values when you see the edge warning.



## Halve or Zero set value

### Halve value

Select  $\frac{1}{2}$  to half displayed value.

Zero point of the PSD moves halfway towards the laser point.

### Zero set value

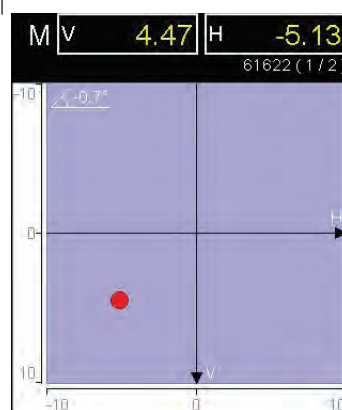
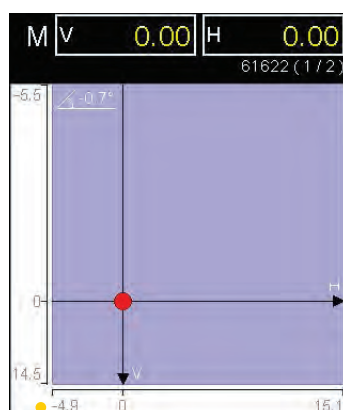
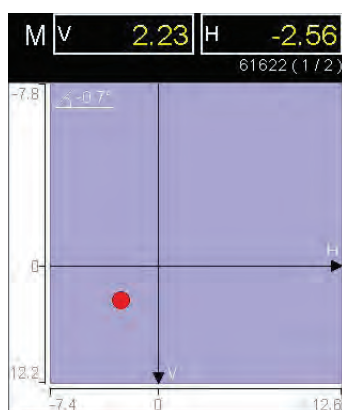
Select 0 to zero set displayed value.

Zero point of the PSD moves to the laser point.

### Absolute value

Select  $\frac{1}{1}$  to return to the absolute value.

Zero point of the PSD returns to the PSD centre.



Note the change of the current range

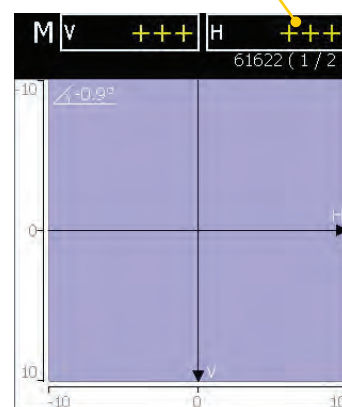
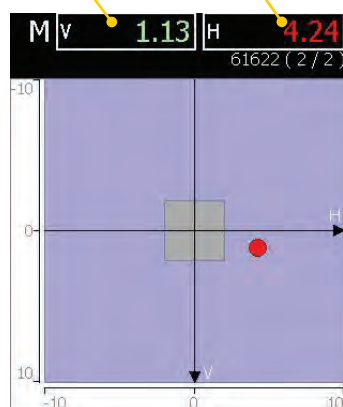
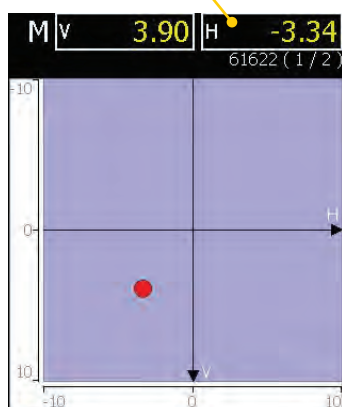
## Live values – colours

Live values are normally yellow

Green when within tolerance



Red when outside tolerance

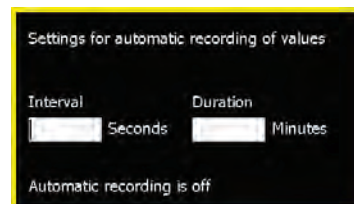
Loss of signal, laser beam interrupted for example



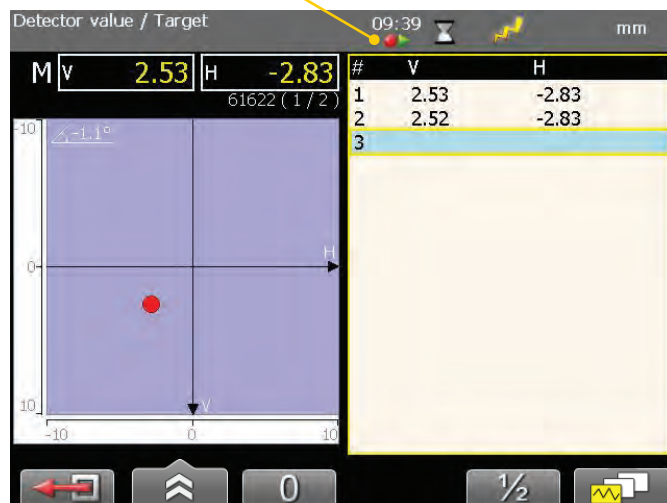
## Automatic recording

In Values, it is possible to make automatic recording of values. This is very useful when you want to register values during a longer time period for example.

1. Select  and  to start automatic recording.
2. Set Interval.
3. Press navigation button “right”.
4. Set Duration.
5. Press **OK**. The recording will start and you can follow the progress on screen.



Icon indicates that values are being recorded



## Views

You can decide how to display the current values. As default a target and a table is displayed, but you can choose to show only target for example.

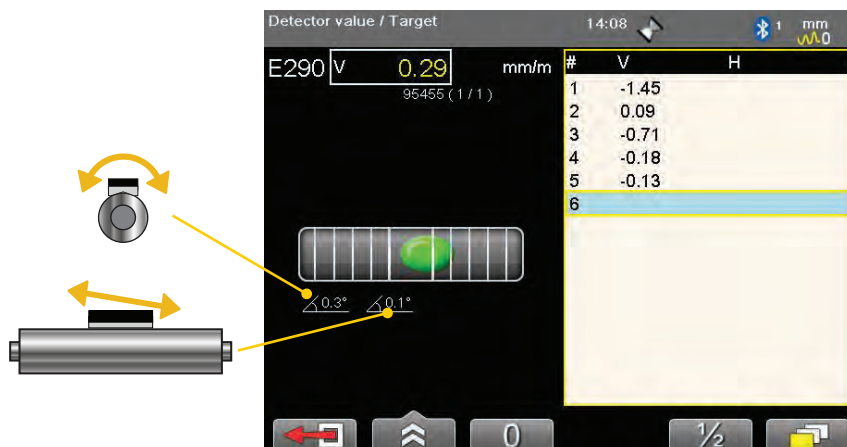
Select  to display the different layout options, see image below.

### **Note!**

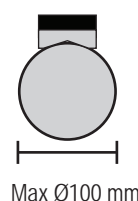
Use left and right navigation button to switch between two or more detectors when only one target is displayed.

## Precision level E290 (Optional equipment)

Connect the Precision level, see “Set up wireless connection” on page 21.



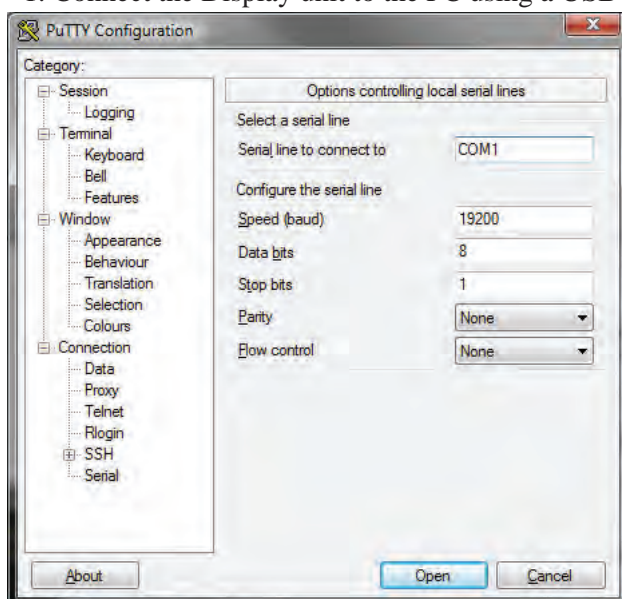
When measuring a shaft using the Precision level, we recommend that the shaft is no larger than 100 mm in diameter.



# Streaming values




With the Streaming value functionality, you can transfer data from the Display unit. For this to work, you need a USB to USB Null Modem Cable, the USB cable delivered with the system does not work for streaming values.

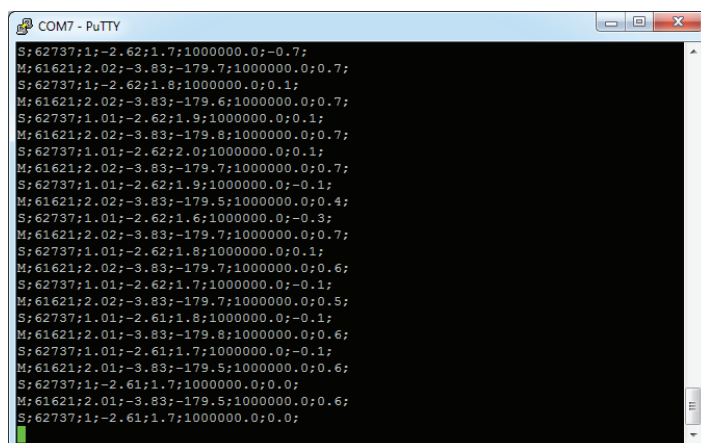
1. Connect the Display unit to the PC using a USB to USB Null Modem Cable.



The USB-to-USB null modem cable shows up as a Virtual Serial Port with the following properties:  
19200 bps, 8n1 without flow control.

The port number can, for example, be found using the Device Manager. See 'USB Serial Port' under 'Ports (COM and LPT)'.

2. Click Open.
3. Start the program Values in the Display unit.
4. Select  and  to start streaming values.
5. To stop, select .



In this example, PuTTY is used to show the streamed data

## Data format

The data is sent as lines with semi colon separated values. Each line begin with a detector identification, S, M, Vib or BTA, followed by the detector serial number. The unit and resolution depends on the settings in the user profile.

**Data from Vib:** Vib;serial;LP;HP;G;

**Data from BTA:** BTA;serial;PSD1X;PDF2X;PDF3X;X axis angle;Y axis angle;Z axis angle;




**Data from S:** S;serial;PSD X; PSD Y; X axis angle;Y axis angle;Z axis angle;

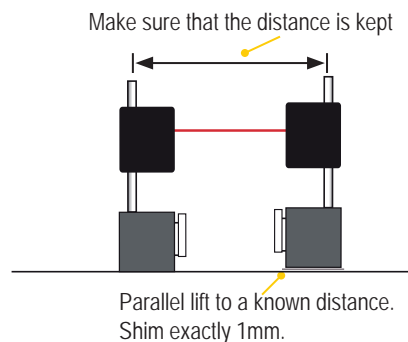
**Data from M:** M;serial;PSD X; PSD Y; X axis angle;Y axis angle;Z axis angle;

## Calibration check

Use the program Values to check if the detector readings are within specified tolerances.

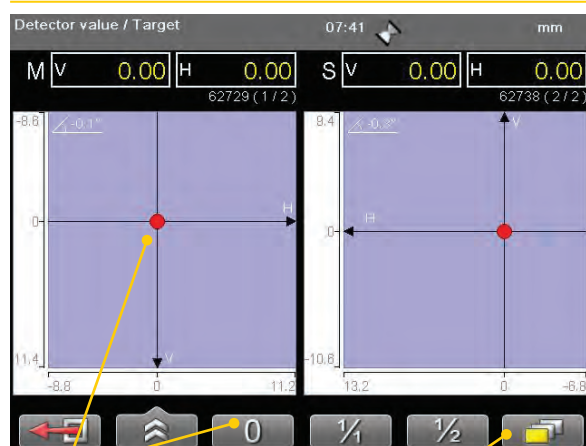
### Quick check

1. Set the tolerance to 0.01 mm (0.5mil).
2. Select  and show targets for both M- and S-unit.
3. Select  to zero set value.
4. Place a shim under the magnet base to lift the M-unit 1mm (100mils). The M-unit's reading shall correspond to the movement within 1% (1mil  $\pm$  1digit) (0.01mm  $\pm$  1 digit).
5. Remove the shim from the M-unit.
6. Select  to zero set value.
7. Make a mark to mark out the position of the detector.
8. Place the shim under the magnet base of the S-unit. The S-unit's reading shall correspond to the movement within 1% (1mil  $\pm$  1digit) (0.01mm  $\pm$  1 digit).



### Note!


The shim must be exactly 1 mm. In this example it is only the M-unit that is checked.

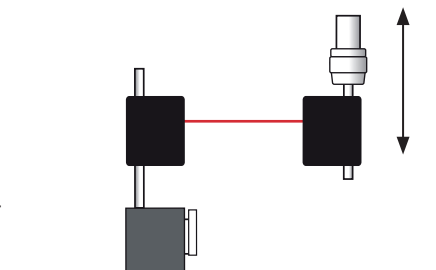


Zero set value

Select to show both targets.

### Precision check

1. Fasten one unit in a machine tool.
2. Select  to zero set value.
3. Move the units a known distance is to use the movement of a machine tool spindle.
4. The fastened unit's reading shall correspond to the movement within 1% (1mil  $\pm$  1digit) (0.01mm  $\pm$  1 digit).



### Note!

In this example it is only the unit fastened in the machine that is checked.



# HORIZONTAL



For horizontally mounted machines.

Select between three different measuring methods:



## EasyTurn™

Start anywhere on the turn. The three measuring positions can be registered with as little as 20° between positions. By default, the EasyTurn program is shown.

See “Measure using Easy Turn™” on page 35.



## Horizontal Multipoint

Start anywhere on the turn. Register as many points as you wish.

See “Thermal compensation” on page 43



## 9-12-3

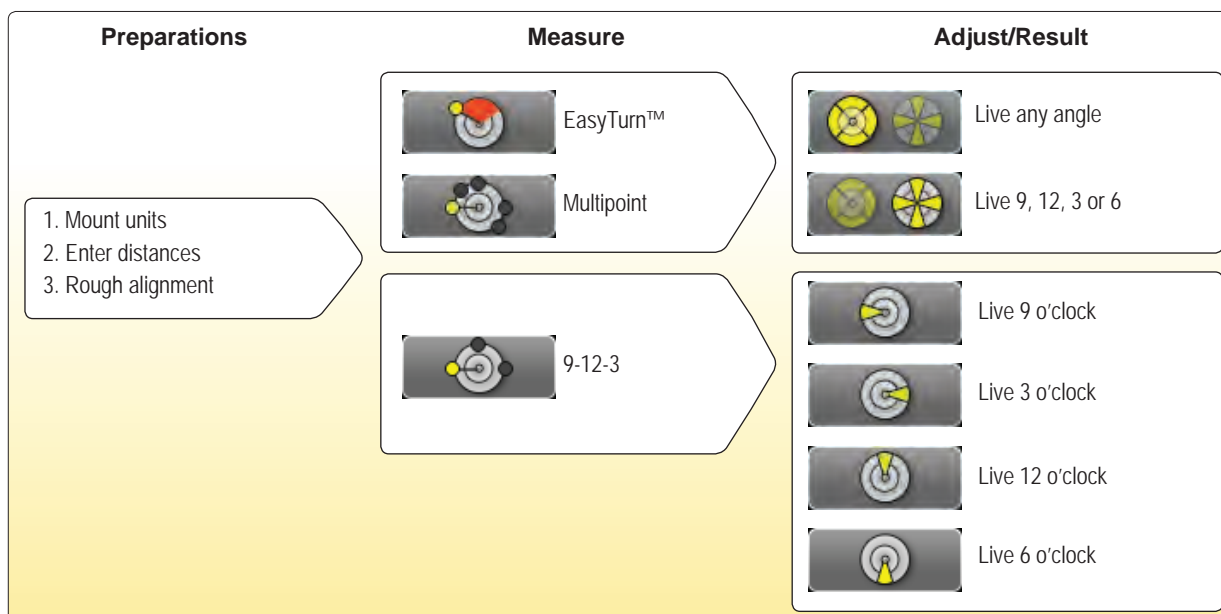
The measuring positions are registered at positions 9, 12, 3 o'clock. The inclinometers are not used.

“Measure using 9-12-3” on page 38.

### Note!

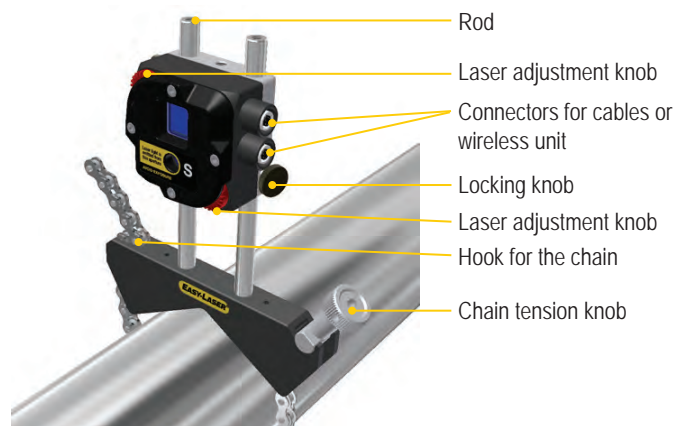
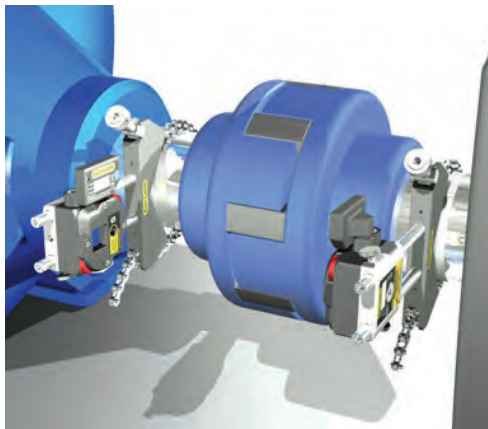
Measurements made with older versions of the Horizontal program are opened with the older version of the program. For information regarding the previous program version, please see corresponding manual.

## Work flow



## Mount the units

1. Mount the S-unit on the stationary machine and the M-unit on the movable machine.
2. Mount the units facing each other. Make sure they are at the approximately same rotational angle and radius.



Mounted measuring units

## Connect cables or wireless units

### Cable

The measuring units has two connectors that are used for cables or wireless units.

1. Connect a cable to the Display unit. Connect the other end to any of the measuring units.
2. Connect the second cable between the measuring units.

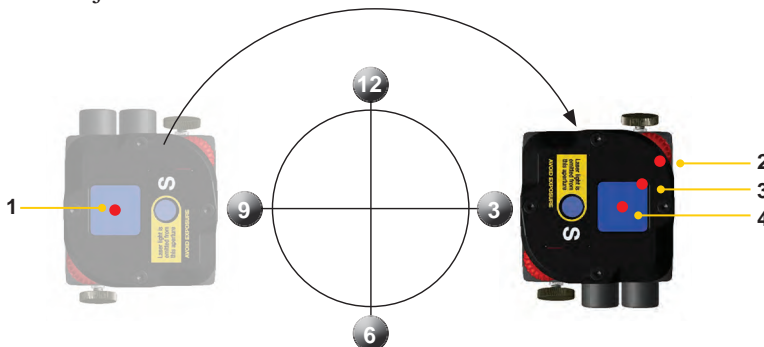
### Wireless

The Display unit is equipped with wireless technology, which makes it possible for the Display unit to receive data without using cables. For more information, see “*Set up wireless connection*” on page 21.

## Adjust measuring units

When making a new installation, a rough alignment can be necessary. Place the Measuring units on the rods, make sure they are at the approximately same rotational angle and radius. Also make sure that the adjustment knob is adjustable in both directions.

1. Place the Measuring units at 9 o'clock. Aim the laser beams at the centre of the targets.
2. Turn the shaft to position 3 o'clock. Note where the laser beams hit.
3. Adjust the laser beams half way to the centre of targets. Use the adjustment knobs.
4. Adjust the movable machine until the laser beam hits the centre of targets.




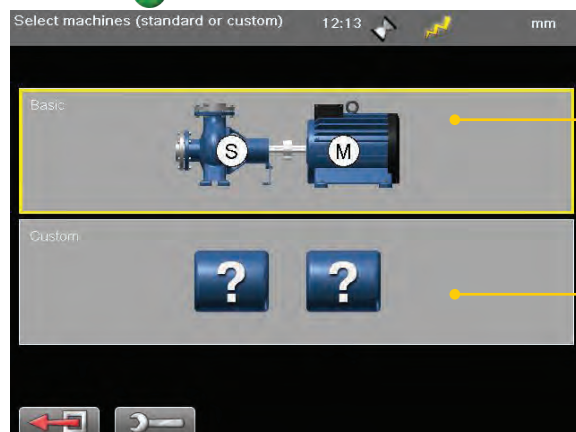
The example shows the S-unit, but the procedure is made on both units.



## Select machines

Before measuring your machines, you need to define what kind of machines you have.

1. Use navigation buttons to select Basic or Custom.
2. Press .

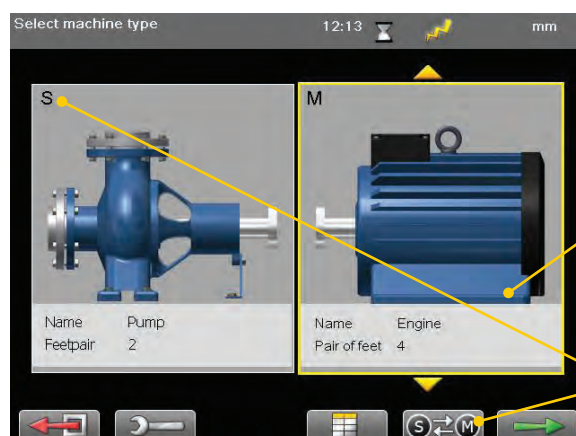


**Basic:** Contains a pump and a motor. These predefined machines have two feet pair each.

**Custom:** Select this option if you want to select machine types.


### Custom

Select this option if you want to select machine types. There are several machine types to choose from. You can also define as many feet pairs as you need on the machines.



More than three feet pairs are visualized as one solid foot on the machine.

Switch M and S






1. Use navigation buttons up and down to find the machine you want.
2. Press . The next machine becomes active.

When you are done, select  to continue to Enter distance view.


### Select number of feet pair

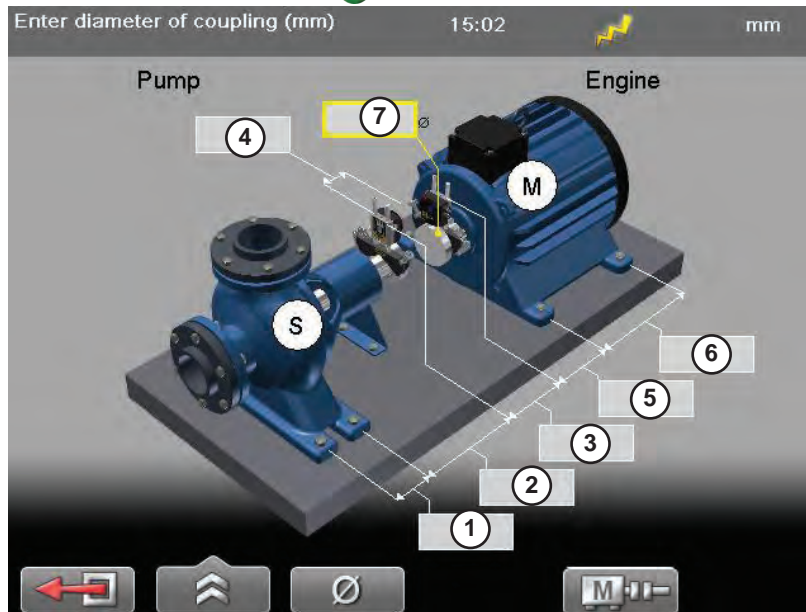
If you want to change the number of feet pair on the machine, simply enter the number you want on the numerical buttons.




### Function buttons

	Leave program.
	See "Control panel" on page 15.
	Open table to rename the machines and change the number of feet pairs.
	Switch on which machine you will place the S (stationary) and M (movable) measuring unit.
	Continue to Measure view.











# Enter distances

Confirm each distance with .



- ① Distance between first and second feet pair. Optional, select  to activate field.
- ② Distance between second feet pair and S-unit. Optional, select  to activate field.
- ③ Distance between S-unit and M-unit. Measure between the rods.
- ④ Distance between S-unit and centre of coupling.
- ⑤ Distance between M-unit and feet pair one.
- ⑥ Distance between feet pair one and feet pair two.
- ⑦ Coupling diameter. Optional, select  to activate field.

## Function buttons

	Leave program.
	 See "Control panel" on page 15.  See "Tolerance" on page 45.  See "Thermal compensation" on page 43.  Select to enter distances of the S-machine.  Toggle between showing Distance view in 3D or 2D.
	<b>Diameter.</b> Select to enter coupling diameter. This is necessary if you want the result based on the gap of the coupling instead of angle.
	Toggle button. Show movable machine to the left or the right.
	Continue to Measure view. Available when you have entered the mandatory distances.


### Note!

The M-unit can be used as a detector together with a laser transmitter.  
Do not use the S-unit for this.

# Measure using Easy Turn™




## Preparations

Follow the preparations as described in the previous pages.

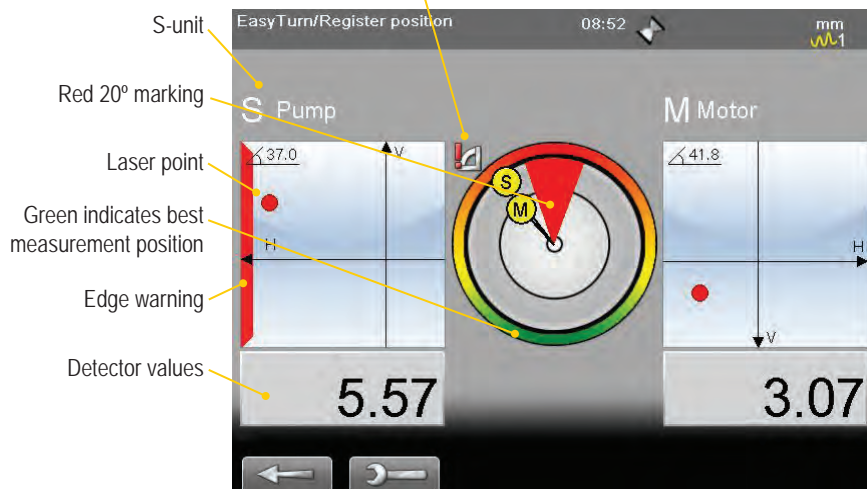
1. Mount the measuring units.
2. Enter distances, confirm each distance with .
3. If needed, perform a rough alignment.
4. If needed, perform a Softfoot check.

## Measure

It is possible to measure with as little as 40° spread between the measurement points. However, for an even more accurate result, try to spread the points as much as possible. The colours indicates where the optimum positions to measure are.

1. Adjust laser to the centre of the targets. If needed, adjust the units on the rods, then use laser adjustments knobs.
2. Press  to register first position. The first position is automatically set to zero. A red marking is displayed.
3. Turn shafts outside of the red 20° marking.
4. Press  to register second position.
5. Turn shafts outside of the red markings.
6. Press  to register third position. The Result and adjust view displayed.








Angle warning. Shown if the angle between M and S is greater than 2 degrees.



### Edge warning

When the laser beam is close to the edge, the edge is "lit up" as a warning. It is not possible to register values when you see the edge warning.


## Function buttons

	<b>Back.</b> Measure previous position or back to Distance view.
	See "Control panel" on page 15.
	 Switch to the EasyTurn™ method.
	 Switch to the 9-12-3 method.
	 Switch to the Horizontal Multipoint method.
	See "SOFTFOOT" on page 47.






# Measure using Multipoint

## Preparations

Follow the preparations as described in the previous pages.

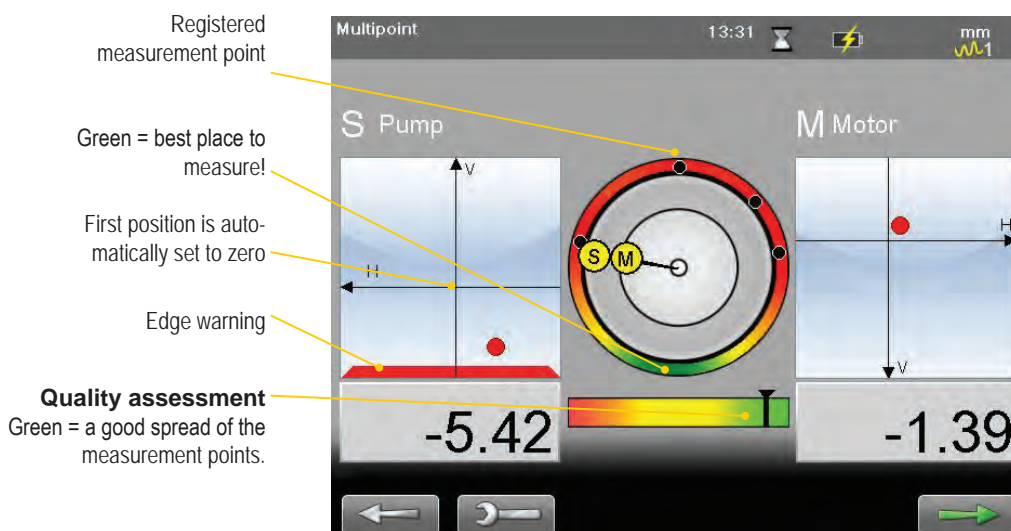
1. Mount the measuring units.
2. Enter distances, confirm each distance with .
3. If needed, perform a rough alignment.
4. If needed, perform a Softfoot check.

## Measure

1. Select  and  to switch to Horizontal Multipoint.
2. Adjust laser to the centre of the targets. If needed, adjust the units on the rods, then use laser adjustments knobs.
3. Press  to register first position. The first position is automatically set to zero.
4. Press  to register as many points as you wish. After three points a result is available.
5. Select  to display the Result and adjust view. See “Result and adjust” on page 39.

### Spread the measurement points









For a more accurate result, try to spread the points as much as possible. The colours indicate where the optimum positions to measure are. The colour bar indicates a statistical accuracy of the measurement.



### Edge warning

When the laser beam is close to the edge, the edge is “lit up” as a warning. It is not possible to register values when you see the edge warning.

### Function buttons

	<b>Back.</b> Measure previous position or back to Distance view.
	See “Control panel” on page 15.
	 Switch to the EasyTurn™ method.
	 Switch to the 9-12-3 method.
	 Switch to the Horizontal Multipoint method.
	See “SOFTFOOT” on page 47.
	Continue to the Result and adjust view. Available after registering three positions with a minimum spread of 40°.

## Quality assessment

*Not available for the US market!*

From the result view, select  and  to show the Quality assessment view

### Attainable accuracy

Many measurement points that also have a good spread, will statistically ensure a high accuracy. This is the same indicator as on the measurement view. If the attainable accuracy is low, try to spread the points as much as possible.

### Acquired accuracy

Actual measured values from the units. If the acquired accuracy is low, it may depend on for example air turbulence or bearing clearance.

### Temperature stability

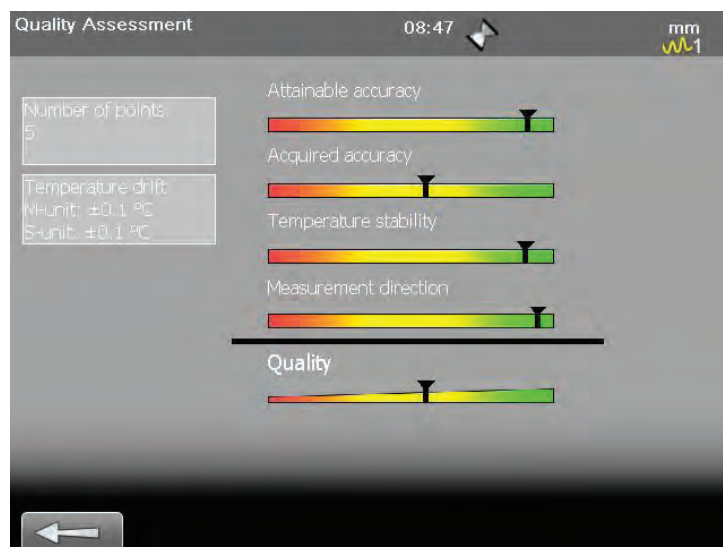
Measured temperature variation in the measuring units. If the stability is low, remeasure when the temperature has stabilized.

### Measurement direction

Indicates if you have changed measurement direction. It is better to move the measurement units in the same direction.

### Quality assessment


A sum of the four quality factors. Also available in the pdf report.








# Measure using 9-12-3

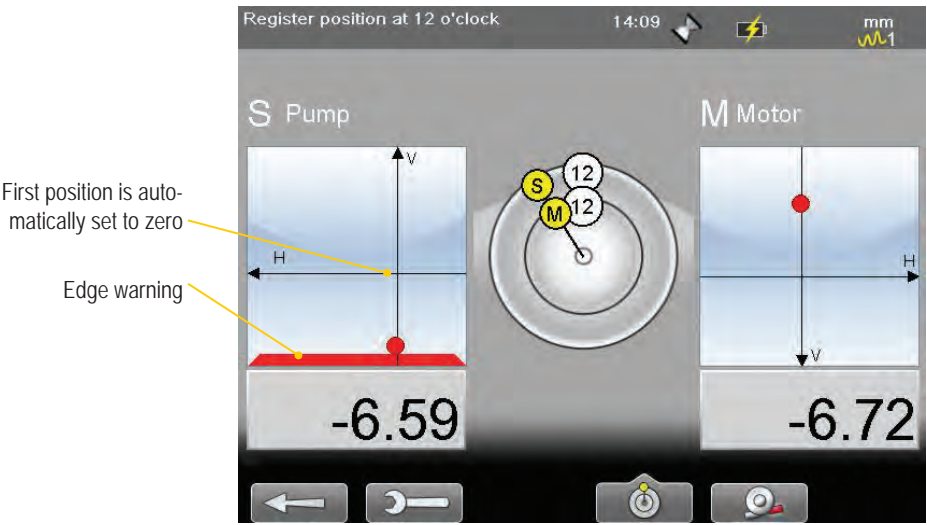
## Preparations

Follow the preparations as described in the previous pages.

- 1. Mount the measuring units.
- 2. Enter distances, confirm each distance with .
- 3. If needed, perform a rough alignment.
- 4. If needed, perform a Softfoot check.








## Measure

- 1. Select  and  to switch to 9-12-3.
- 2. Adjust laser to the centre of the targets. If needed, adjust the units on the rods, then use laser adjustments knobs.
- 3. Turn shafts to 9 o'clock.
- 4. Press  to register first position. The first position is automatically set to zero.
- 5. Turn shafts to 12 o'clock.
- 6. Press  to register second position.
- 7. Turn shafts to 3 o'clock.
- 8. Press  to register third position. The Result and adjust view is displayed. See “Result and adjust” on page 39.



**Edge warning**  
When the laser beam is close to the edge, the edge is “lit up” as a warning. It is not possible to register values when you see the edge warning.

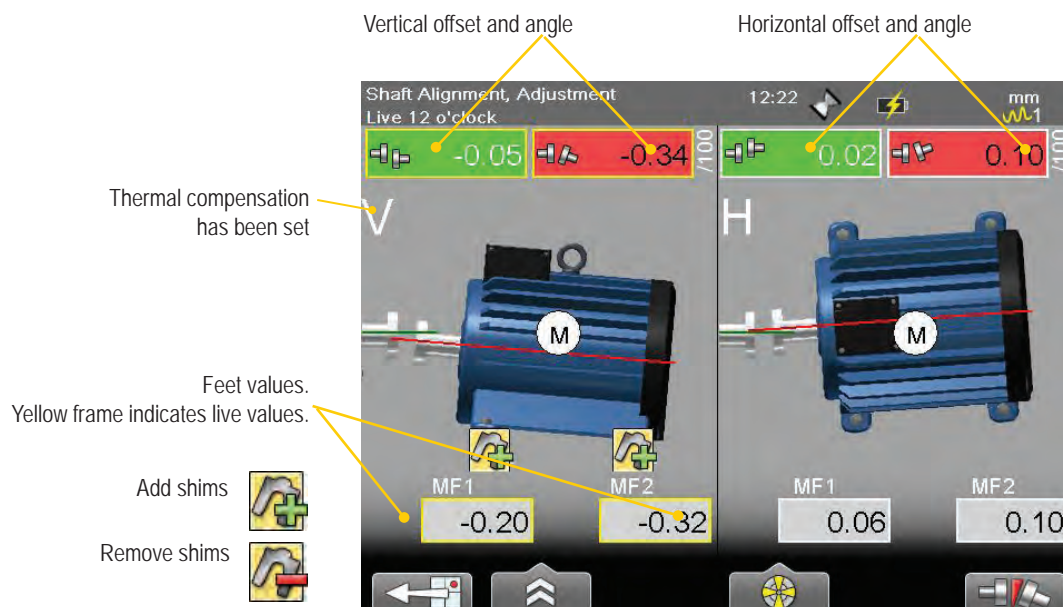
## Function buttons

	<b>Back.</b> Measure previous position or back to Distance view.
	See “Control panel” on page 15.
	 Switch to the EasyTurn™ method.
	 Switch to the 9-12-3 method.
	 Switch to the Horizontal Multipoint method.
	See “SOFTFOOT” on page 47.



# Result and adjust

Offset, angle and feet values are clearly displayed. Both horizontal and vertical direction are shown live, which makes it easy to adjust the machine. Values within tolerance are green.



## Function buttons

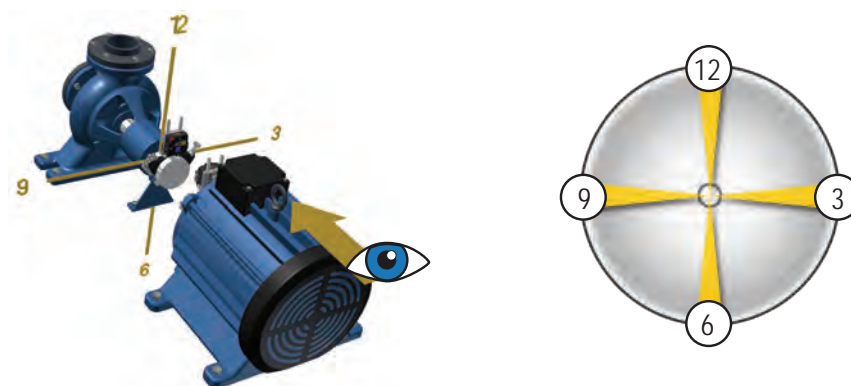
	Back to measure view.
	See "Control panel" on page 15. Save, see "Measurement file handling" on page 11. See "Tolerance" on page 45. See "Thermal compensation" on page 43. Show target. This is a quick way to see where the laser beam hits the target and how the measuring units are positioned. Print report on thermal printer (optional equipment). Available when you open a saved measurement. <b>Edit distances.</b> Press  to confirm changes. The result is recalculated. See "Quality assessment" on page 37. Result table. See "Result table" on page 42.
	RefLock, lock feet. <i>Note! Not available for E420.</i>
	See "Live values" on page 40. Toggle button. Show/hide Position indicator. See "Position indicator" on page 41.
	Toggle button. Switch between to show gap and show angular error per 100 mm. For this to work you need to set the coupling diameter.

## Live values

When reading the values, face the stationary machine from the movable machine.

Positions for measuring units as seen from the movable machine.

Live values are marked with yellow frame.



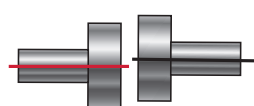
Face the stationary machine (S) from the movable machine (M). Then 9 o'clock is to the left, as in the measuring programs.

## Offset and angle values

The offset and angle value indicate how well the machine is aligned at the coupling.

They appear in both horizontal and vertical direction.

*These values are important to get within tolerance.*

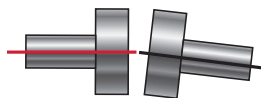


### Offset

The centre lines of two axis are not concentric but parallel.

This is measured at the coupling centres.

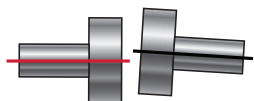
In this example, a positive offset is shown.



### Angular misalignment

The centre lines of two axis are not parallel.

In this example, a negative angle is shown.



### Offset and angular misalignment

Misalignment is often a combination of both offset and angular misalignment.

## Show live values for EasyTurn™ and Multipoint

The inclinometer can be used to show live values at all angles.



Show live values at any angle.



Inclinometer controls when to show live values.

## Show live values for 9-12-3

The inclinometer is not used. You can manually show in which position your measurement units are.

Select  to show the live options.



Force live to 6 o'clock.



Force live to 12 o'clock.



Force live to 3 o'clock.




Force live to 9 o'clock.




## Adjust

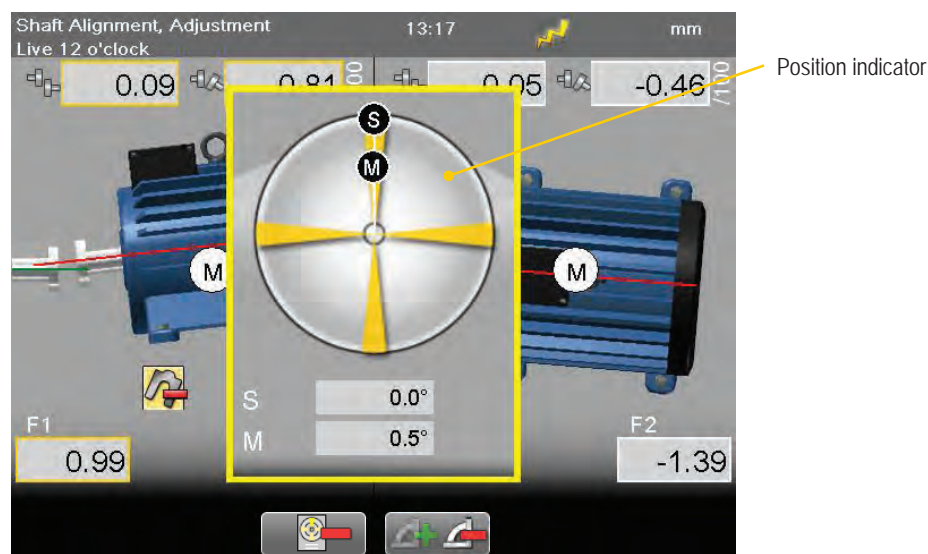
Adjust the machine if needed.

1. Shim the machine according to the vertical feet values.
2. Adjust the machine sideways according to the live horizontal values.
3. Tighten the feet.
4. Select  to remeasure.






### Position indicator

To adjust, you need to place the measuring units in live position (9, 12, 3 or 6 o'clock).

Select  to show the Position indicator.






### Function buttons



	Toggle button. Show/hide position indicator manually.
	
	Toggle button. Select  to display the position indicator automatically when you move the measuring units.
	

## Result table

With the result table, you can measure the same coupling several times and document the results.



1. Measure using Easy-Turn, 9-12-3 or Multipoint.
2. Go to the Result view.
3. Select  to remeasure the coupling. Remeasure as many times as needed.
4. Go to Result view and select  and  to open the result table.

Once you have opened the result table, the information will also be included in the report. The three latest measurements are visible. If you have more, use the navigation buttons to scroll.

Result table 09:30  mm  5

#	Vertical		Horizontal		Note
	Offset	Angle	Offset	Angle	
1	0.13	0.08	-0.01	0.16	As found 1.
2	0.21	0.10	-0.02	0.15	
3	0.23	0.11	-0.02	0.15	

The table is shown in the report

 Remove the table from the report  
 Edit note

Angle or Gap is displayed.




Add notes to the measurements

The three latest measurements are visible.  
No live values are visible in the report.





#	Vertical		Horizontal		Note
	Offset	Gap	Offset	Gap	
1	0.13	0.05	-0.01	0.11	As found 1.
2	0.21	0.07	-0.02	0.10	
3	0.23	0.07	-0.02	0.10	
4	0.22	0.07	-0.02	0.10	
5	0.17	0.06	-0.02	0.10	

The table is included in the report

### Add a note

1. Select a measurement.
2. Select  or  to write or edit a note.
3. Press  to save the note.

### Function buttons

	Toggle button. Show/hide the result table in the report.
	
	Add (or edit) a note for the selected measurement.
	Delete the selected measurement.

## Save

You can save a measurement and open it later to continue to measure. When you save the measurement again, it will **not** overwrite the earlier version.

When you save a measurement, a pdf is automatically generated.

See "Measurement file handling" on page 11.

# Thermal compensation

During normal operation, machinery is influenced of different factors and forces. The most common of these changes is the change in the temperature of the machine. This will cause the height of the shaft to increase. This is called thermal growth. To compensate for thermal growth, you enter values for cold condition compensation.

Select  and  from the result and distance view. The Thermal compensation view is displayed.

## Example

It can be necessary to place the cold machine a bit lower to allow thermal growth. In this example we assume a thermal growth of +5mm in **HOT** condition. Therefore we compensate with -5mm in **COLD** condition.

1 Before thermal compensation.

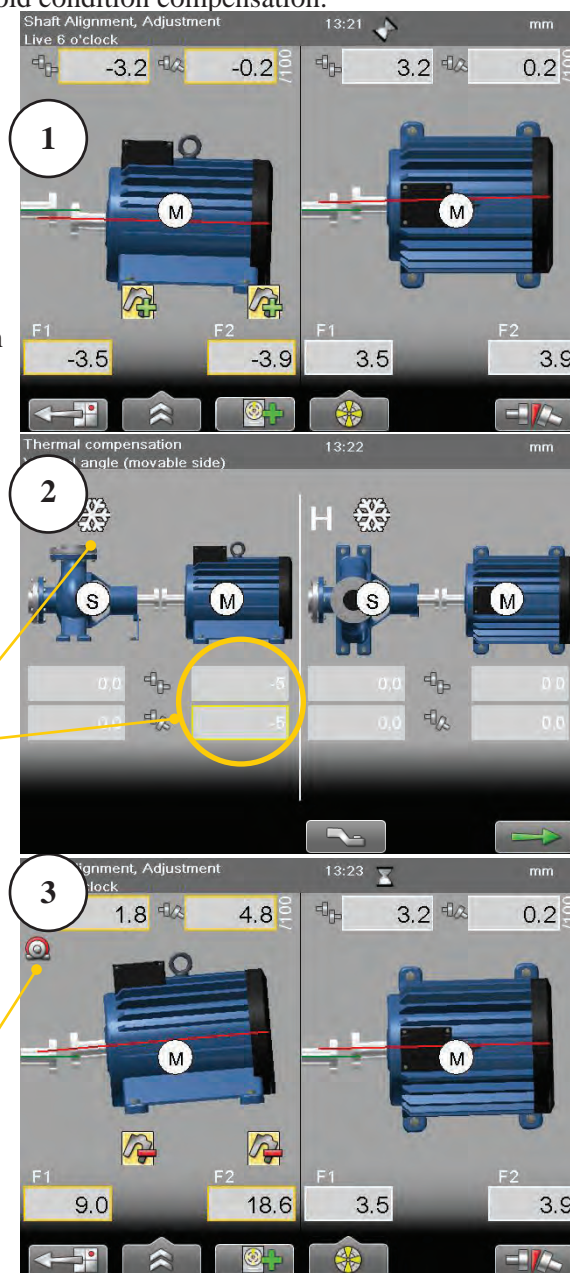
2 Set thermal compensation.

Indicates that the compensation values are set for cold (offline) condition.


Vertical offset and angle for movable machine.

3 Thermal compensation set. When you have set thermal compensation and return to the result view, the values have changed. When the machine becomes warm, the thermal growth will make it perfectly aligned.

Indicates that thermal compensation has been set

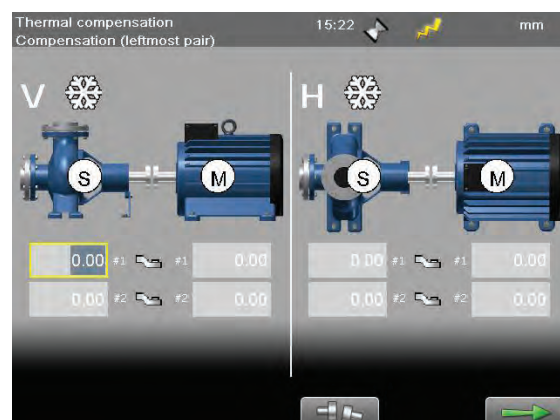


## Feet values

1. On the distance view, enter distances for the S-machine.
2. Select .
3. Set thermal compensation values based on feet values. The coupling values are recalculated. If there are more than two feet pairs, you enter values for the first and last feet pair.






### Note!

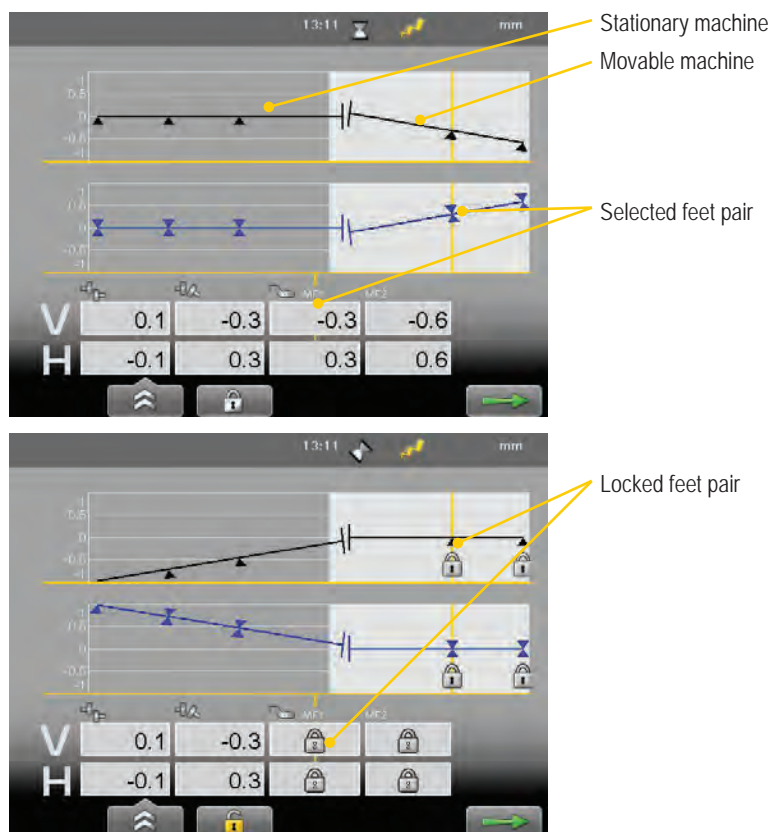
Only the coupling values are visible in the PDF report and the printed report.



# RefLock™

From the result view, you can select the function RefLock™. Here you can choose any two feet pairs as locked and thus choose which machine is to be used as stationary and which as adjustable. If you want to lock feet pair on the stationary machine, you need to enter distances.

1. Select  and .
2. The RefLock graph view is displayed. Navigate using the left and right navigation button.
3. Select  to lock the selected feet pair or  to unlock.
4. Select  to continue to the result view.

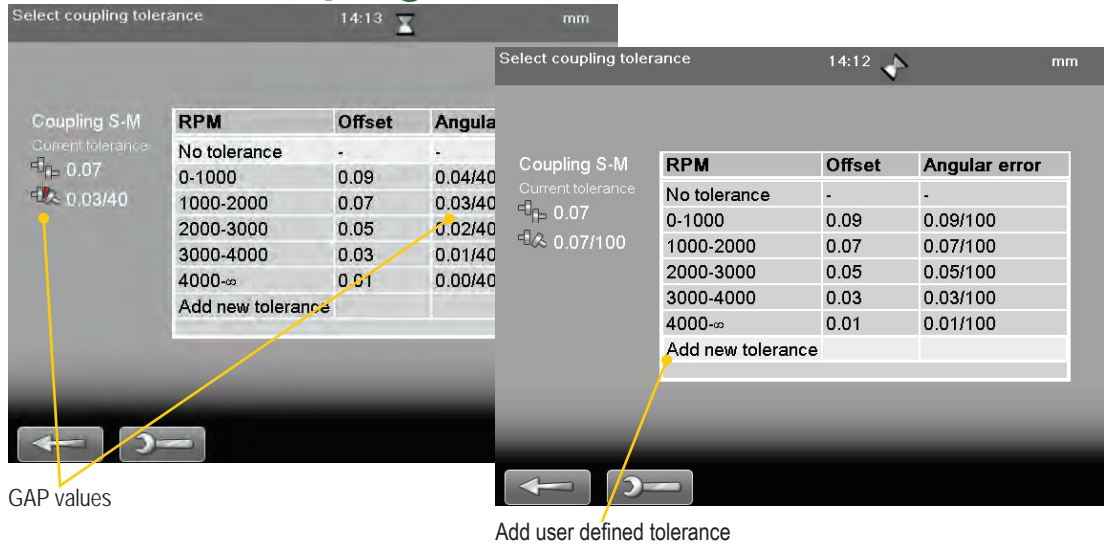


## Note!





RefLock™ is available when using the program Horizontal. Not available for programs Vertical or Cardan.

# Tolerance

1. Select  and . The tolerance window is displayed.
2. Select a tolerance and press .





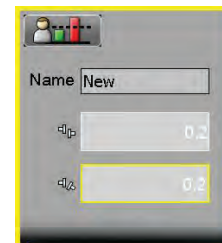
## Function buttons

	Close Tolerance view.
	See "Control panel" on page 15.
	Edit user defined tolerance.
	Delete user defined tolerance.

## Add new tolerance

You can add your own user defined tolerance.

1. Select the row "Add new tolerance". Press .
2. Enter name and tolerance.
3. Press . The new tolerance is added to the list.



## Tolerance in result views

The tolerances are clearly displayed in the result views.

Green = within tolerance

Red = not within tolerance



## Tolerance table

The rotation speed of the shafts will decide the demands on the alignment. The table on this side can be used as a guidance if no other tolerances is recommended by the manufacturer of the machines.

The tolerances is set to the maximum allowed deviation from accurate values, with no consideration to if that value should be zero or compensated for thermal growth.

### Offset misalignment

rpm	Excellent		Acceptable	
	mils	mm	mils	mm
0000-1000	3.0	0.07	5.0	0.13
1000-2000	2.0	0.05	4.0	0.10
2000-3000	1.5	0.03	3.0	0.07
3000-4000	1.0	0.02	2.0	0.04
4000-5000	0.5	0.01	1.5	0.03
5000-6000	<0.5	<0.01	<1.5	<0.03

### Angular misalignment

rpm	Excellent		Acceptable	
	mils/''	mm/100mm	mils/''	mm/100mm
0000-1000	0.6	0.06	1.0	0.10
1000-2000	0.5	0.05	0.8	0.08
2000-3000	0.4	0.04	0.7	0.07
3000-4000	0.3	0.03	0.6	0.06
4000-5000	0.2	0.02	0.5	0.05
5000-6000	0.1	0.01	0.4	0.04

The higher the rpm of a machinery is, the tighter the tolerance must be. The acceptable tolerance is used for re-alignments on non-critical machinery. New installations and critical machines should always be aligned within the excellent tolerance.

### **Note!**

*Consider these tables as guidelines. Many machines must be aligned very accurately even if they have a lower rpm. For example gearboxes.*

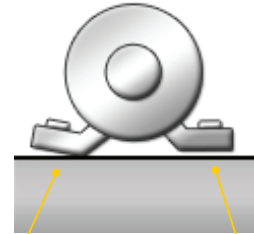
# SOFTFOOT



Perform a softfoot check to ensure that the machine is resting evenly on all its feet. A softfoot can be angular and/or parallel, see image.

Softfoot can be caused by:




- Twisted machinery foundations.
- Twisted or damaged machinery feet.
- Improper amount of shims under machine feet.
- Dirt or other unwanted materials under machine feet.







Angular softfoot

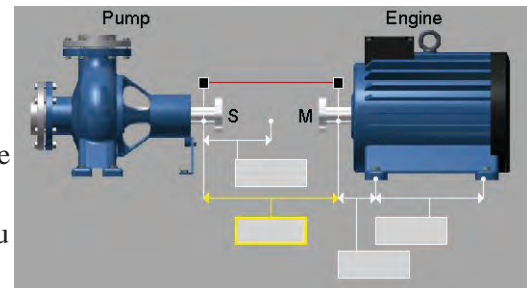
Parallel softfoot

## Start Softfoot from main shaft menu









1. Select  and .
2. Enter distances. Select “Custom” if you want to select other machine images and/or more than three feet pair.
3. Select  to continue.

## Start Softfoot from Horizontal program

1. Select  and  to open Horizontal program.
2. Enter distances. Confirm each distance with . To perform a Softfoot check, you need to enter distances between the feet pairs. The measure view is displayed.
3. Select . Softfoot is only available before you have registered any measurement points.



## Function buttons

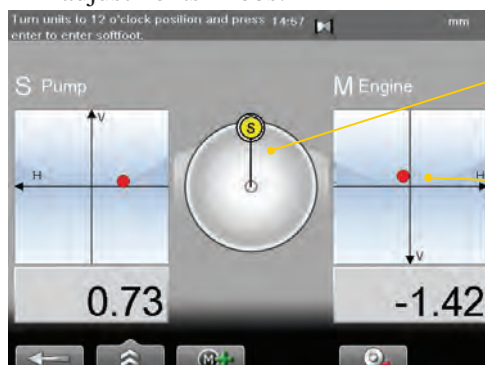
	Leave program.
	 See "Control panel" on page 15.
	Enter distance for S-machine. Makes it possible to perform a soft-foot measurement on the S-machine.
	Toggle between 3D and 2D view.
	Add a feet pair. Only available for E530. In E710 you select machines and optional number of feet when you select custom.
	Toggle button. Show movable machine to the left or the right.
	Continue to Measure view. Available when you have entered the distances.

## Filter

When you measure Softfoot, the detector filter is increased by three steps (maximum to filter 7). If you measure with a higher filter than 7, that filter will remain. When the Softfoot measurement is done, the filter is restored.

## Measure softfoot

1. Tighten all feet bolts.
2. Turn the measuring units to 12 o'clock.
3. Adjust laser to the centre of targets. If needed, adjust the units on the rods, then use laser adjustments knobs.



Turn the measuring units to 12 o'clock.

Adjust laser point to centre of target.

4. Press . The Softfoot measure view is displayed. The first bolt is marked with yellow.
5. Loosen and then retighten the first bolt.
6. Press to register value.
7. Register values on all four feet. The result is displayed.
8. Shim the foot with the largest movement.
9. Do a Softfoot check again.

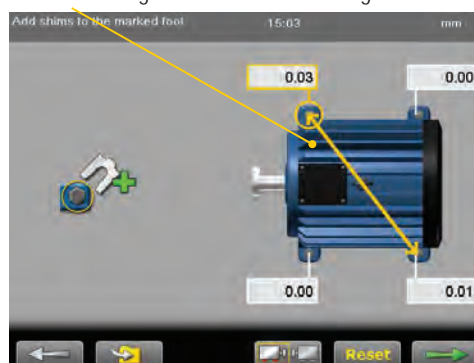
### Measure:

Loosen and retighten bolt before register value.



### Result:

Arrow indicating that the machine is tilting in this direction.



### Note!

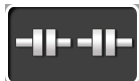
*If the largest movement is opposite from the smallest it is not a conventional softfoot and you will be asked to check the foundation.*

## Function buttons

	Leave Softfoot.
	See "Control panel" on page 15.
	Save. Only available when you have started Softfoot from the main menu.
	Zero value of selected foot.
	Toggle button to switch machine. To check Softfoot, distances between feet pairs are necessary. If needed, the Enter distance view is displayed. <i>Not available for E420.</i>
	Remeasure Softfoot.
	Continue to Measure view, only available when you have started Softfoot from the program Horizontal.

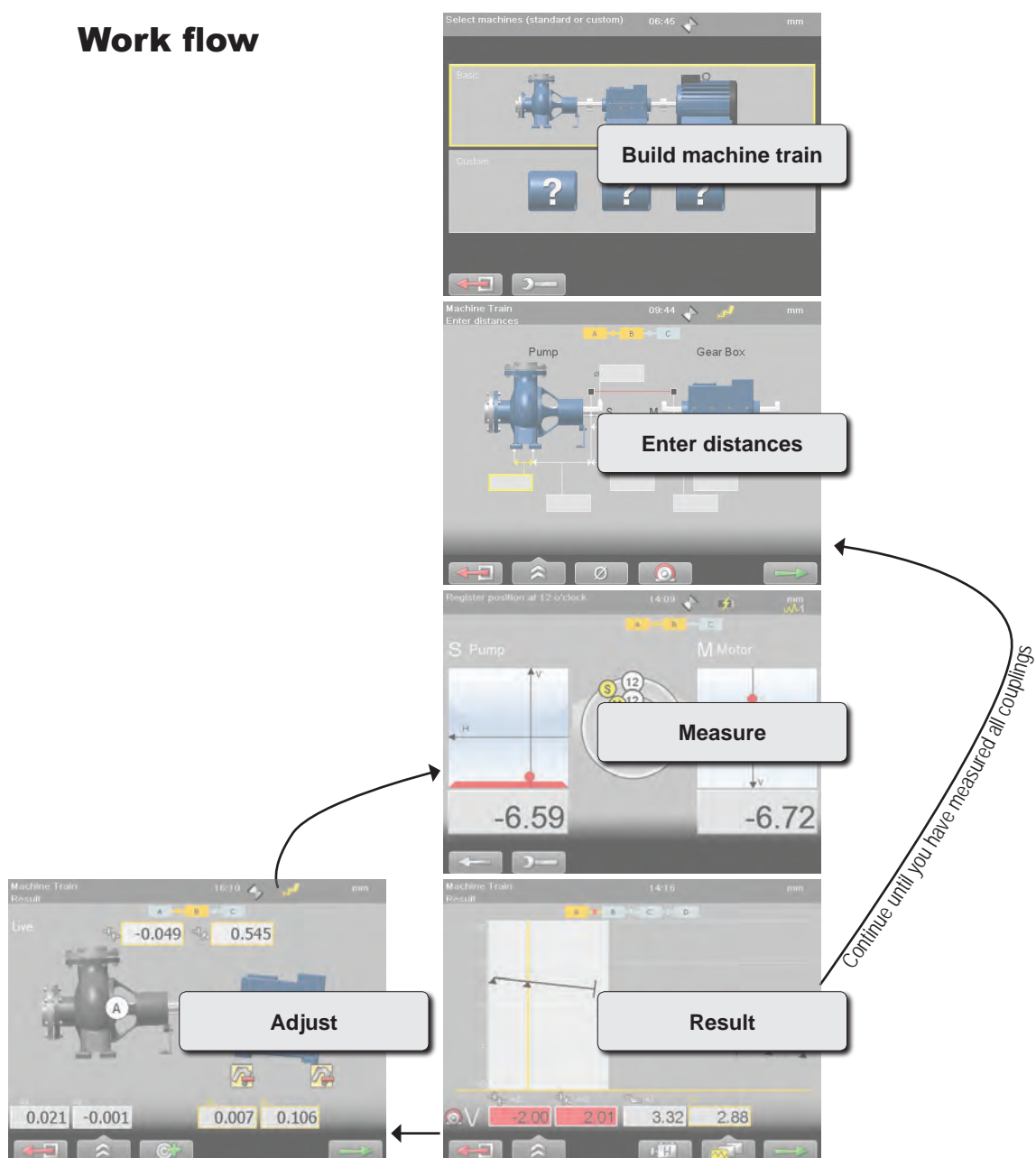


# MACHINE TRAIN




Use for machines mounted in a train with two or more couplings.

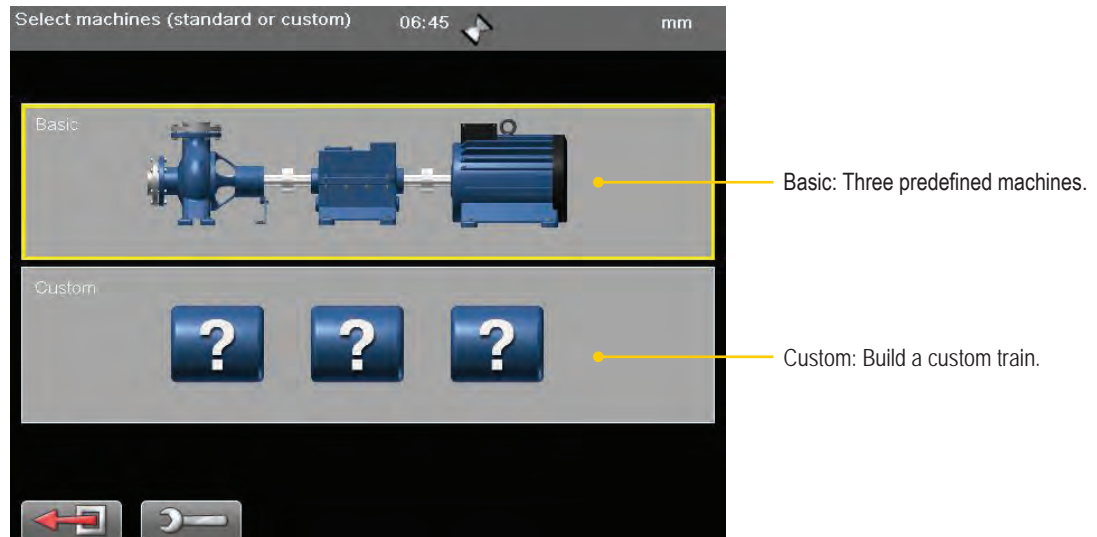
## Work flow



# Build machine train

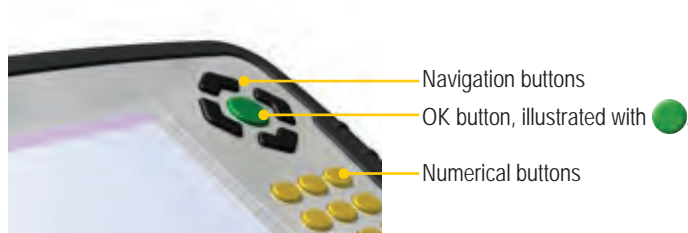
Before measuring your machines, you need to define what kind of machines you have.

1. Use navigation buttons to select Basic or Custom.
2. Press .



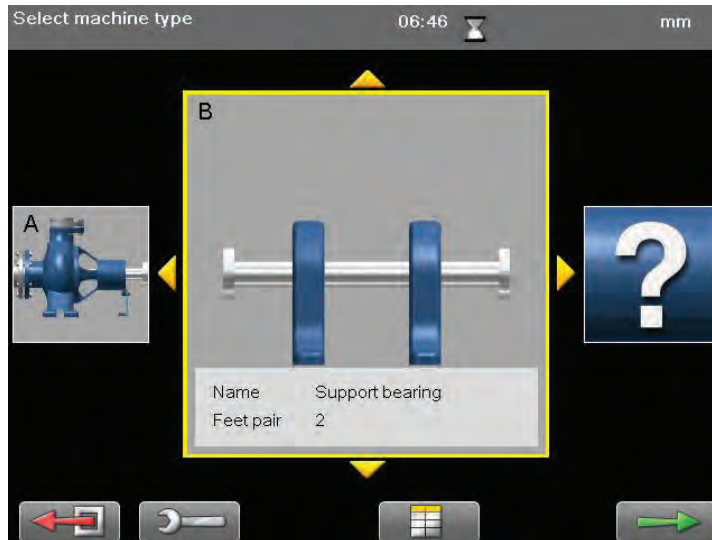
## Basic

The basic machine train contains a pump, a gearbox and a motor. These three predefined machines all have two feet pair each.



## Custom

Select this option if you want to build a custom machine train. You build the train from left to right. There are several machine types to choose from and you can add as many as you need to your machine train. You can also define as many feet pairs as you need on the machines.

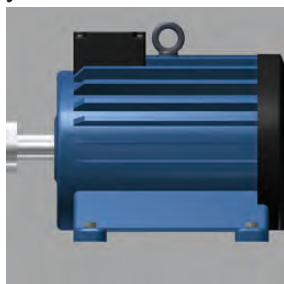


### Select machine

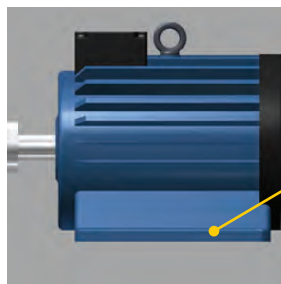
1. Use navigation buttons up and down to find the machine you want.
2. Press . The next machine becomes active.
3. Add as many machines as you need. When you are done, select to continue to Measure view.

### Select number of feet pair

If you want to change the number of feet pair on the machine, simply enter the number you want on the numerical buttons.



Machine with two feet pairs



More than three feet pairs are visualized as one solid foot on the machine.

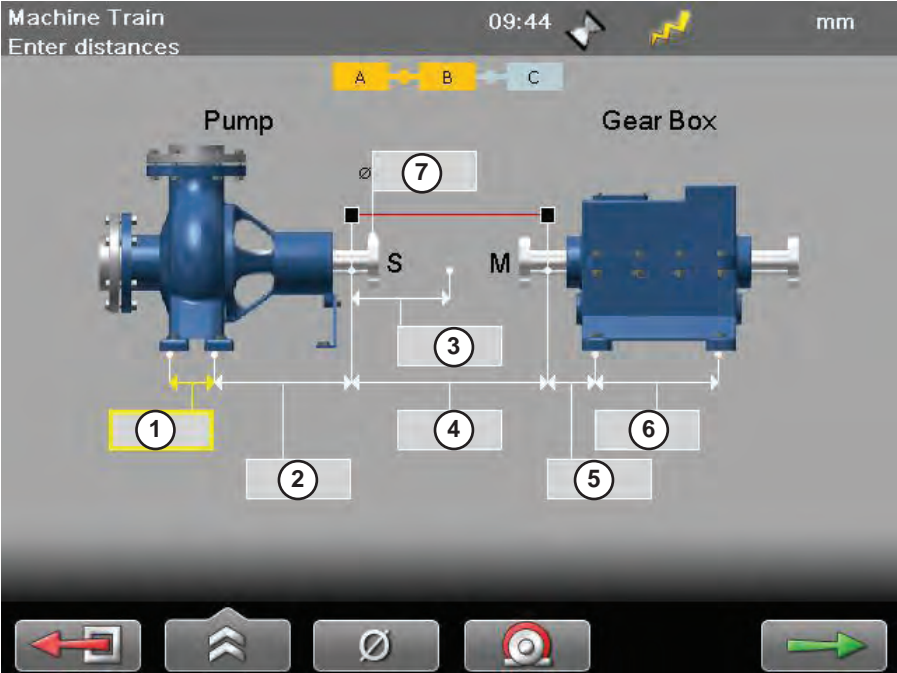
### Build train table


Select to open a table view. In this table you can rename the machines and change the number of feet pairs.

#	Name	Feetpair
1	Engine	2
2	New gearbox.	2
3	Support bearing	2
4	Gear Box	3








# Enter distances

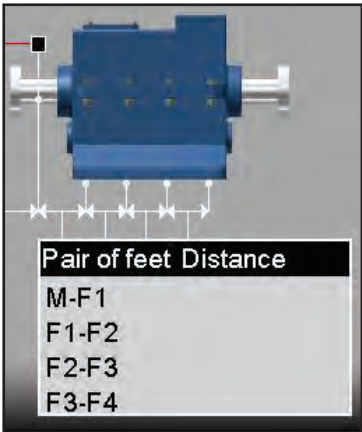
Confirm each distance with .



- ① Distance between first and second feet pair.
- ② Distance between second feet pair and S-unit.
- ③ Distance between S-unit and centre of coupling.
- ④ Distance between S-unit and M-unit. Measure between the rods.
- ⑤ Distance between M-unit and feet pair one.
- ⑥ Distance between feet pair one and feet pair two.
- ⑦ Coupling diameter. Optional, select  to activate field.

## Function buttons






	Leave program.
	 See “Control panel” on page 15.
	 See “Tolerance” on page 62.
	 See “Thermal compensation” on page 43.
	<b>Diameter.</b> Select to enter coupling diameter. This is necessary if you want the result based on the gap of the coupling instead of angle.
	Continue to Measure view.

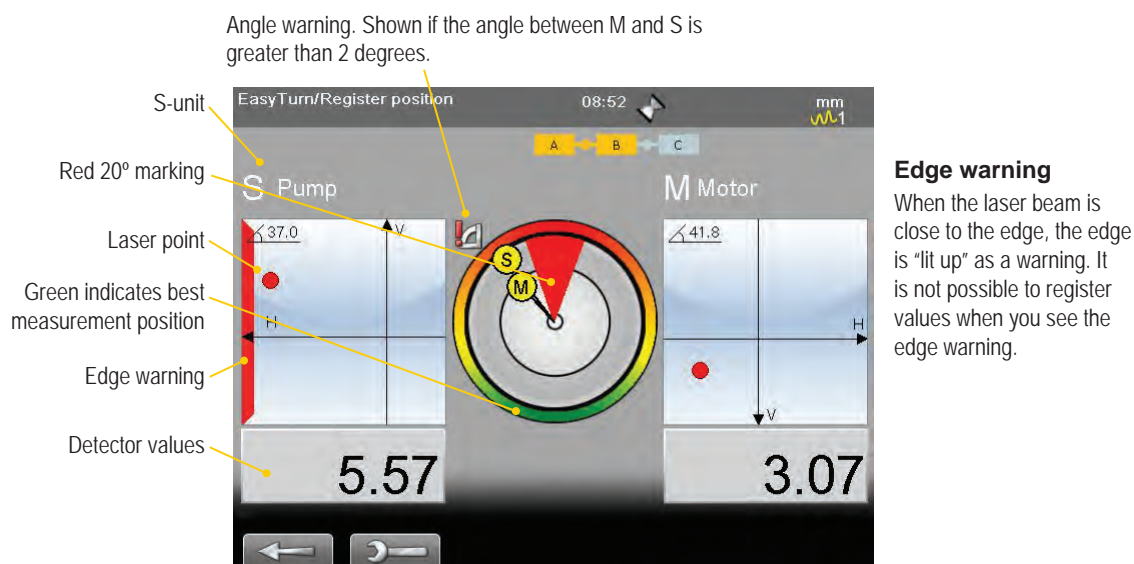


When there are more than three feet pairs, a table is displayed where you enter the distances.








# Measure using EasyTurn™

It is possible to measure with as little as 40° spread between the measurement points. However, for an even more accurate result, try to spread the points as much as possible. The colours indicates where the optimum positions to measure are.








1. Adjust laser to the centre of the targets. If needed, adjust the units on the rods, then use laser adjustments knobs.
2. Press  to register first position. The first position is automatically set to zero. A red marking is displayed.
3. Turn shafts outside of the red 20° marking.
4. Press  to register second position.
5. Turn shafts outside of the red markings.
6. Press  to register third position. The Result and adjust view displayed.
7. The result is displayed. You can show the result as graph, table or machine view.  
*See chapter Result.*
8. From the result view, select  to measure next coupling. If you want to adjust the coupling, select the machine you want to adjust and press . *See chapter Adjust.*



## Function buttons

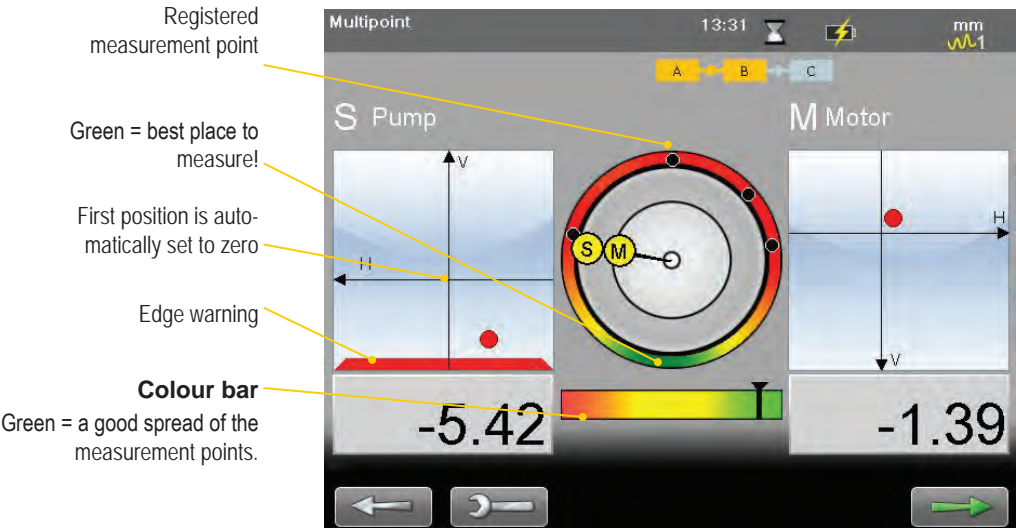
	<b>Back.</b> Measure previous position or back to Distance view.
	See "Control panel" on page 15.
	 Switch to the EasyTurn™ method.  Switch to the 9-12-3 method.  Switch to the Horizontal Multipoint method.
	See "SOFTFOOT" on page 47.

# Measure using Multipoint

- 1. Select  and  to switch to Horizontal Multipoint.
- 2. Adjust laser to the centre of the targets. If needed, adjust the units on the rods, then use laser adjustments knobs.
- 3. Press  to register first position. The first position is automatically set to zero.
- 4. Press  to register as many points as you wish. After three points a result is available.
- 5. Select  to display the Result and adjust view. You can show the result as graph, table or machine view. See “Result” on page 56.
- 6. From the result view, select  to measure next coupling. If you want to adjust the coupling, select the machine you want to adjust and press . See “Adjust” on page 60.

## Spread the measurement points









For a more accurate result, try to spread the points as much as possible. The colours indicates where the optimum positions to measure are. The colour bar indicates how statistical accurate the measurement is.



### Edge warning






When the laser beam is close to the edge, the edge is “lit up” as a warning. It is not possible to register values when you see the edge warning.

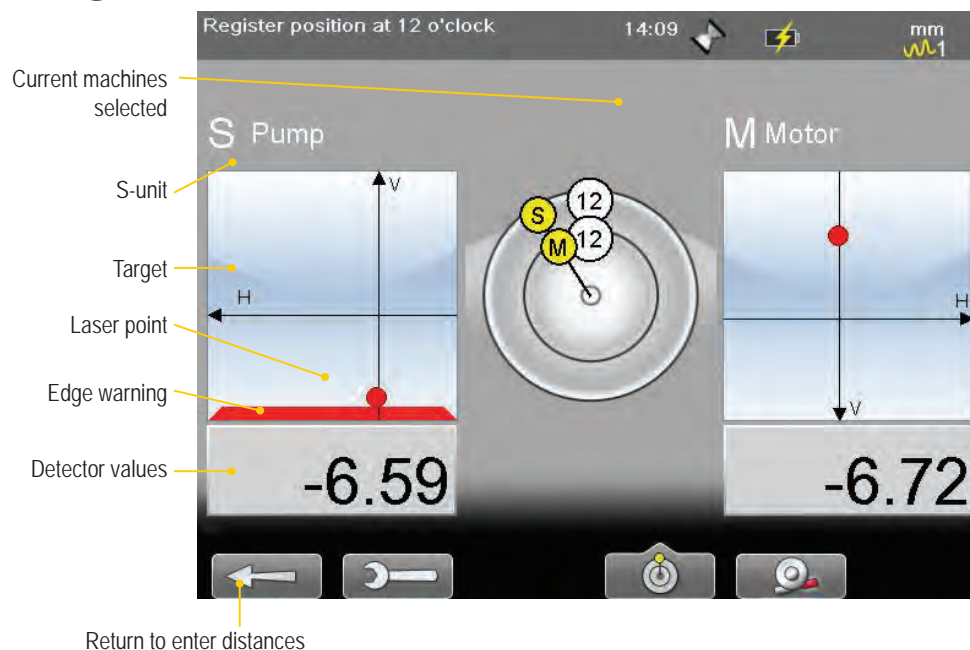
## Function buttons



	<b>Back.</b> Measure previous position or back to Distance view.
	See “Control panel” on page 15.
	 Switch to the EasyTurn™ method.
	 Switch to the 9-12-3 method.
	 Switch to the Horizontal Multipoint method.
	See “SOFTFOOT” on page 47.
	Continue to the Result and adjust view. Available after registering three positions.










# Measure using 9-12-3

1. Select  and  to switch to 9-12-3.
2. Adjust laser to the centre of the targets. If needed, adjust the units on the rods, then use laser adjustments knobs.
3. Turn shafts to 9 o'clock.
4. Press  to register first position. The first position is automatically set to zero.
5. Turn shafts to 12 o'clock.
6. Press  to register second position.
7. Turn shafts to 3 o'clock.
8. Press  to register third position.



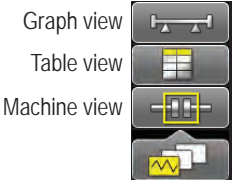
9. The result is displayed. You can show the result as graph, table or machine view.  
See "Result" on page 56.
10. From the result view, select  to measure next coupling. If you want to adjust the coupling, select the machine you want to adjust and press . See "Adjust" on page 60.

## Function buttons

	<b>Back.</b> Measure previous position or back to Distance view.
	See "Control panel" on page 15.
	 Switch to the EasyTurn™ method.
	 Switch to the 9-12-3 method.
	 Switch to the Horizontal Multipoint method.
	Softfoot.



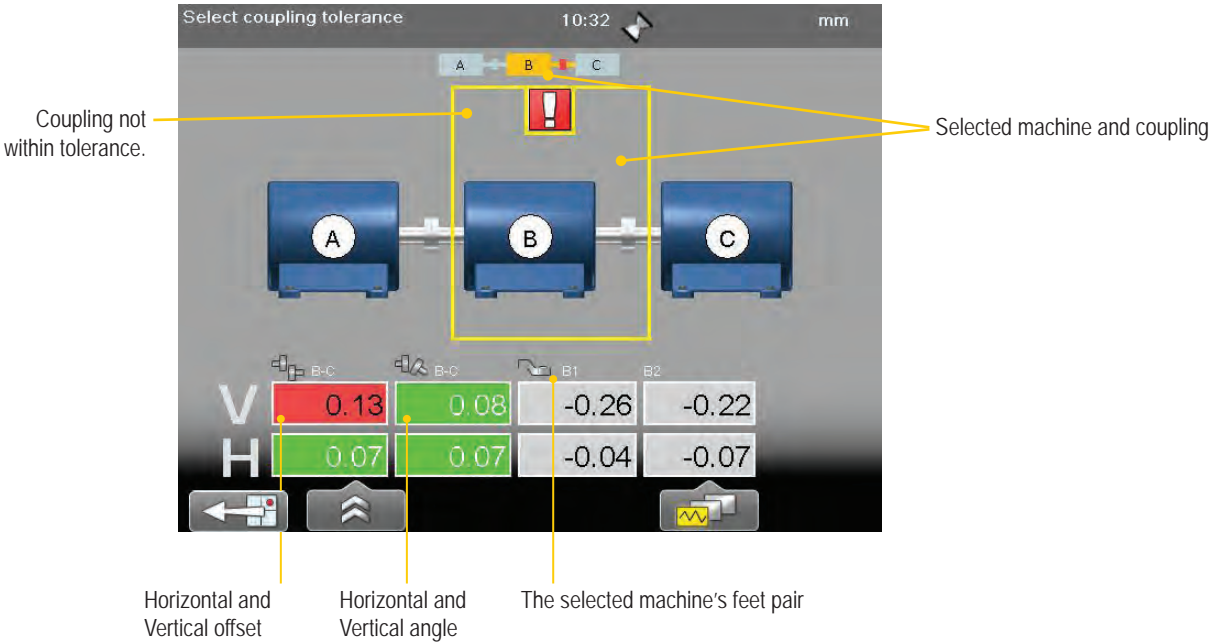
# Result



You can show the result as graph, table or machine view.  
By default the machine view is displayed. Navigate in the result views by using the navigation buttons.

## Result Machine view

Select  and . The Machine view is displayed.















### Feet pair

If there are more than three feet pairs, values are only displayed for the first three pairs in this view. To view values for all feet pairs, switch to Table view.

### Adjust coupling

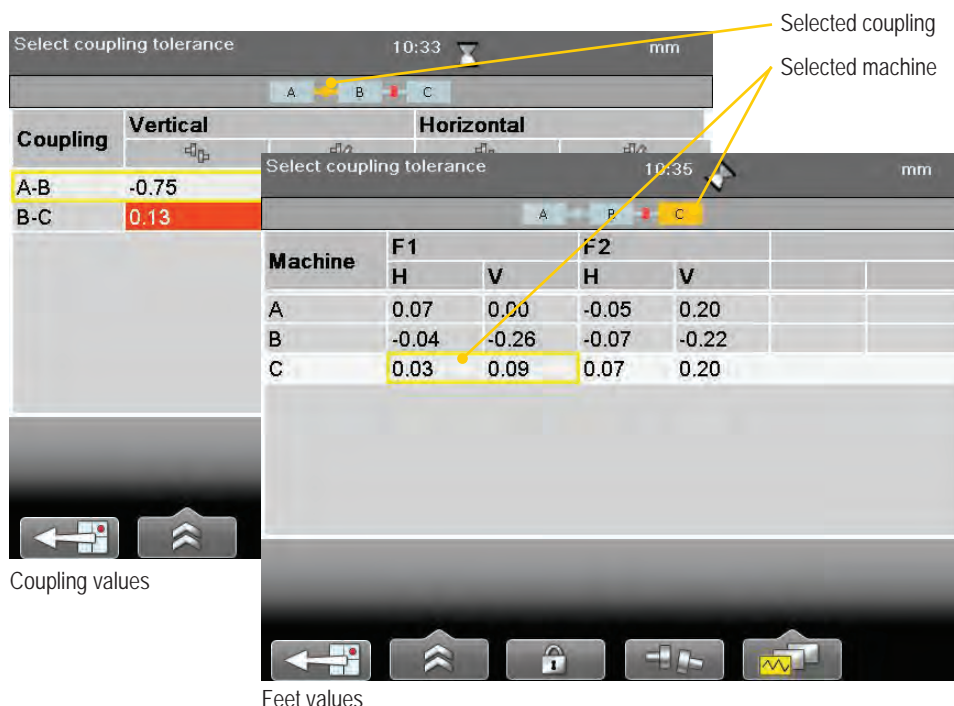
Select the machine you want to adjust and press . See “Adjust” on page 60.

### Function buttons

	Remeasure the coupling. Press and hold to leave program.
	 See “Control panel” on page 15.  <b>Save file.</b> “Measurement file handling” on page 11.  See “Tolerance” on page 62.  See “Thermal compensation” on page 43.  View and edit distance.  <b>Print.</b> “Measurement file handling” on page 11.   Toggle button. Show Gap or Angle values.
	Switch result view.
	Measure next coupling.

## Result Table view

Select  and . The Result Table view is displayed.  
Navigate using the navigation buttons.



The screenshot shows the 'Result Table view' interface. At the top, there's a header bar with 'Select coupling tolerance' and a clock showing 10:33. Below this, a table lists couplings: A-B with a value of -0.75 and B-C with a value of 0.13. To the right, another table lists machines A, B, and C with their respective horizontal (H) and vertical (V) values. A yellow box highlights the values for machine C: H=0.03 and V=0.09. At the bottom, there are navigation buttons and a 'Feet values' label.














Coupling	Vertical
A-B	-0.75
B-C	0.13

Machine	F1		F2	
	H	V	H	V
A	0.07	0.00	-0.05	0.20
B	-0.04	-0.26	-0.07	-0.22
C	0.03	0.09	0.07	0.20

Labels in the image: Selected coupling, Selected machine, Coupling values, Feet values.

## Function buttons

	Remeasure the coupling. Press and hold to leave program.
	 See "Control panel" on page 15.  <b>Save file.</b> "Measurement file handling" on page 11.  See "Tolerance" on page 62.  See "Thermal compensation" on page 43.  View and edit distance.  <b>Print.</b> "Measurement file handling" on page 11.   Toggle button. Show Gap or Angle values.
	Lock / unlock feet pair. Available when you show feet values. See "Lock feet pair" on page 59.
	Toggle between showing feet or coupling values.
	<b>Switch result view.</b>

## Save

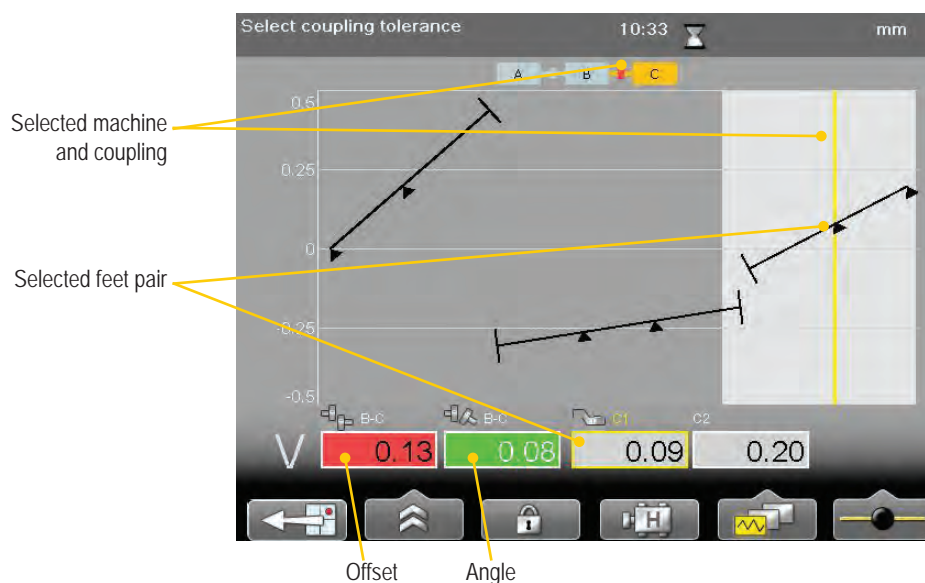
You can save a measurement and open it later to continue to measure. When you save the measurement again, it will **not** overwrite the earlier version.

When you save a measurement, a pdf is automatically generated only when the whole train has been measured.










See "Measurement file handling" on page 11.

## Result Graph view

Select  and . The Graph view is displayed.



### Function buttons

	Remeasure the coupling. Press and hold to leave program.
	See “Result Machine view” on page 56.
	Lock / unlock feet pair. If you can not adjust a feet pair, use the lock function. See “Lock feet pair” on page 59.
	Toggle between showing horizontal or vertical graph.
	<b>Switch result view.</b>
	Available when you have measured the whole train. See “Best fit and Manual fit”.
	<b>Best fit</b>
	<b>Manual fit</b>
	Select to measure next coupling.

## Lock feet pair



This function is available in graph and table view. We recommend that you lock two feet pair to get the most accurate calculated reference line as possible. If you choose to lock only one feet pair, the tilt of the train is maintained and the coupling is offset.


## Best fit and Manual fit

By default, an average best fit is calculated on the measured machine train. This means that the train is tilted to the flattest possible plane. If no feet pairs are locked, the system assumes that all machines are possible to move in all directions. For each coupling that you measure, the best fit is recalculated. When you have made adjustments on a coupling, the best fit is no longer recalculated.


### Manual fit

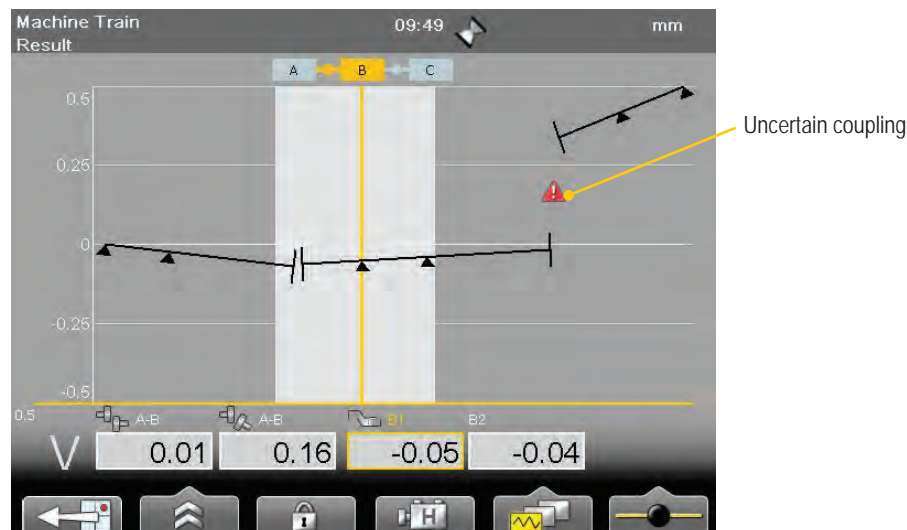
Only available when you have measured the whole train, and only in graph view. Use this function when you know that you for example can move a machine a little in one direction, but not at all in another direction.

1. Select  and  to activate the Manual fit function. If there are locked feet pair, these are unlocked.
2. Use the numerical buttons to move the graph.
  - Buttons 1 and 4 move the left part of the train
  - Buttons 2 and 5 moves the whole train.
  - Buttons 3 and 6 moves the right part of the train.
  - Button -+ will change the scale.

To return to average best fit, select  and .

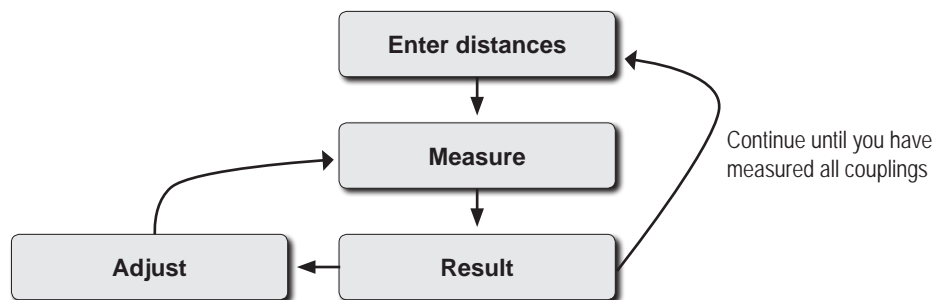
## Uncertain coupling

When you adjust one coupling, it might affect the next coupling in the machine train. In the example below, the coupling A - B has been adjusted, which might have an affect on the coupling B - C. This is indicated with the symbol . When you remeasure or adjust the coupling, the warning is removed.

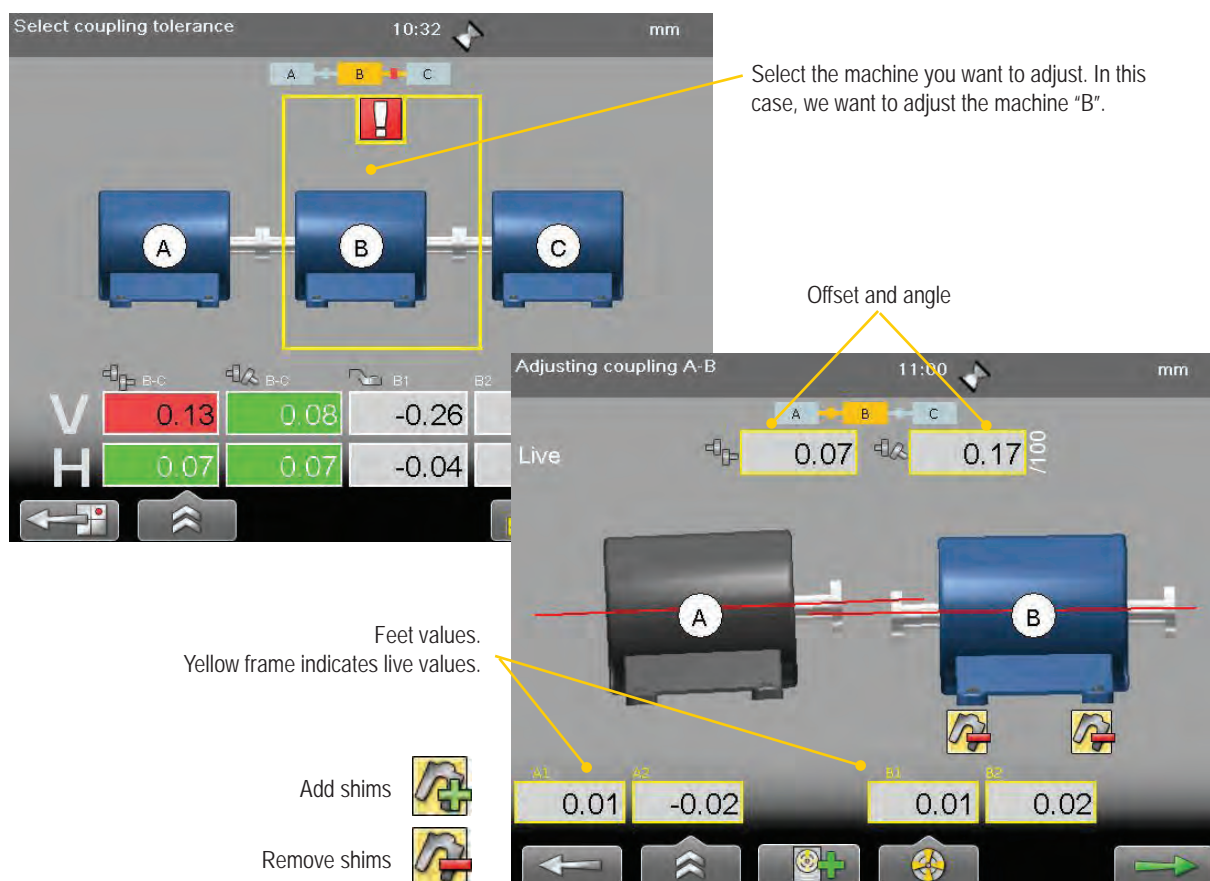


# Adjust






You can adjust a machine even though you have not measured the whole train.



1. Select the machine you want to adjust and press .  
If you just measured the coupling, the Adjustment view is displayed. If not, you need to remeasure the coupling first and the Measure view is displayed.
2. Adjust the machine.
3. Select when you are done. The Measure view is displayed.
4. Remeasure the coupling to confirm the adjustment.



## Function buttons

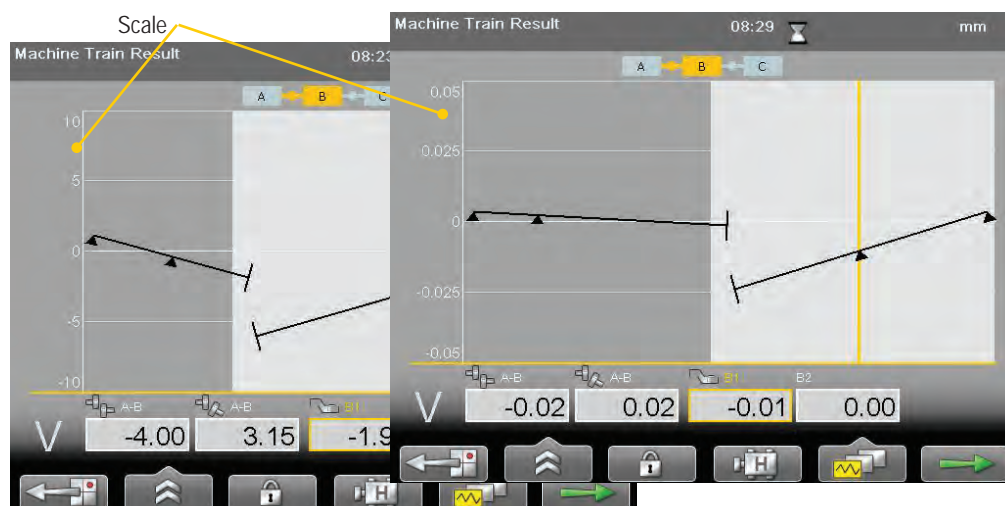
	Back to result view.
	See “Control panel” on page 15.
	Toggle button. Select to show/hide Position indicator. See “Position indicator” on page 41.
	See “Live values” on page 40.
	Continue. You need to remeasure the coupling to confirm the position of the measuring units.

## Uncertain coupling

When you adjust one coupling, it might affect the next coupling in the machine train. This is indicated with the symbol .

## Scale

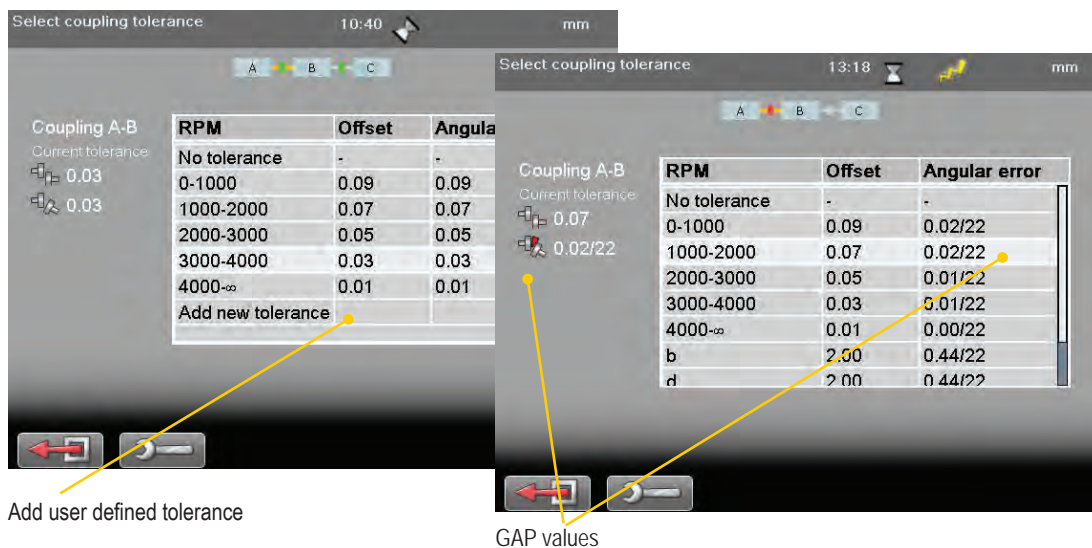
The scale of the graph might change when you have made adjustments.









# Tolerance

1. Select  and . The tolerance window is displayed.
2. Select a tolerance and press . The next coupling in the train is selected.





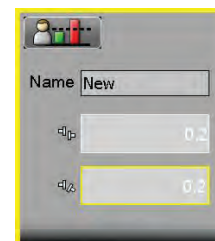
## Function buttons

	Close Tolerance view.
	See “Control panel” on page 15.
	Edit user defined tolerance.
	Delete user defined tolerance.

## Add new tolerance

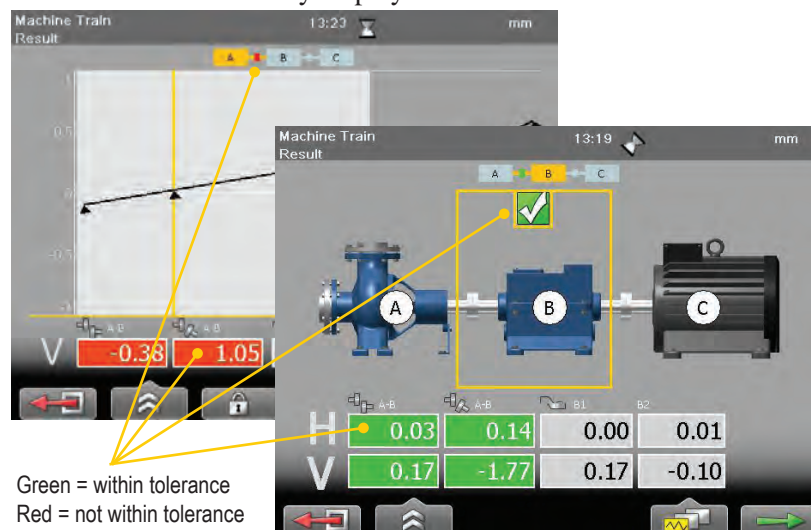
You can add your own user defined tolerance.

1. Select the row “Add new tolerance”. Press .
2. Enter name and tolerance.
3. Press . The new tolerance is added to the list.



## Tolerance in result views

The tolerances are clearly displayed in the result views.





# VERTICAL

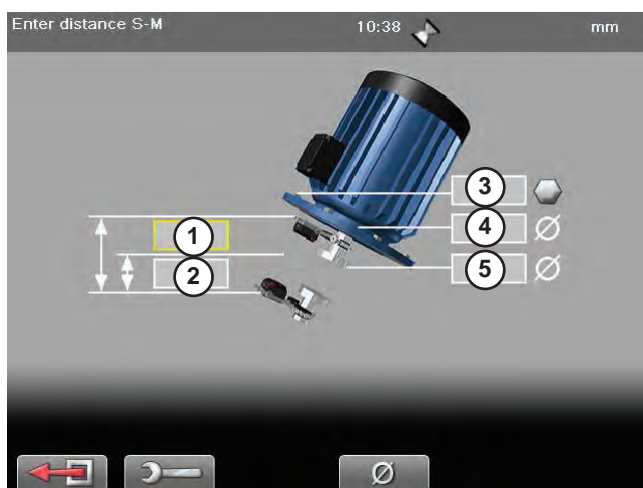


The program Vertical is used for vertical and/or flange mounted machines.

## Preparations

1. Mount the M-unit on the movable machine and the S-unit on the stationary machine.
2. Select and to open Vertical program.
3. Enter distances. Confirm each distance with .

If you have a barcode reader, simply scan the barcode and all machine data is read.  
See “Measurement file handling” on page 11.






- 1 Distance between S-unit and M-unit.  
Measure between the rods. **Mandatory**.
- 2 Distance between S-unit and centre of coupling. **Mandatory**.
- 3 Number of bolts (4, 6 or 8 bolts).
- 4 Bolt circle diameter (centre of the bolts).
- 5 Coupling diameter. Select to activate field.

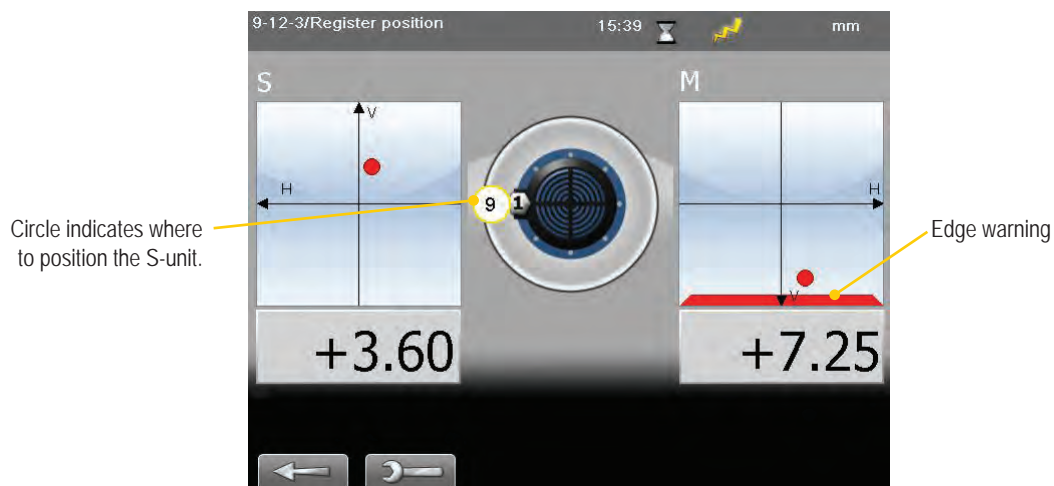
## Function buttons

	Leave program.
	See “Control panel” on page 15.
	Select to enter diameter of coupling.
	Forward to measure view.

## Measure

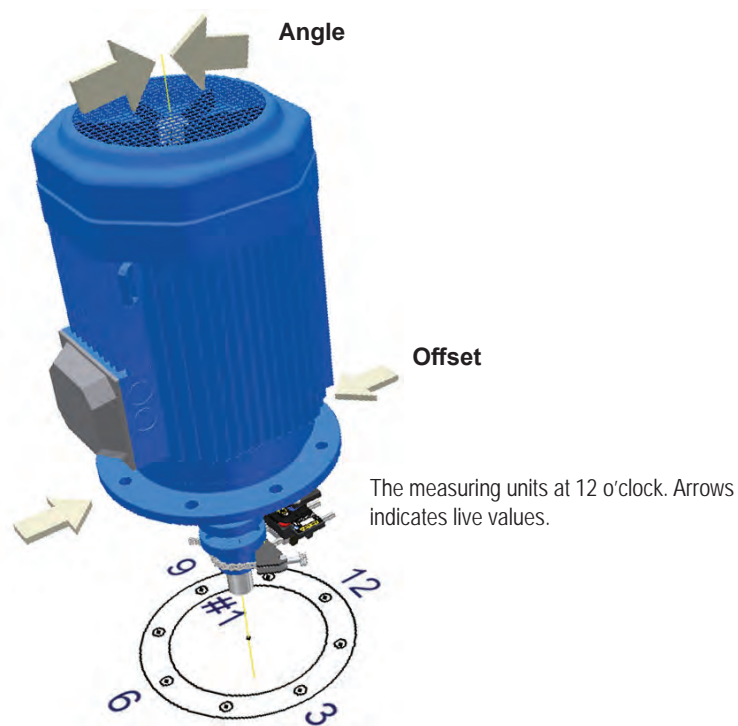
The program Vertical uses the 9-12-3 method.

1. Position the units at 9 o'clock, at bolt number one. Make sure that it is possible to also position the units at 12 and 3 o'clock.
2. Press  to register first position. The first position is automatically set to zero.
3. Turn units to position 12 o'clock.
4. Press  to register position.
5. Turn units to position 3 o'clock.
6. Press  to register position. Measurement result is displayed.



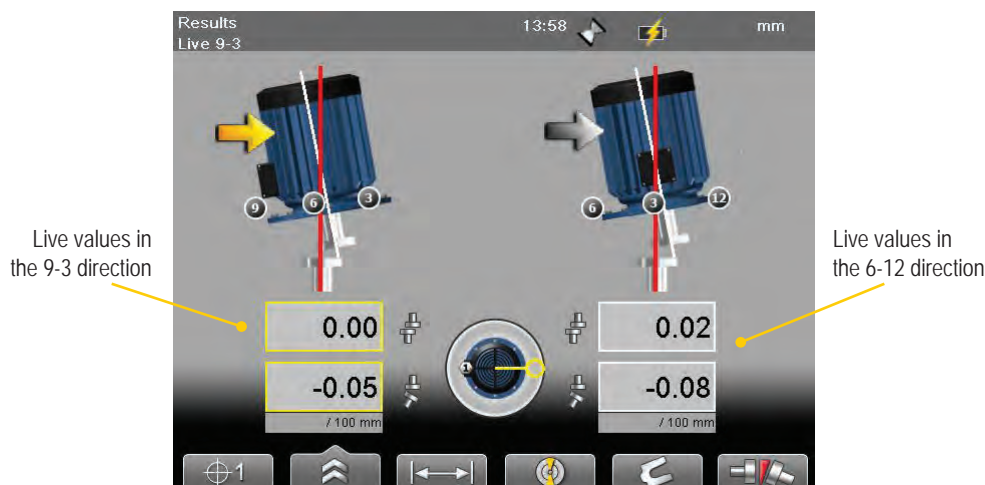
### Edge warning

When the laser beam is close to the edge, the edge is “lit up” as a warning. It is not possible to register values when you see the edge warning.





## Result

The result is displayed as sideways offset in the coupling and angular error between shafts.
















### Live values

The values can be displayed live in two directions:

- Live in the 9-3 direction.  
Select  and position the measuring units at 3 o'clock.
- Live in the 6-12 direction.  
Select  and position the measuring units at 12 o'clock.



### Function buttons

	Back, remeasure from first position.
	 See "Control panel" on page 15.
	Save, see "Measurement file handling" on page 11.
	Set tolerance.
	<b>Show target.</b> This is a quick way to see where the laser beam hits the target and how the measuring units are positioned.
	Print report on thermal printer (optional equipment). Only available when you open a saved measurement.
	Adjust distances. Press  to confirm changes. The result is recalculated.
 	Toggle button. Switch between showing live values in the direction 9-3 or 6-12.
	See "Shim result view" on page 66.
 /100	Toggle button. Switch between to show gap and show angular error per 100 mm. For this to work you need to set the coupling diameter.

## Shim result view

To view this, you need to enter number of bolts and diameter of bolt circle.



1. Select  to open Shim value view. The values are not live.
2. Read values. The highest bolt is calculated as 0.00. Values below zero indicates that the bolt is low and need shimming.
3. Select  to return to Result view.

---

### **Note!**

*If you shim the machine, remeasure from position 9 o'clock to update all measurement values.*

---

## Adjust machine

1. Compare the offset and angular error to the tolerance demands.
2. If the angular error need to be adjusted, please shim the machine first, then adjust the offset.
3. Tighten the bolts and remeasure.

# CARDAN

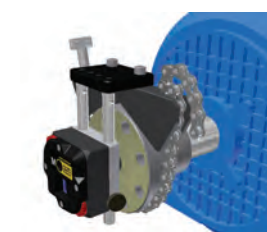
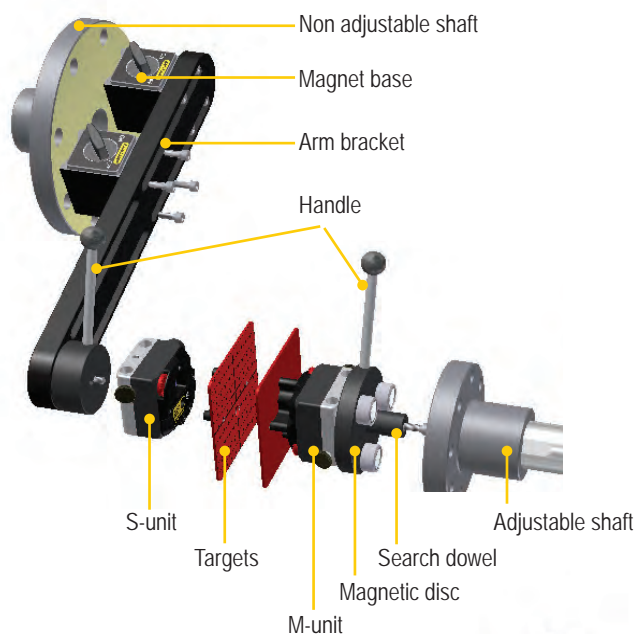


The Cardan program is used for alignment of cardan-shaft-coupled/centre-offset machines.

## Mount the units

1. Mount the arm bracket on the non adjustable shaft. You can use the magnet bases or the mount the bracket directly on the flange.
2. Mount the S-unit on the arm bracket.
3. Mount the M-unit on the magnetic disc. If the adjustable shaft has a thread, use suitable search dowel. This makes the centering easier.
4. Mount the targets.

The Cardan bracket has an offset range of 0 - 900mm.





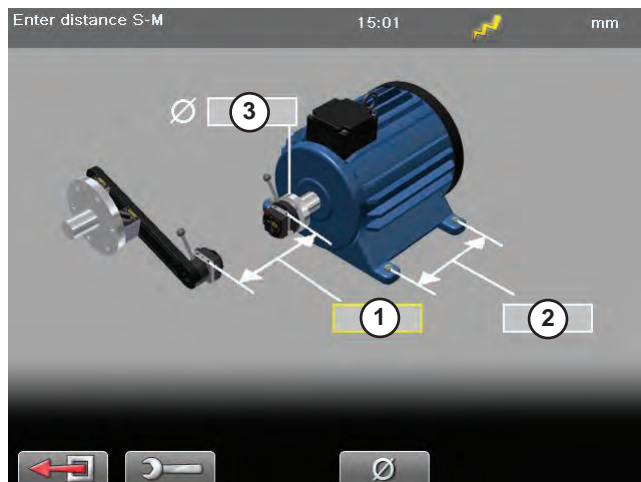
Alternative mounting with offset bracket and chain.




Joined arm brackets for large offset





## Enter distances

1. Select  and  to open Cardan program.
2. Enter distances. Confirm each distance with **OK**.



- 1 Distance between S-unit and M-unit.  
Measure between the rods. **Mandatory**.
- 2 Distance between feet pair one and feet pair two. Optional.
- 3 Coupling diameter. Optional, select  to activate field.

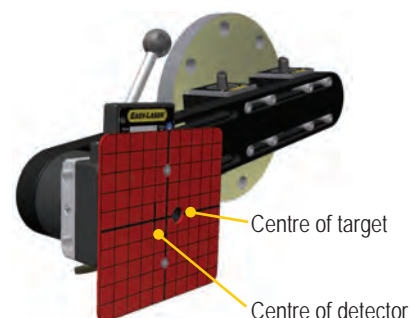
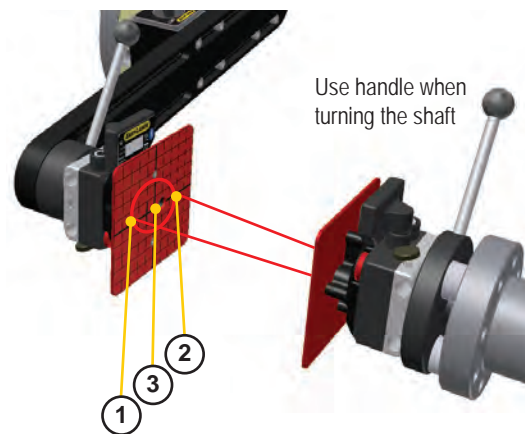
## Function buttons

	<b>Leave program.</b>
	See "Control panel" on page 15.
	<b>Diameter.</b> Select to enter coupling diameter. This is necessary if you want the result based on the gap of the coupling instead of angle.
	<b>Continue.</b> Available when you have entered the mandatory distances.

## Cone laser beam

When you turn the shaft, the laser beam will draw a circle on the target. If the distance between S and M is small (<300 mm or 12 inch), it can be difficult to cone the laser beam. If this is the case, proceed to *Rough alignment*.

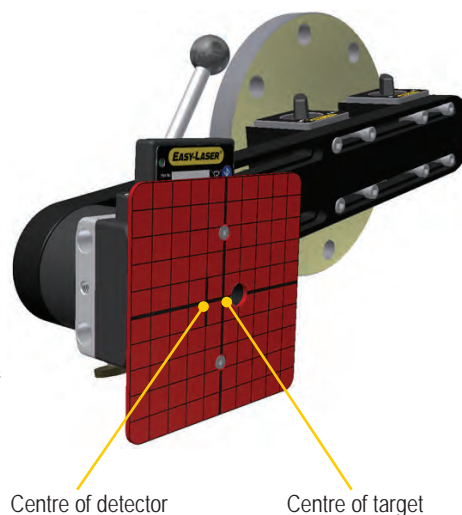
1. Note where the laser beam hit the target at position **1**.
2. Turn one of the shafts 180°. Note the position **2**.
3. Adjust the laser beam halfway towards position **1**, to position **3**.
4. Turn the shaft again. If the laser beam does not move when you turn, the laser beam is correctly coned.
5. Repeat step 2–5 with the opposite unit.
6. Position both units at 9 o'clock.
7. Move the arm bracket until the laser hits the centre of the target on the M-unit.
8. Adjust the S-unit laser beam until it hits the centre of the detector. Adjust using the red screws.
9. Adjust the arm bracket until the laser from the M-unit hits the S-unit in the centre of the target.
10. Adjust the laser beam on the M-unit until it hits the centre of the detector.
11. Remove the targets.





## Rough alignment

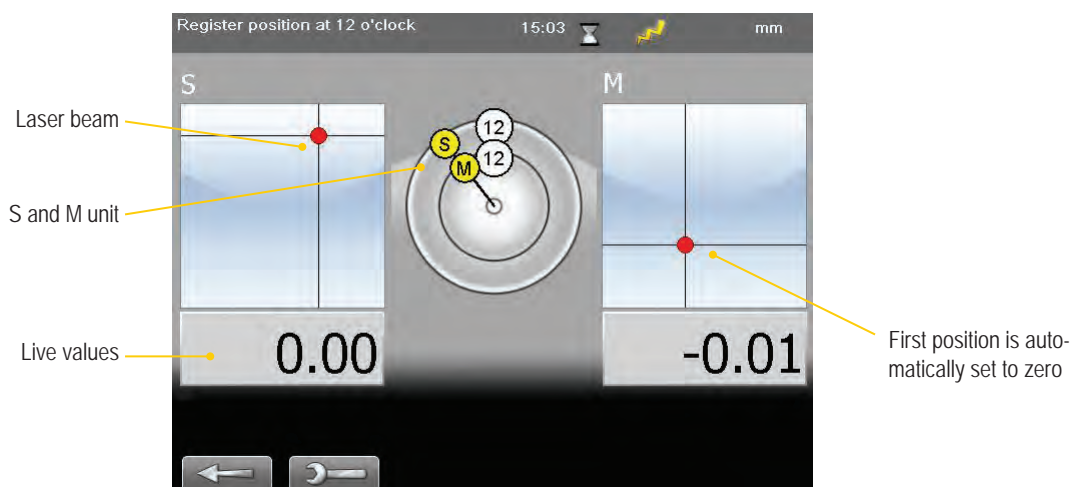
1. Adjust the arm bracket until the laser beam from the M-unit hits the centre of the target.
2. Adjust the movable machine until both laser beams hit **centre of the targets**.
3. Adjust the arm bracket if the adjustment of the machine is not enough.
4. Turn the shafts to 9 o'clock.  
Connectors pointing upwards.
5. Adjust the laser beams to the marking for **centre of detector**.
6. Remove the targets. The Display unit shows the position of the laser beams.



## Measure

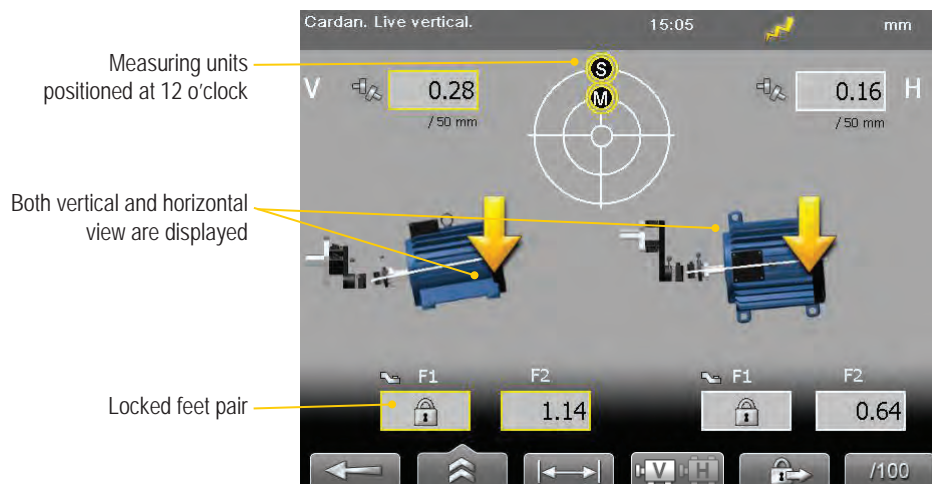
The shafts are positioned at 9 o'clock.

1. Press **OK** to register first position. The first position is automatically set to zero.
2. Turn the shafts to 12 o'clock.
3. Press **OK** to register position.
4. Turn the shafts to 3 o'clock.
5. Press **OK** to register position.
6. The result for the angular error is displayed.





## Result



### Function buttons

	<b>Back</b>
	See "Control panel" on page 15.
	See "Measurement file handling" on page 11.
	<b>Show target.</b> This is a quick way to see where the laser beam hits the target and how the measuring units are positioned.
	Print report on thermal printer (optional equipment). Available when you open a saved measurement.
	Generate report. Available when you open a saved measurement.
	Toggle button. Show vertical or horizontal live values.
	Toggle button to move the lock. By default, the feet pair with the <b>highest value</b> is set to zero and locked.
	Toggle button. Switch between to show gap and show angular error per 100 mm. For this to work you need to set the coupling diameter.

## Adjustment

Check the machine according to the tolerance and adjust the machine if needed. No offset adjustment is made.

1. Adjust the machine vertically by shimming according to the vertical feet values.
2. Adjust the machine sideways according to the live horizontal values.
3. Tighten the feet.
4. Select to remeasure.


# STRAIGHTNESS

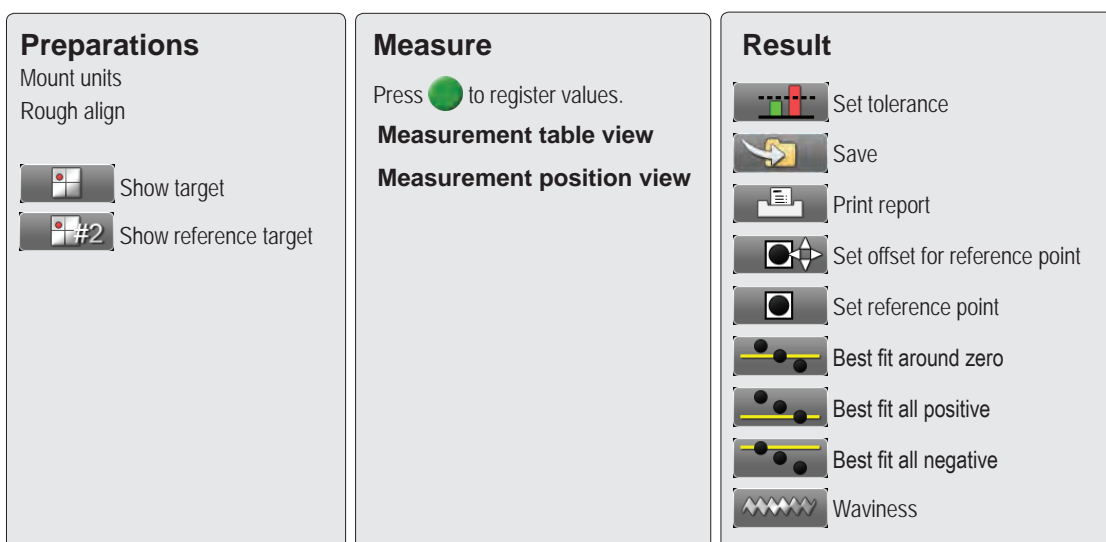


The program Straightness is used for machine foundations, shafts, bearing journals and machine tools for example.

The basic principle for straightness measurement is that all measurement values will show the position of the detector unit relative to the laser beam. First, the laser beam is roughly aligned along the measurement object. The detector is then positioned on the selected measuring points and the values registered.

## Work flow





Select  and  to start the Straightness program.



### **Note!**

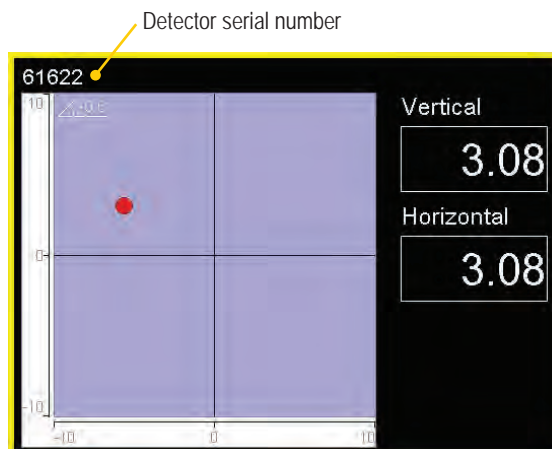
The M-unit can be used as a detector together with a laser transmitter.  
Do not use the S-unit for this.

## Show target






Select  and  to display a target. This is a quick way to see where the laser beam hits the target and how the detector is positioned. Select  to close the target, or press .

### Calculated and raw values




The values displayed here are **raw** values. When you measure, **calculated** values are used. Calculated values are based on the distance from first measurement point and selected reference points.

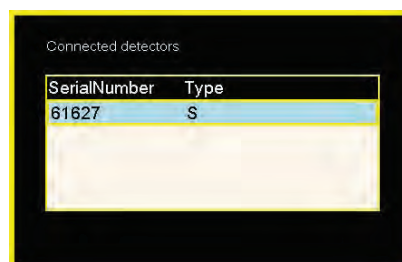


### Function buttons

	Zero set displayed value. Only zeroes the value while the target is opened.
	Return to the absolute value.
	Halve displayed value. Only zeroes the value while the target is opened.
	Close target. (Or press  .





## Show reference target

Select  and  to display the reference target. The first time you select the command, a window is displayed. Select which detector you want to use as reference detector and press .



Connected detectors	
SerialNumber	Type
61627	S

### Function buttons

	Zero set displayed value.
	Return to the absolute value.
	Close target. You can also close by pressing  .

See "Halve or Zero set value" on page 27.

# Measure

- 1. Press . A window is displayed where you can enter the distance for the measurement point. If you leave the field empty, you can measure using “quickmode”.
- 2. Press to register a value. An hourglass is displayed while the value is registered.
- 3. Select to continue to Result view.

Measure  
Position # 6(6)

12:38

mm

Calculated values

Vertical

Horizontal

Angle

#	V	H	Ref.	Dist.
1	3.2	-1.2		100
2	2.4	-1.1		150
3	0.0	0.0		320
4	-0.6	-0.3		400
5	-2.0	0.0		520
6	-4.4	0.1		600
7				

600

Vertical, Horizontal and Angle values

Reference point.  
See also Calculation settings

History points.  
See also Straightness settings.

Reference point with offset

Selected measuring point

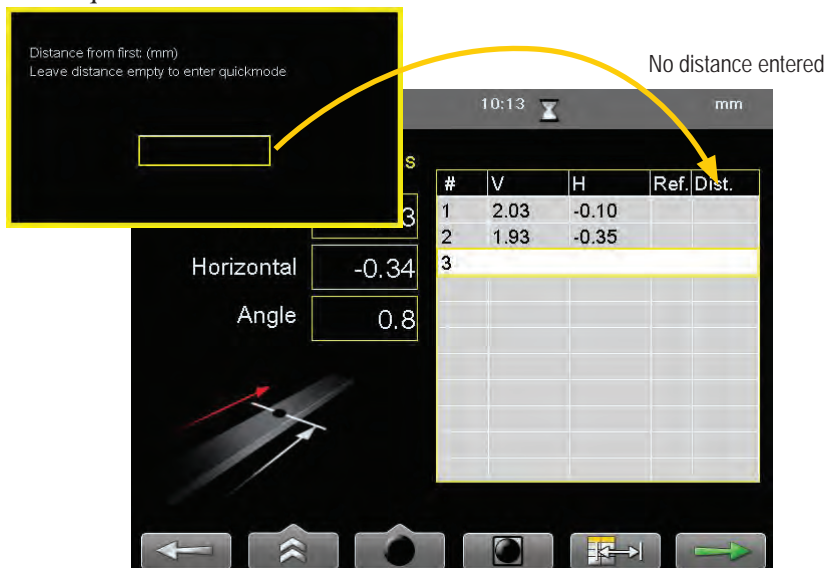
Distance from first point

## Function buttons


	Leave program.
	<div><div> See “Control panel” on page 15.</div><div> See “Straightness settings” on page 84</div><div> Show target.</div><div> Show reference target.</div></div>
	<div><div> Edit distance. Edit distance for selected point.</div><div> Add measuring point.</div><div> Delete measuring point.</div><div> Go to measuring point. A window is displayed. Enter the point to which you want to go.</div><div> Set offset. Set offset for selected reference point.</div><div><div>0</div>Zero set displayed value. Only available before registering the first point. (Or press numerical button zero.)</div><div><div>1/1</div>Return to the absolute value. Only available before registering the first point. (Or press numerical button 1.)</div></div>



## Quickmode

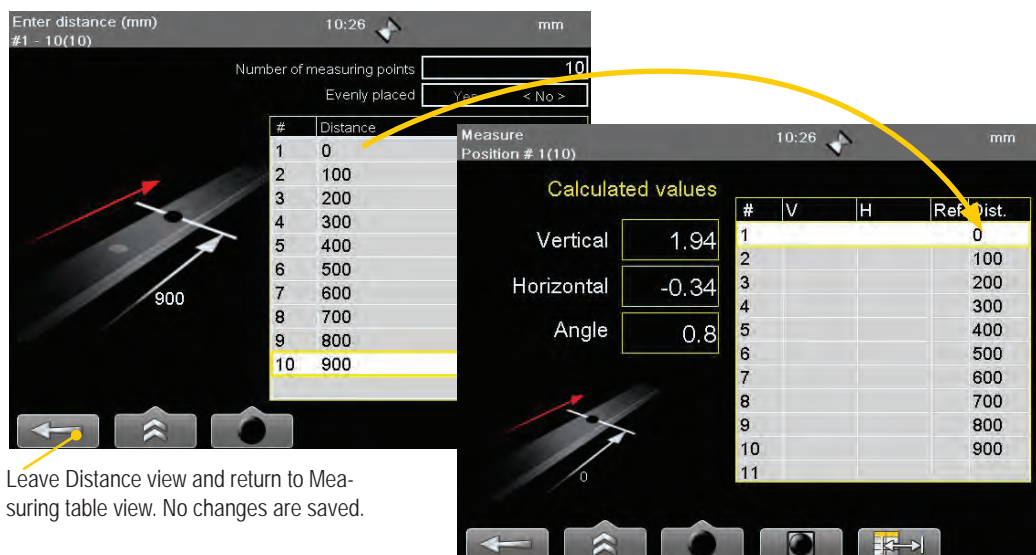
Quickmode means that you measure without entering any distances. Leave field empty to use quickmode.



## Enter distances

Select  to open the Distance view. This is an easy way to fill in many distances. Do this before you have registered a value.

- Enter number of measuring points. Press .
  - Select if the points are evenly placed or not. Use navigation buttons left and right. If set to <YES>, you are prompted to fill in the distance between point 1 and 2.
  - If set to <No>, fill in each distance in the table.
- Select  to save changes and return to Measuring table view.

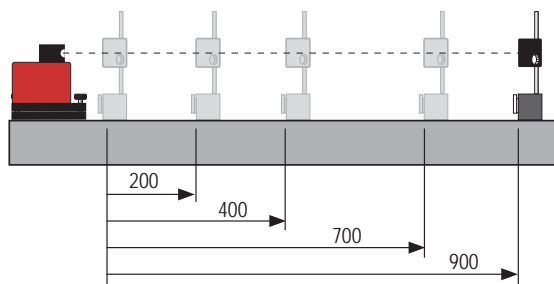


### Note!

If you have registered values and open Enter distance view and make changes, your registered values will be deleted.

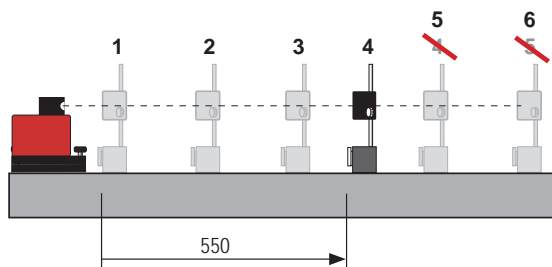
## Add and delete points

Distances are always measured from the same point.



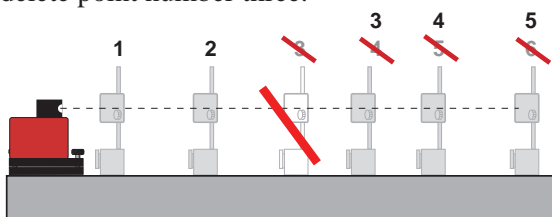
### Add measuring point

Adding points between rennumbers the existing following points. In this example, we add a new point after point number three.



### Delete measuring point

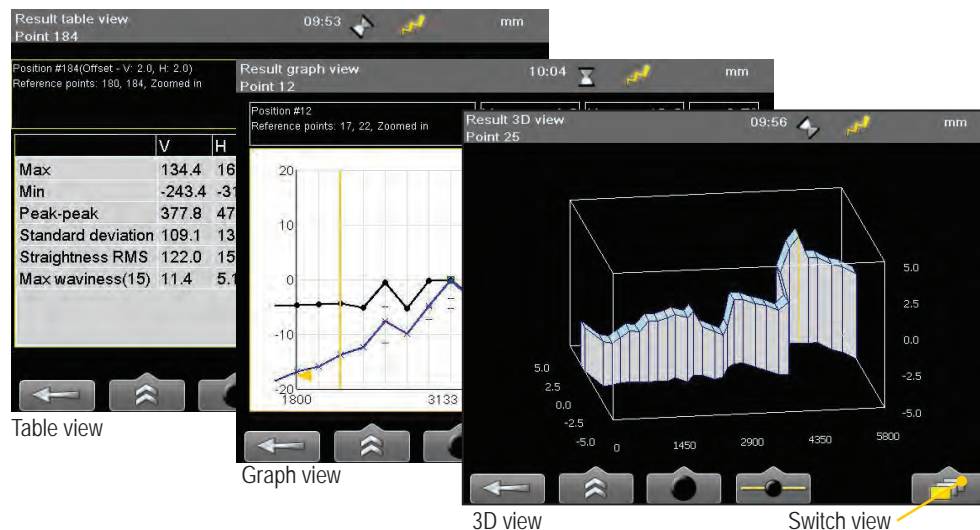
Deleting points between rennumbers the existing following points. In this example, we delete point number three.





# Result

The result can be displayed as graph, table or a 3D view. By default the table view is displayed. The function buttons are almost the same for all three views. Zoom is only available in Graph view. See following pages for more information regarding each view and its functions.

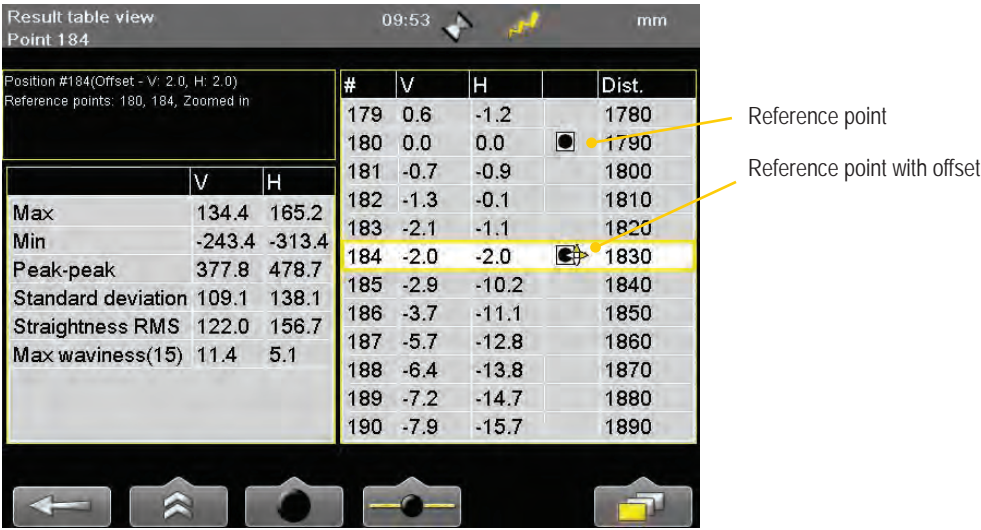


## Function buttons

	Back to measure. To remeasure, select a point and then .
	Contains a sub-menu: <ul style="list-style-type: none"> <li> See “Control panel” on page 15.</li> <li> See “Straightness settings” on page 84.</li> <li> <b>Save file.</b> See “Measurement file handling” on page 11.</li> <li> <b>Print report.</b> Save file and plug in printer (optional equipment).</li> <li> <b>Save report</b> (only when you have opened a saved measurement).</li> <li> <b>Set tolerance.</b> It is possible to set different vertical and horizontal tolerance. See “Tolerance” on page 79.</li> <li> <b>Zoom.</b> Only available in Graph view.</li> </ul>
	Contains a sub-menu: <ul style="list-style-type: none"> <li> <b>Go to measuring point.</b> A window is displayed. Enter the point to which you want to go.</li> <li> <b>Set offset for reference point.</b> See “Calculation settings” on page 80.</li> </ul>
	Contains a sub-menu. See “Calculation settings” on page 80. <ul style="list-style-type: none"> <li> <b>Raw data.</b> Return to original data.</li> <li> <b>Set as reference point.</b></li> <li> <b>Remove as reference point.</b> The point itself is <b>not</b> removed.</li> <li> <b>Best fit around 0.</b></li> <li> <b>All positive.</b> The best fit with all measurement points <b>above</b> zero.</li> <li> <b>All negative.</b> The best fit with all measurement points <b>below</b> zero.</li> <li> <b>Show waviness.</b></li> </ul>
	<b>Views.</b> Switch between table, graph and 3D view.

### Result table view

Navigate using the navigation buttons. To remeasure, select a point in the list and select .

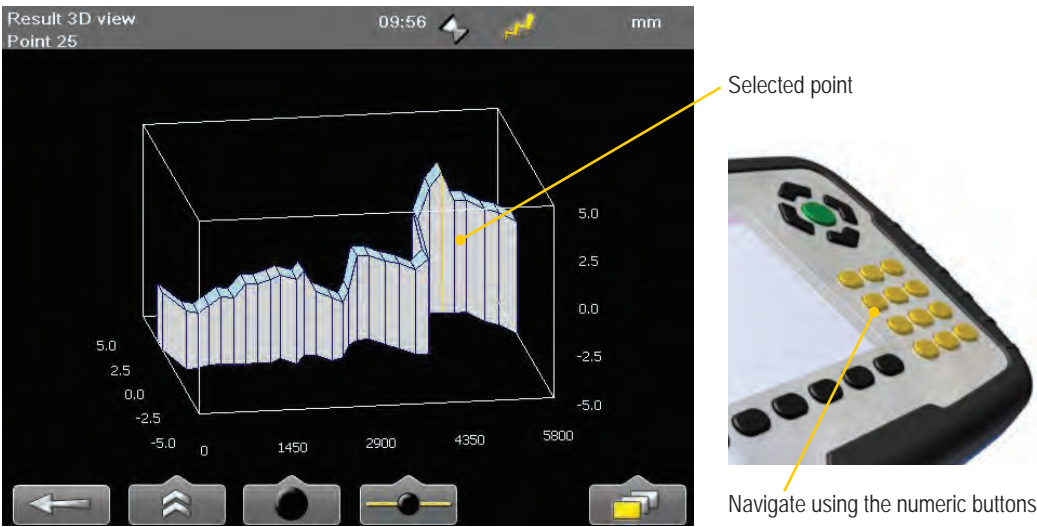


Max	The highest value.
Min	The lowest value.
Peak-peak	Difference between Max and Min value
Standard deviation	Average difference between Max and Min value.
Straightness RMS	Root Mean Square (Numerical Flatness)
Max waviness	Set waviness is shown in bracket. See “Waviness” on page 83.

### Result 3D view

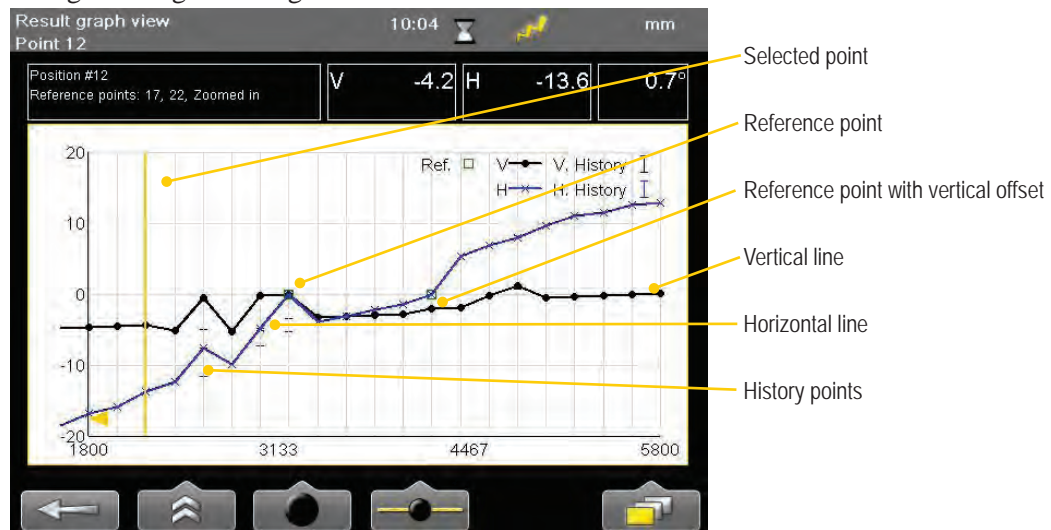
Navigate using the numeric buttons.

- Buttons 2, 4, 6 and 8 rotates the 3D view.
- Button 5 returns to the initial view.



## Result graph view

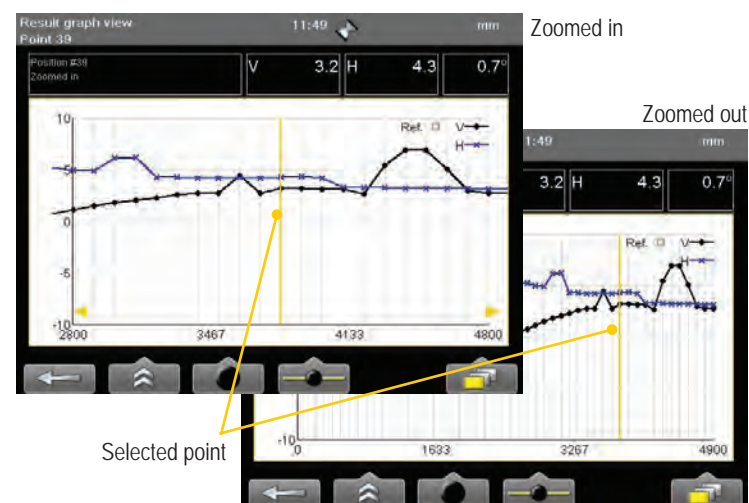
Navigate using the navigation buttons.



### Zoom

It is possible to zoom in the graph view if you have registered more than 20 points.

Select a measurement point and select and . The graph is zoomed in around the selected point.






### Scale using navigation buttons

Press navigation button “Up” and “Down” to scale the result graph view.

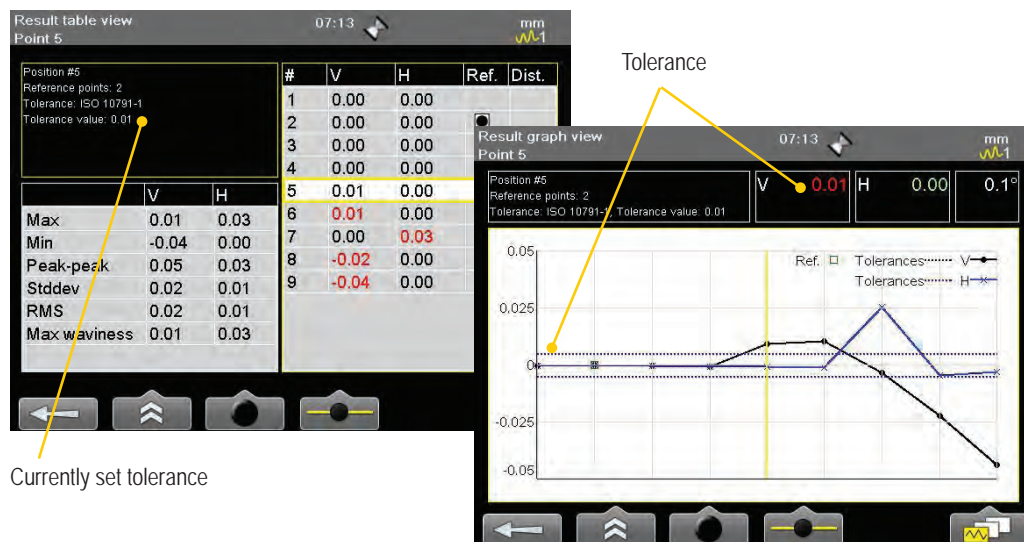


## Tolerance

1. Select  and .
2. Select a predefined tolerance or create a custom tolerance. Press .

### Tolerance in graph and table view

- In the Table view, the values within tolerance are shown in black, values not within tolerance are red.
- In the Graph view, vertical and horizontal tolerances are colour coded.





### Predefined tolerance

There are two ISO standard tolerances. The ISO tolerance is calculated automatically depending on which distances you have entered and interpreted in the same way as our custom tolerance.

Tolerance	Vertical Min	Max	Horizontal Min	Max
None				
Custom tolera				
ISO 10791-1	-0.005	0.005	-0.005	0.005
ISO 10791-2	-0.005	0.005	-0.005	0.005

Predefined tolerances

### Custom tolerance

- Set vertical and horizontal tolerance. Press  to confirm.
- Select  to edit a custom tolerance

	Min	Max
Vertical	<input type="text"/>	<input type="text"/>
Horizontal	<input type="text"/>	<input type="text"/>

Enter custom tolerance



# Calculation settings

#	V	H
1	1.94	-0.34
2		-0.34
3		-0.34
4		-0.10
5		-0.23
6		-0.36
7		-0.37
8		-0.05

Select to display sub-menu with different calculation settings.

Select to revert to original data. All calculations and reference points are removed.

## Reference points

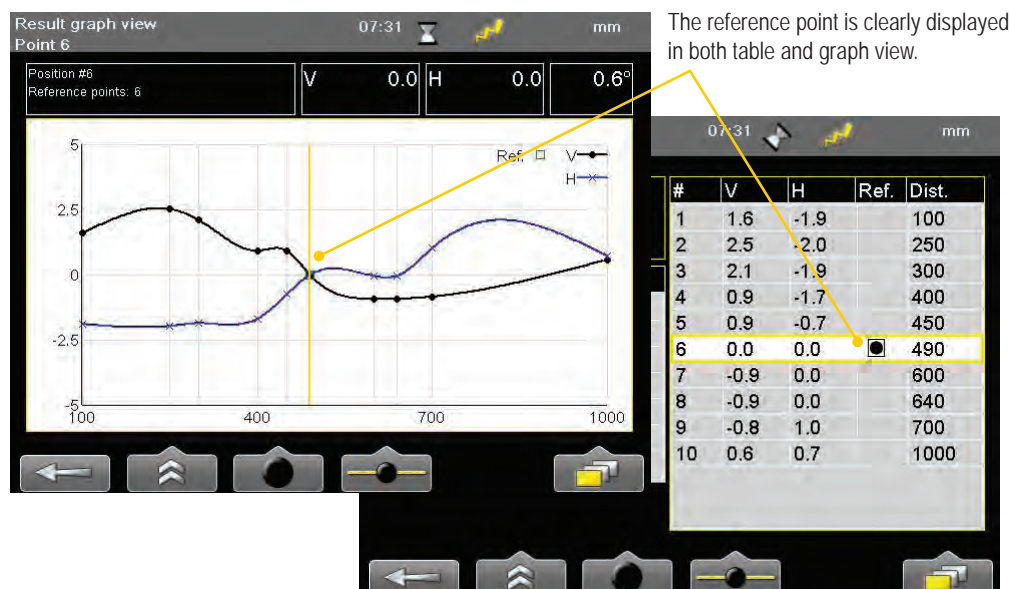
Select and to set selected point as reference point. You can set one or two reference points. To remove a reference point, select it in the table or graph and then select . The point itself is **not** removed. The reference points are clearly displayed in both table and graph.

### Note!

You can also set and remove reference points by pressing the green button.

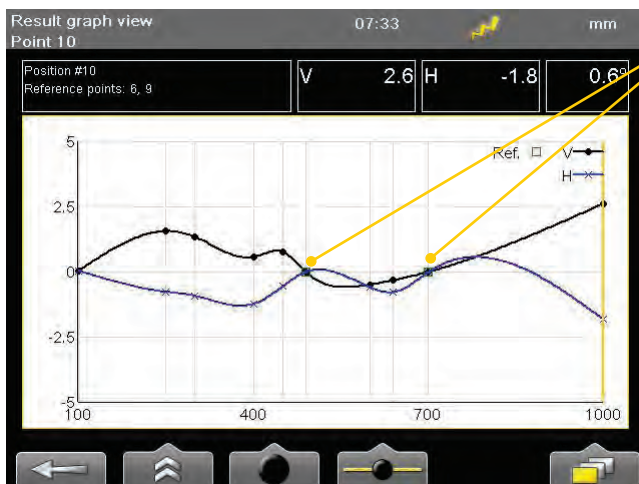
### One reference point

Setting a single reference point will offset all other measurement points based on the set reference point.



## Two reference points

Setting two reference points will offset all other measurement points based on a reference line drawn between the two set reference points.



## Reference point with offset

By using reference point offset it is possible to move the position of a reference point. This can be used for instance in turbine measurements to compensate for thermal expansion.



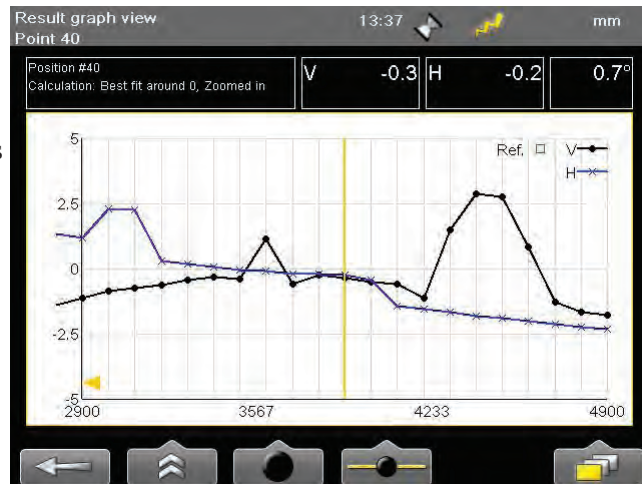


## Best fit operations

All best three best fit operations will try to find a reference line where the peak to peak value of the measurement points is minimized. This can be used for instance to see if a surface is within given tolerances. The difference between the best fit operations is the offset that is set.

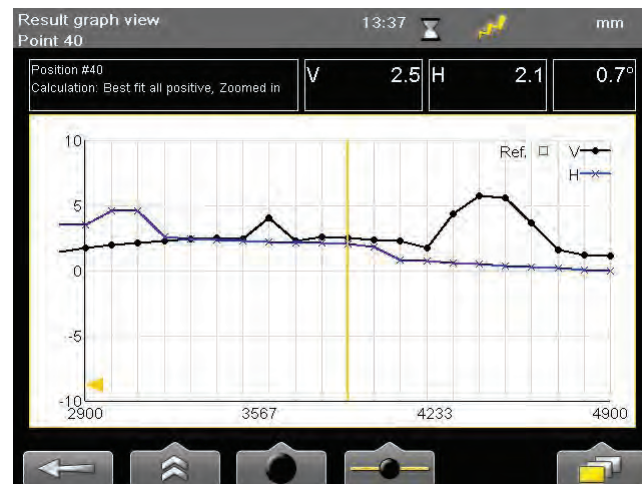
### Best fit – around 0

This operation removes all reference points. Centre the values so that the maximum and minimum values are equally large.



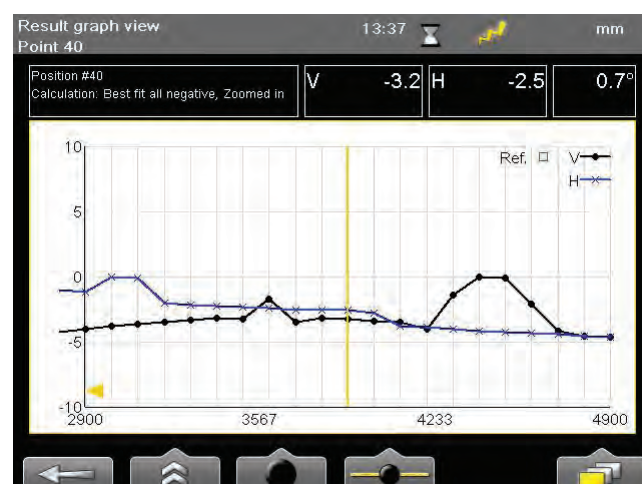
### Best fit – all positive

Removes all reference points. The best fit with all measurement points above zero.



### Best fit – all negative

Removes all reference points. The best fit with all measurement points below zero.



## Waviness

It may be insufficient to interpret the quality of a measurement by looking only at the measurement peak to peak value. Waviness is often used to detect large deviations. In some applications there might not be a problem with many small deviations, but one large will cause great problems. Bearings in diesel engines is one example.

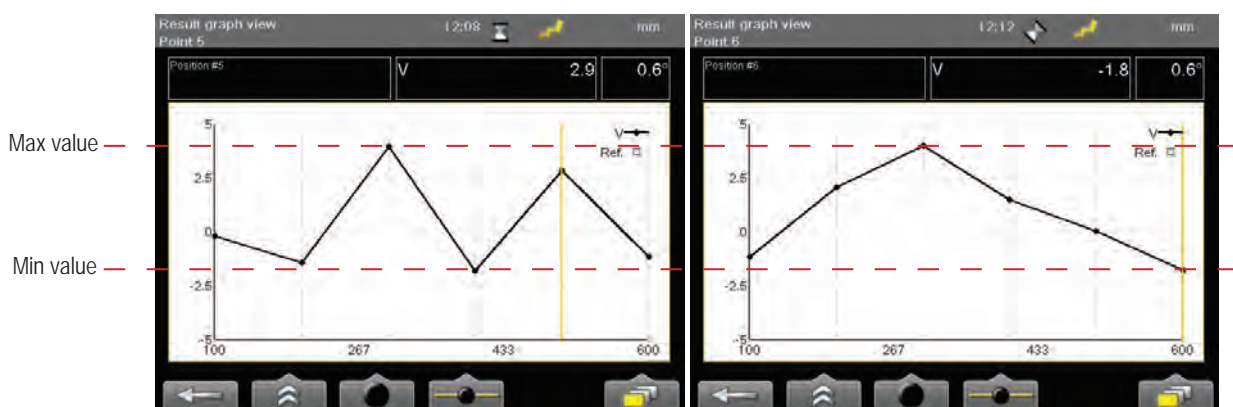
To set waviness, select  and .

To show waviness graph, select  and .

### Example

The two surfaces in the example below have the same peak to peak value. However the first measurement is rougher than the second.

In many applications a smooth measurement is desired. Using waviness it is possible to indicate the smoothness of a measurement. In this example, the rougher measurement will get a waviness graph with higher values.



Two surfaces with same peak-to-peak value



### Waviness calculation

The waviness number is calculated by letting a sliding set of reference points traverse the measurement values. The maximum absolute value between the reference points will determine the waviness number at the given position.

Waviness factor 1 checks the deviations between three measurement points. For example between points 1-3, 2-4 and 3-5 etc.

Waviness factor 2 checks the deviations between four measurement points.



# Straightness settings

Select  and  to open Straightness settings.  
For global settings, see “Control panel” on page 15.



## Show/hide horizontal values

It is possible to hide the horizontal values. The horizontal values will still be registered, but not visible.



1. Select . A window is opened.
2. Select Yes or No. Navigate using the navigation buttons.
3. Press  to confirm choice.

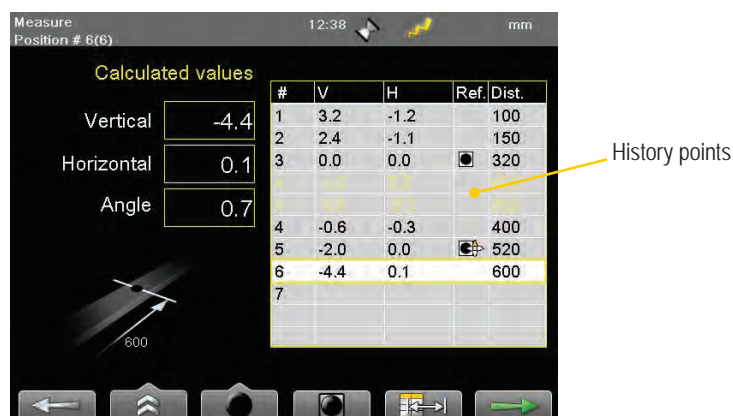
### Note!

Only available when you use the program Straightness with a two axis detector.



## Show history

If you remeasure a point, the old values are saved as history points. You can select to show or hide these points while measuring. It is only possible to select the latest registered value, not the history points. If you delete a point with history points, all its history is deleted as well. Default is set to hide. Even when set to “hide”, the history points are saved and can be viewed later.

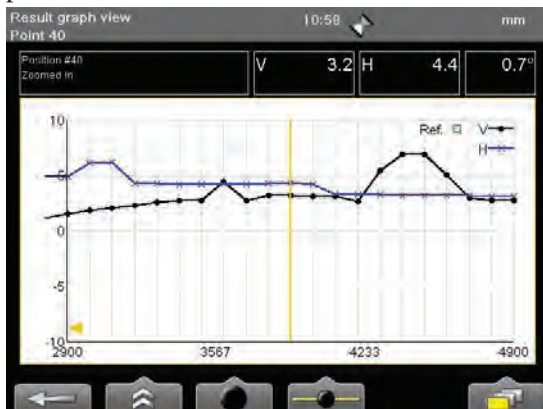
1. Select . A window is opened.
2. Select Yes or No. Navigate using the navigation buttons.
3. Press  to confirm choice.



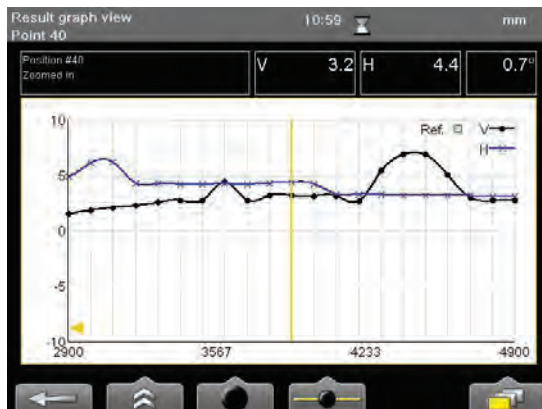
## Smooth/sharp graph

1. Select . A window is opened.
2. Select Yes or No. Navigate using the navigation buttons.
3. Press  to confirm choice.

When set to Smooth, the graph will find a smooth path between the measurement points.





Sharp

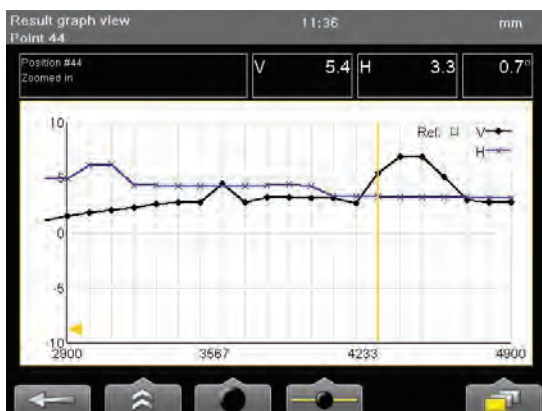


Smooth

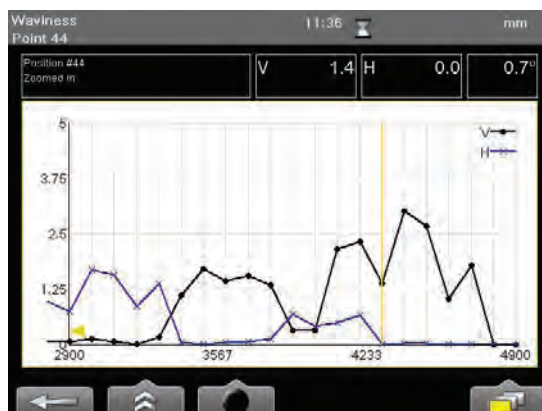
## Waviness settings

1. Select . A window is opened.
2. Select waviness factor. Navigate using the navigation buttons.
3. Press  to confirm choice.

To show waviness in the result view, select  and .



Graph view



Same measurement but with waviness

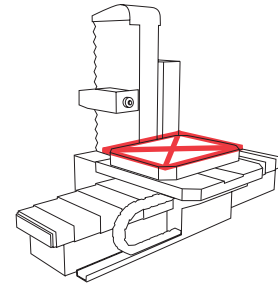
See "Waviness" on page 83.






# FLATNESS

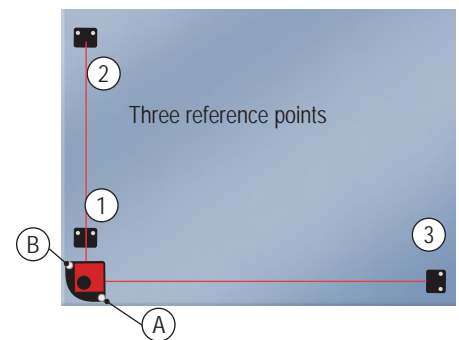


Program to measure flatness of machine bases,  
machine tables, etc.



## Preparation

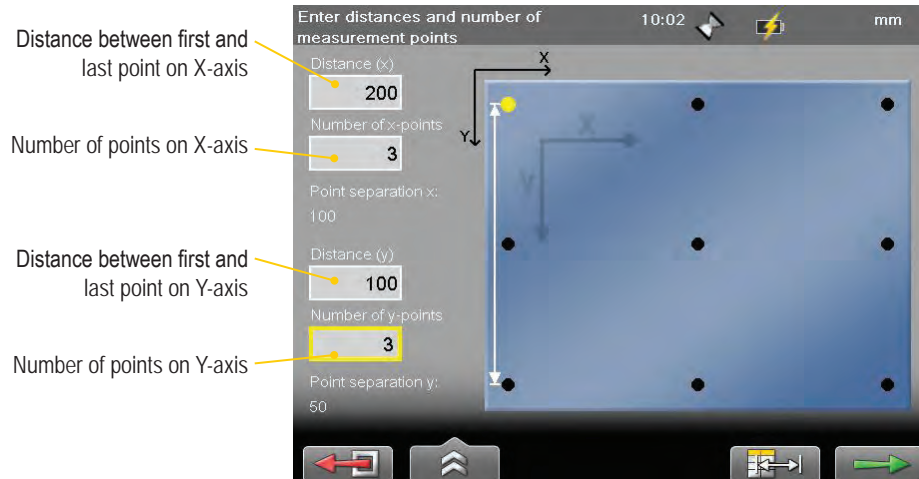
1. Mount the laser transmitter on the table.
2. Mount the detector close to the transmitter on the table (1).
3. Select  to open the program Flatness and enter distances.
4. Select  to open the target.
5. Select  to zero set the value. This is now reference point number one.
6. Move the detector to reference point number two (2).
7. Adjust the laser beam by using the screw (A) on the tilt table. Level to  $\pm 0.1$  mm.
8. Move the detector to reference point number three (3).
9. Adjust the laser beam by using the screw (B) on the tilt table. Level to  $\pm 0.1$  mm.










Repeat procedure until you have all three reference points within  $\pm 0.1$  mm.

Enter distances

Up to 500 measurement points can be handled.



## Function buttons


	<b>Back.</b> Leave program.
	 See “Control panel” on page 15.
	 See “Tolerance” on page 89.
	 <b>Show target.</b>
	Open distance table view. “Distance table view” on page 88.
	Continue to Measure view.

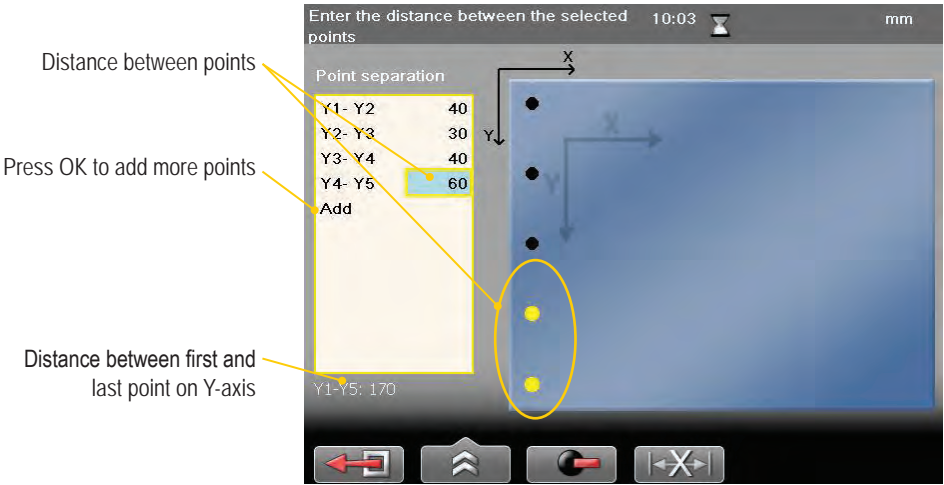
**Note!**

If one of your axis has more than six measurement points, make that the Y-axis. This will give you a better pdf-report.









## Distance table view

Select  to open Distance table view. Use if the distances between points vary in X or Y axis.

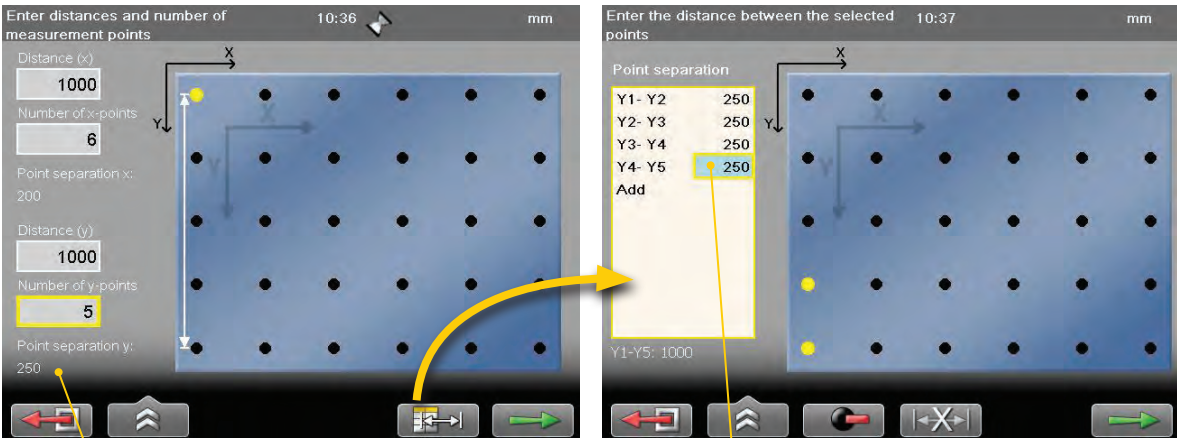


### Function buttons

	Leave Distance table view and return to Distance view. No changes are saved.
	See “Control panel” on page 15.
	See “Tolerance” on page 89.
	Delete point. It is only possible to delete the last point in the list.
	Toggle button. Enter distances for X or Y-axis.
	Continue to Measure view.

### Note!


It is also possible to enter distances in the default distance view and switch to Distance table view. This is a fast way if you only need to change one out of many distances



**Distance view (default)**  
Point separation is the same for all points

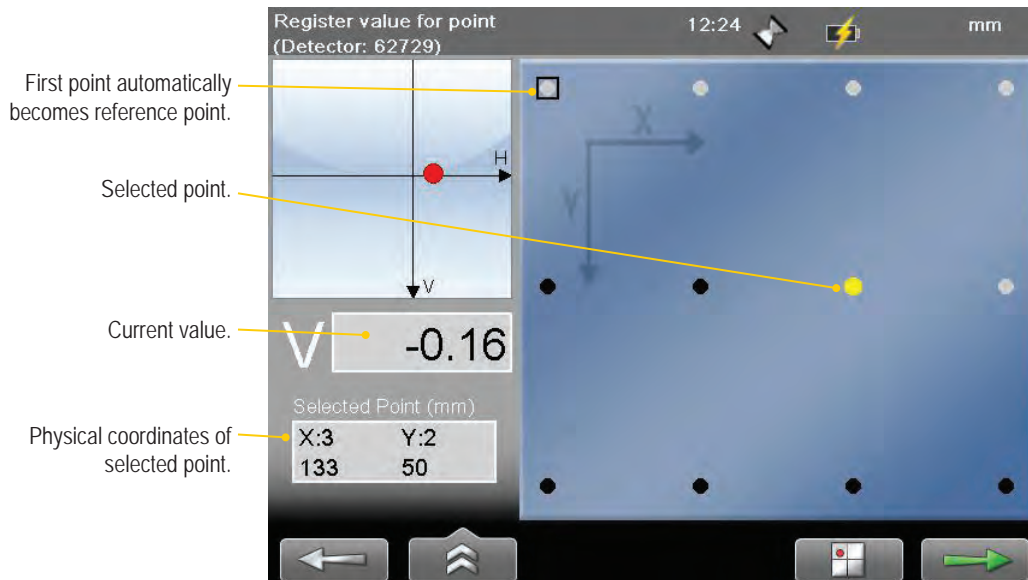
**Distance table view**  
Change point separation if needed

## Measure








Press  to register values. It is possible to measure the points in any order. First measured point is set as reference point. When you have measured all points, the Result view is displayed.

### Note!

*The M-unit can be used as a detector together with a laser transmitter.  
Do not use the S-unit for this.*



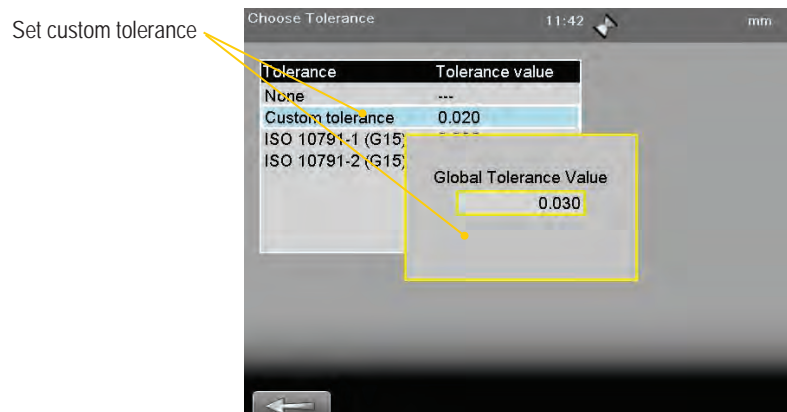
## Function buttons

	<b>Back.</b> Return to enter distances.
	 See "Control panel" on page 15.
	 See "Tolerance" below.
	Measuring direction. Measure left to right or up and down.
	Show target. Useful if you want to rough align for example.
	Continue to Result view. Available when you have measured three positions.

## Tolerance


By default, the ISO standard is used. The ISO tolerance is calculated automatically depending on which distances you have entered. Only global tolerance is available.

Select  to set custom tolerance.


















## Result table

Select  to open table view. Values outside the tolerance are displayed with red.

Statistics		Value	Point			Value	Ref.	Offset
Peak-peak		3.103	X:1,Y:1			0.059		
Min		-1.824	X:2,Y:1			0.000		
Max		1.279	X:3,Y:1			0.009		
Standard deviation		0.657	X:4,Y:1			0.417		
Flatness RMS		0.659	X:1,Y:2			1.263		
Distance data		Value	X:2,Y:2			1.279		
Distance X1-X4		100	X:3,Y:2			-0.452		1.000
Distance Y1-Y4		100	X:4,Y:2			-1.824		
Tolerance		Value	Point data		Value			
Type		Custom tolerance	Selected Point		X:3,Y:2			
Global		0.060	Physical coordinate X		67			
			Physical coordinate Y		33			
			Raw Value		1.447			

## Function buttons

	Remeasure selected point.
	See “Control panel” on page 15.
	Set offset for selected point.
	See “Tolerance” on page 89.
	Save file, see “Measurement file handling” on page 11.
	Toggle button. Set selected point as reference point. Remove as reference.
	See “Calculation settings” on page 92.
	Raw data. Revert to original data.
	Three reference points are automatically set to zero.
	Best fit around 0.
	All positive. The best fit with all measurement points above zero.
	All negative. The best fit with all measurement points below zero.
	See “Result 3D” on page 91.
	See “Result grid” on page 91.
	See “Result table” on page 90.

### Note!

To remeasure: select a measurement point and select .

## Result grid

Select  to open table view.

Result grid view 14:46 mm

3 reference points

	X1	X2	X3	X4
Y1	0.059	0.000	0.008	0.417
Y2	1.263	1.279	-1.452	-1.824
Y3	0.028	0.020	0.010	0.000
Y4	0.000	-0.007	-0.017	-0.024

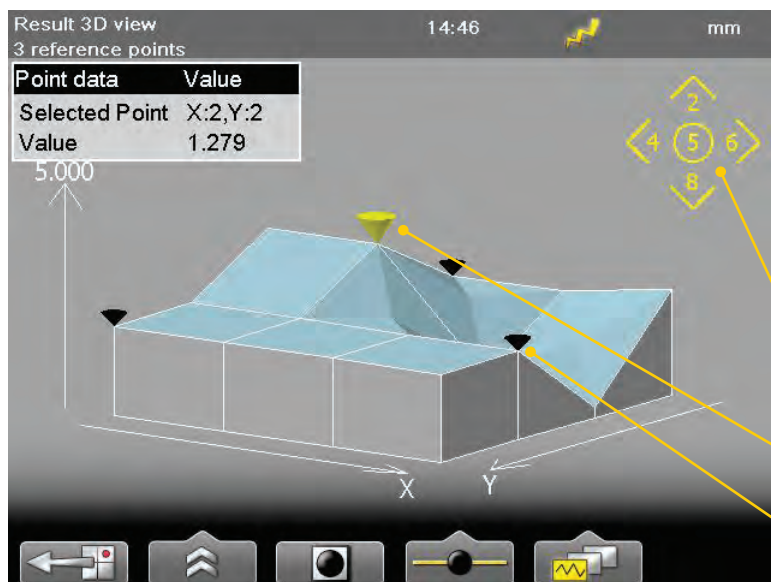
Reference point

Red = values not within tolerance  
Green = values within tolerance

## Result 3D

Select  and  to open 3D view. Only available when all points have been measured.

- Use the navigation button to select measurement points.
- Navigate using the numeric buttons.
  - Buttons 2, 4, 6 and 8 rotates the 3D view.
  - Button 5 returns to the initial view.




Use numerical buttons to rotate the image.

Yellow = selected point

Black = reference point



# Calculation settings

Select  to display calculation settings. You can try different settings to see which one suits the best and analyze the measurement result directly in the Display unit. You can also save reports with different settings to analyze further later.



## Reference points

The measurement values can be recalculated so that any three of them become zero references, with the limitation that a maximum of two of them are in line horizontally, vertically or diagonally in the coordinate system. (If there are three in line, it is just a line, and not a plane!). Reference points are needed when you are going to machine the surface.

### Custom reference points



1. Select  to set currently selected point to zero.
2. Select one or three reference points. When you select a second reference point, the values are not recalculated. Set a third reference point to recalculate the values.
3. Select  if you want to return to raw data.

### Set three reference points



1. Select  to set three reference points.
2. Select  if you want to return to raw data.

## Best fit



### Best fit around 0

When you perform a best fit calculation, the measurement object is tilted to the lowest peak to peak value. It is fitted as flat as possible between two planes where the average value is zero. Select  and  to calculate best fit around 0.

### All positive

The measurement object is tilted as in a Best fit calculation, but the reference line is moved to the lowest measurement point. Select  and  to calculate the best fit with all measurement points above 0.

### All negative

The measurement object is tilted as in a Best fit calculation, but the reference line is moved to the highest measurement point. Select  and  to calculate the best fit with all measurement points below 0.




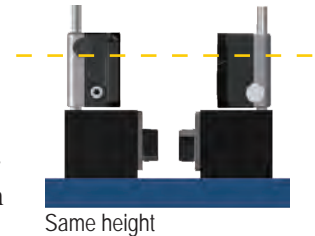


Measure twist on an object by taking two diagonal measurements. If you want to measure a machine foundation made of two beams you can build a temporary reference block at the centre point.


## Preparations

Select  and  to start the program Twist.

1. Place the S-unit as shown on the screen. Make sure that the S- and M-unit are on the same height. Especially important when you are using a tilt table.
2. Mark where the positions A, B, C and D are on your measurement object. Make sure to place the centre point exactly in the middle.
3. Place M-unit on position **D**. Make sure that the laser beam hits the detector target.
4. Place the M-unit on the centre point. Make a mark to ensure that you place the detector exactly on the same position each time.
5. Place the M-unit on measurement position **A**.
6. Select  to zero set the value.
7. Move the M-unit to measurement point **D**. Adjust the laser beam to zero ( $\pm 0.1$ ).

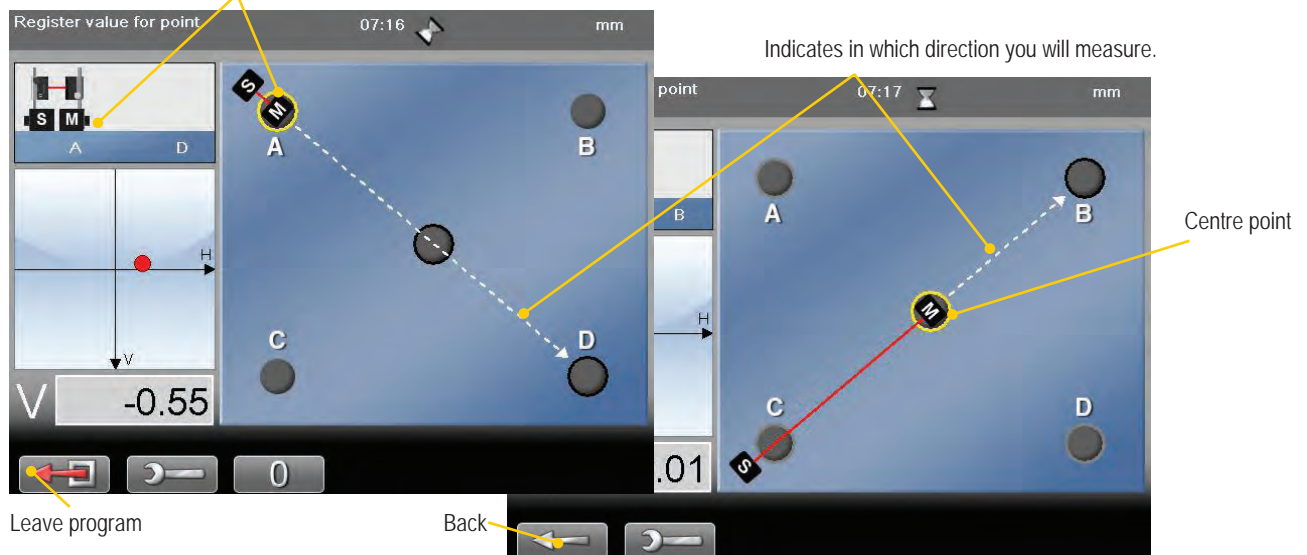


## Measure




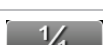
1. Place the S-unit as shown on the screen.
2. Place the M-unit on measurement position **A** and press .
3. Follow the instructions on screen and register values on all measurement points.

When you have registered a value on point **B**, the Result view is automatically displayed.

Guide to where to place the measuring unit



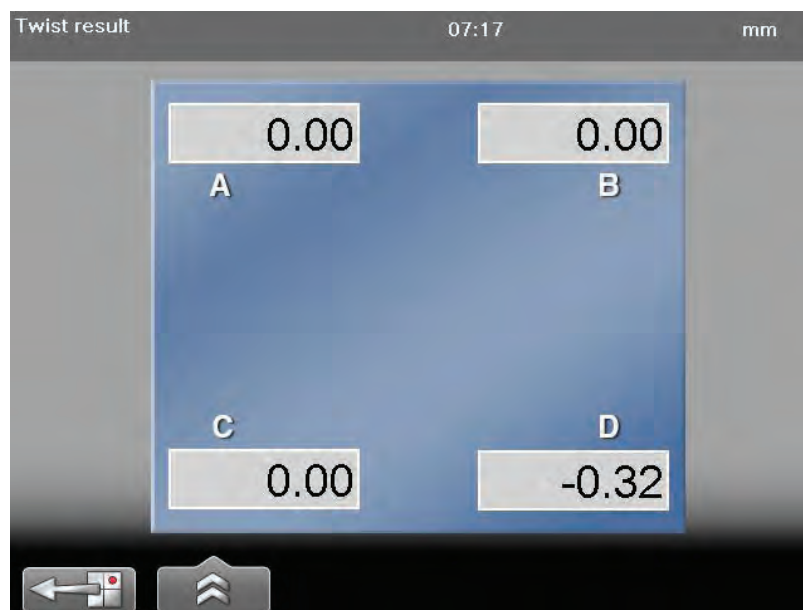
## Function buttons

	<b>Back.</b> Leave program.
	See "Control panel" on page 15.
	Zero set the displayed value. Only available before registering the first value.
	Return to absolute value. Only available before registering the first value.







## Result

Three measurement points are automatically set to zero.



### Function buttons

	Remeasure.
	 Save file, <i>"Measurement file handling" on page 11.</i>
	 See <i>"Control panel" on page 15.</i>

# FLANGE FLATNESS

## Preparations

- Ensure a good measurement environment. Strong sunlight, warning lights, vibrations and temperature gradients can affect the readings.
- Make sure the surface is clean.
- Use the program Values, Flange flatness or targets for the set up. The tighter the tolerances you require, the more important is an accurate set up and levelling.
- Fasten the laser transmitter using the safety strap. See “Safety strap” on page 217.

### Point one

1. Place the laser transmitter (D22 or D23) on the flange. Notice the direction, see image.
2. Place the detector close to the transmitter.
3. Make a mark to mark out the position of the detector.
4. Adjust the detector or target until the laser beam hits the centre.
5. If you use a measurement program, select **0** to zero set point number one.

### Point two

6. Move the detector to point number two, see image.
7. Adjust the laser beam by turning the screw on the transmitter's tilt table. Level to  $\pm 0.05$  mm or better.

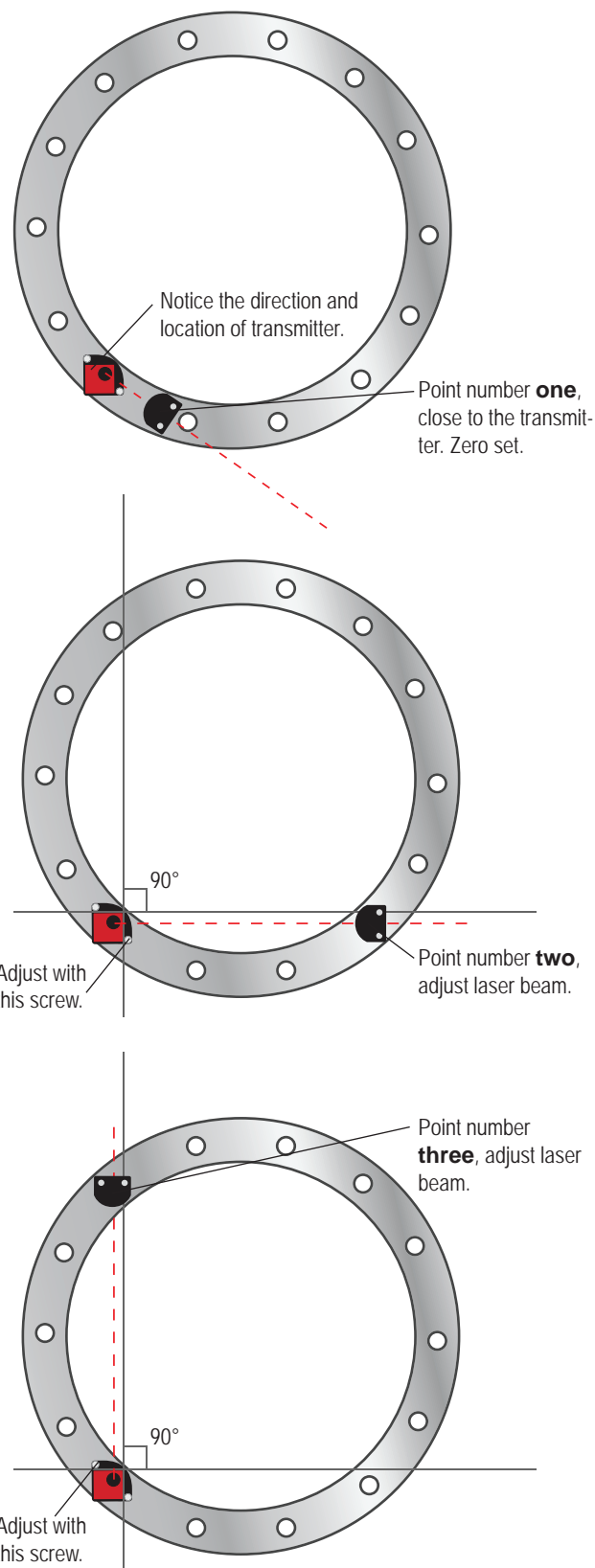
### Point three

8. Move the detector to point number three, see image.
9. Adjust the laser beam by turning the screw on the transmitter's tilt table. Level to  $\pm 0.05$  mm or better.

Repeat procedure until you have all three reference points within  $\pm 0.1$  mm.





### Note!

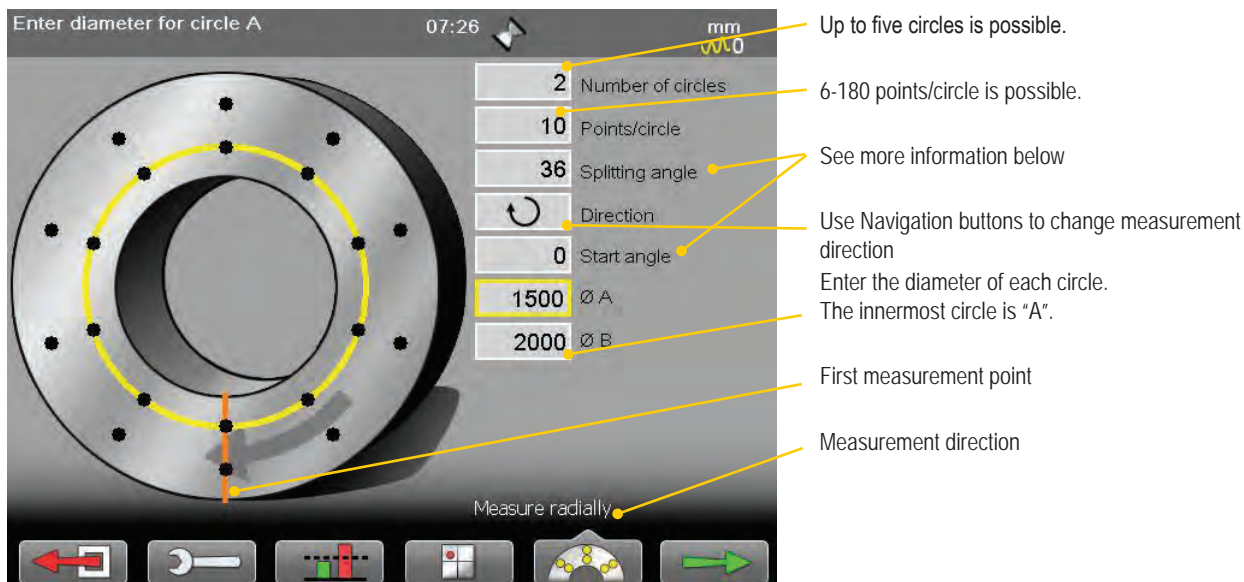
The tilting screws on the laser transmitter have to be operated carefully and according to instructions. See “Tilting screws” on page 59.



## Enter distances

You can measure 1 to 5 circles of measurement points, for example inner, middle and outer circles, in order to see the taper of the flange. Each circle can have 6 – 180 measurement points. It is possible to measure the points in different orders, inner or outer circle first, or radially.

1. Select  and  to open the Flange flatness program.
2. Enter distances, confirm with .
3. Select  to continue to measuring view.













### Splitting angle

The splitting angle is automatically calculated when you enter the number of measurement points. If you know the splitting angle, it is possible to enter this and get the number of measuring points.


### Start angle

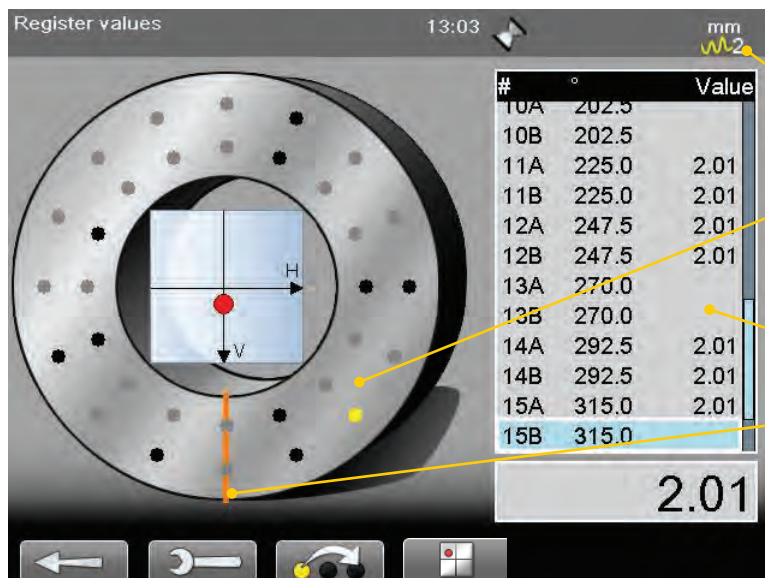
As default, the first measurement point is set to 0°. Select a start angle if you want to start somewhere else.

### Function buttons






	<b>Back.</b> Leave program.
	<b>Open Control panel.</b>
	See "Tolerance" on page 104.
	Show target.
	The measuring order you select is saved and used if you open the file as template or favourite.
	Measure all points on the inner circle first.
	Measure all points on the outer circle first.
	Measure radially, inner point first.
	Measure radially, outer point first.
	<b>Continue to measure.</b>

# Measure






1. If you are measuring a flange vertically, secure the laser transmitter with a safety strap. (Part no. 12-0554)
2. Press  to register measurement values. Registered points are greyed out. Active point is yellow.



See "Filter" on page 15.

-  Active point
-  Measured point
-  Unmeasured point
-  Point that has been skipped
-  First measurement point

## Function buttons



	<b>Back.</b> Press and hold to leave program completely.
	<b>Open Control panel.</b>
	Skip point. Only available when it is possible to skip the selected point. Some measurement points are mandatory to ensure an accurate measurement result.
	Show target.
	Continue to result. Available when you have measured all mandatory points.

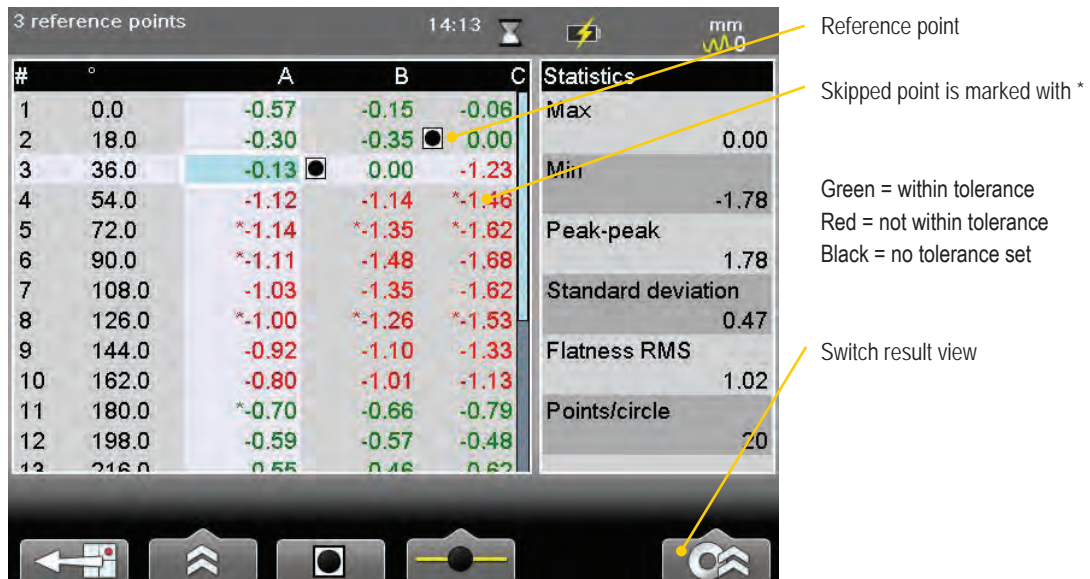
## Note!

The M-unit can be used as a detector together with a laser transmitter.  
Do not use the S-unit for this.

# Result











## Flange table view

Select  and  to display Table view. Use navigation buttons to move in the table. Points marked with \* have been skipped when measuring. Skipped points have a calculated value.



<b>Max</b>	The highest value.
<b>Min</b>	The lowest value.
<b>Peak-peak</b>	Difference between Max and Min value
<b>Standard deviation</b>	Point spread around the mean (average) value.
<b>Flatness RMS</b>	Root Mean Square (Numerical Flatness)

## Function buttons

	Remeasure.
	Open Control panel.
	Save. See "Measurement file handling" on page 11.
	Alter flange diameter.
	See "Tolerance" on page 104.
	Print on thermal printer (Optional equipment).
	Add reference point. Or press  to add reference points. Only available in the table view. See "Custom reference points" on page 100.
	See "Best fit" on page 101.
	Switch result view. Different flange and taper views.

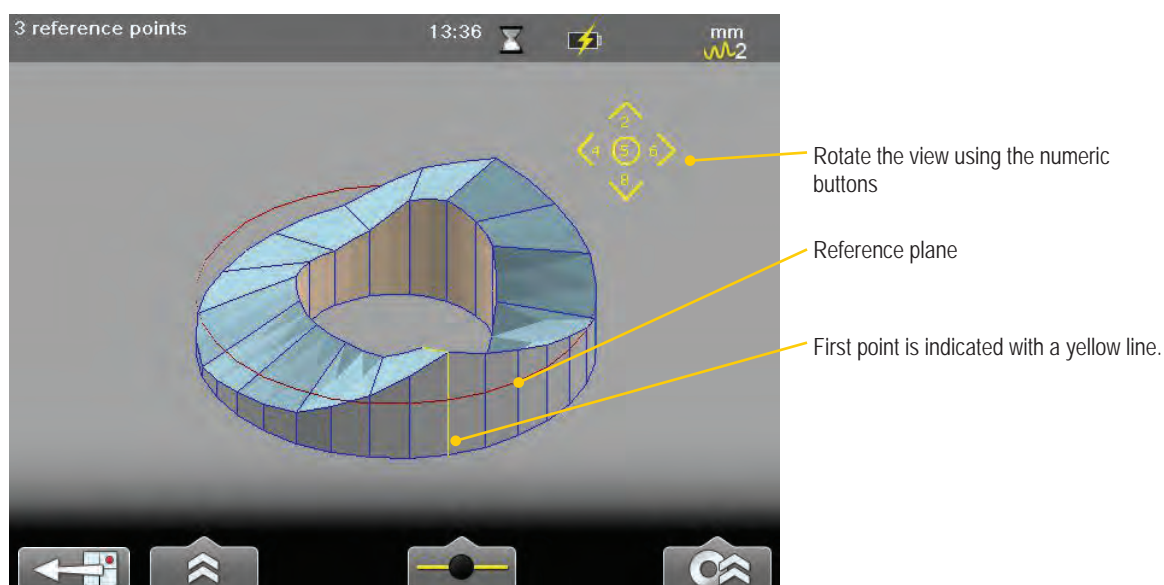


## Flange 3D view

Select  and  to display the 3D view.



Rotate the view using the numeric buttons.

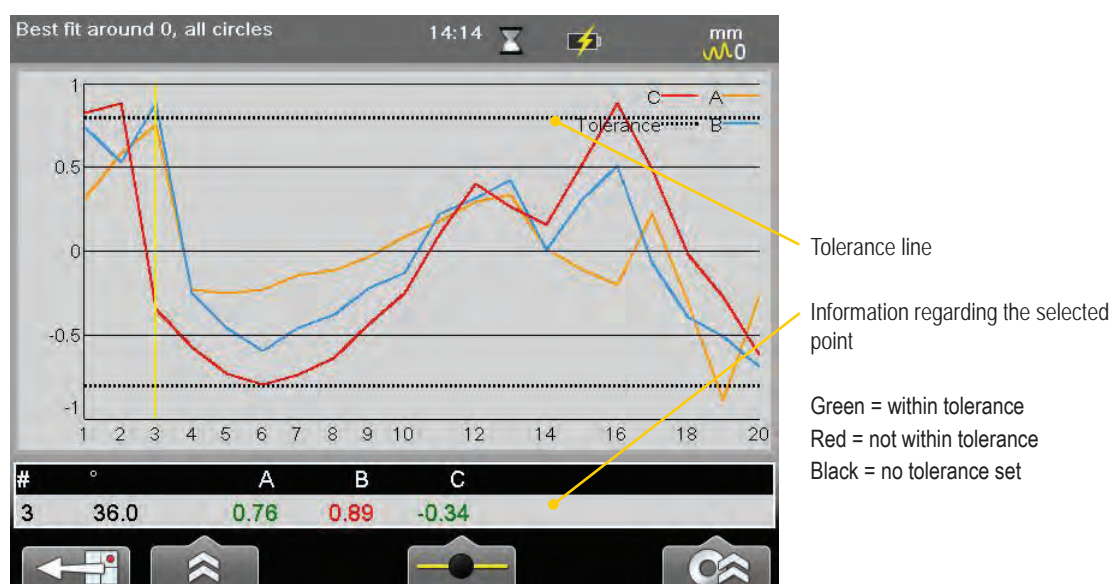
- Buttons 2, 4, 6 and 8 rotate the 3D view.
- Button 5 returns to the initial view.



Same function buttons as in Flange table view.

## Flange graph view

Select  and  to display the Graph view. In this view, you have a good overview of the result. Use the navigation buttons to move in the graph.



Same function buttons as in Flange table view.

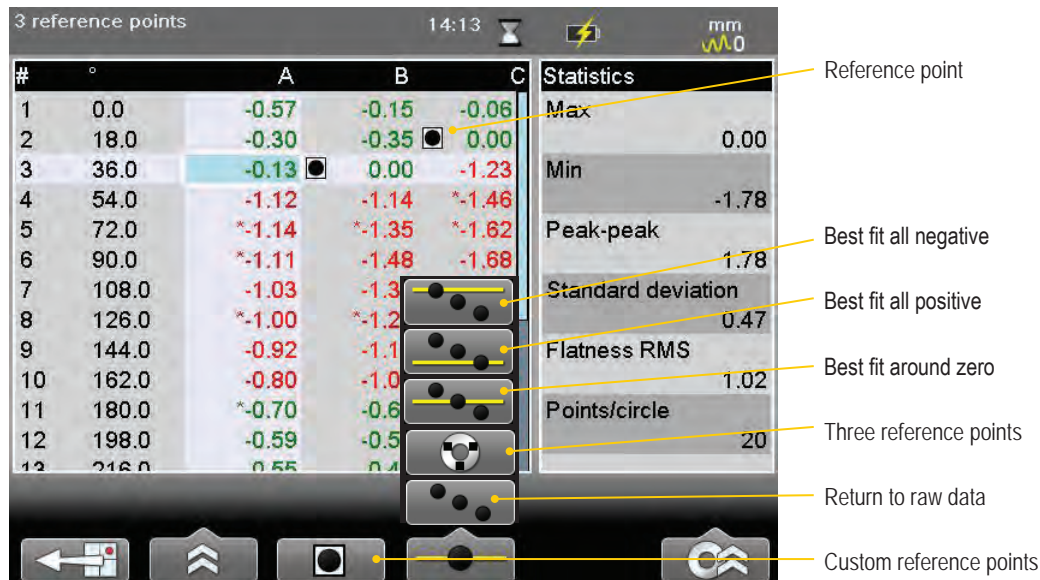


# Reference points




Reference points are needed when you are going to machine the surface.

You can try different scenarios and analyze the measurement result directly in the Display unit. You can also save reports with different settings to analyze further later.




See also “Best fit” on page 101.

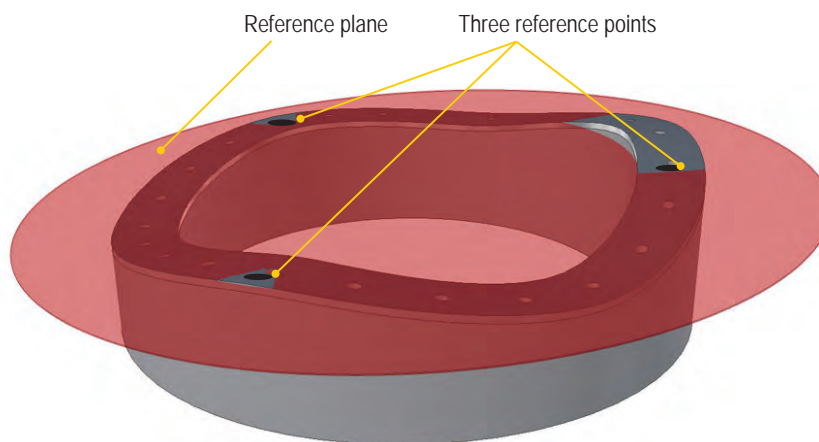


## Custom reference points

1. Select a measurement point in the Table view.
2. Select  to set currently selected point to zero. Or press .
3. Select one or three reference points. When you select a second reference point, the values are not recalculated. Set a third reference point to recalculate the values.
4. Select  if you want to return to raw data.

## Three reference points

1. Select  and  to set three reference points. Three points with the lowest peak to peak value are set to zero.
2. Select  if you want to return to raw data.

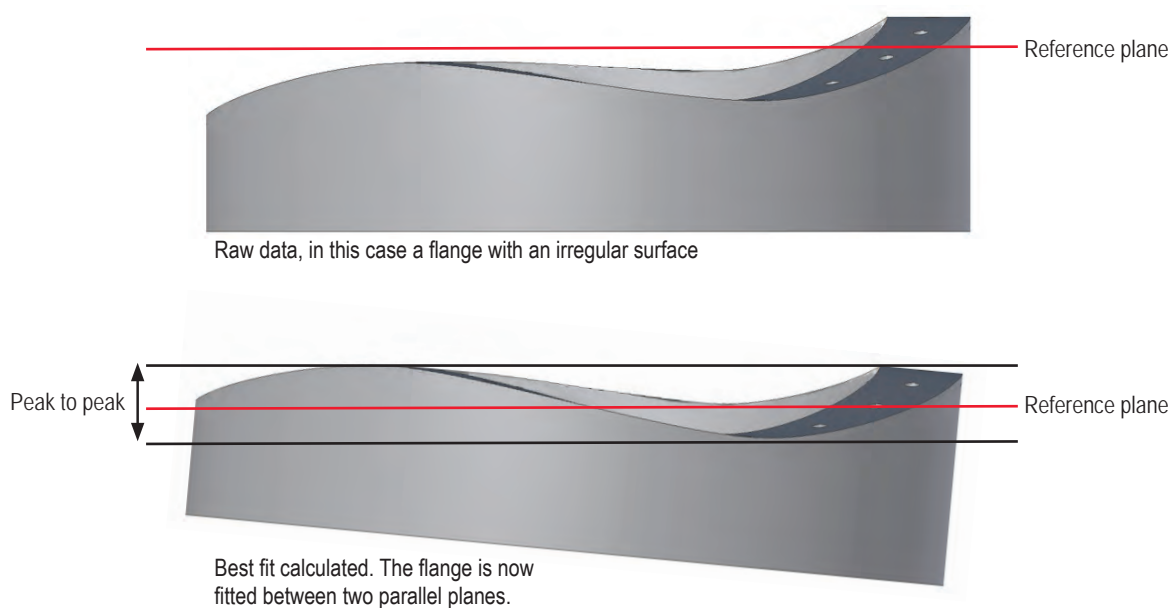


The reference plane is resting on three reference points.

## Best fit

When you perform a best fit calculation, the flange is tilted to the lowest peak to peak value. It is fitted as flat as possible between two planes.

See example below:



## Best fit around zero

Select  and  to calculate best fit around 0. Select one or all circles.

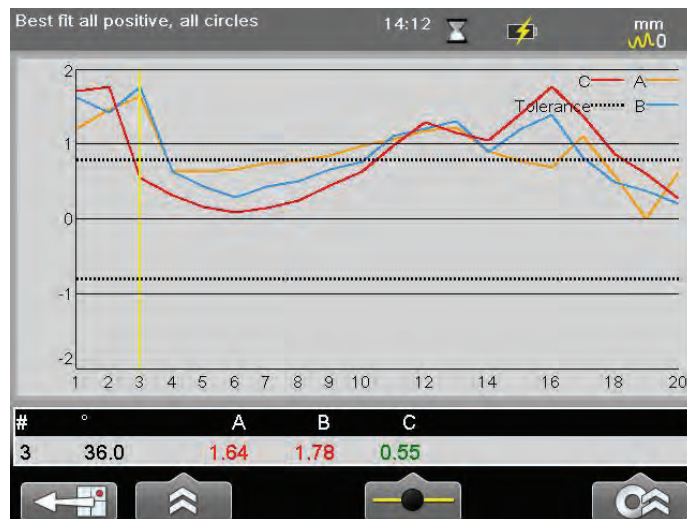
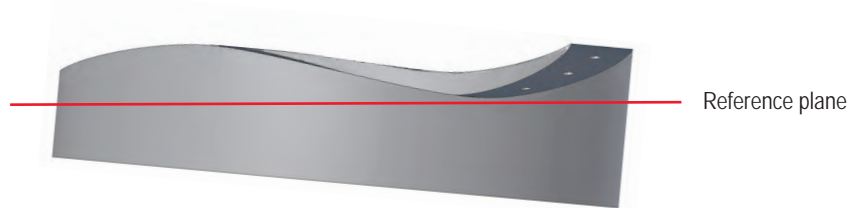




### Note!

You can save reports with different settings for best fit to analyze further later.

## Best fit all positive

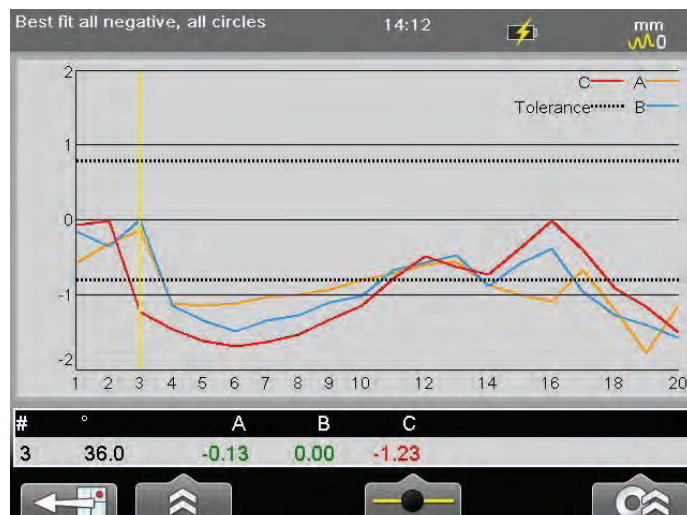
The flange is tilted as in a Best fit calculation, but the reference line is moved to the lowest measurement point.





Select  and  to calculate the best fit with all measurement points above 0. Select one or all circles.

## Best fit all negative

The flange is tilted as in a Best fit calculation, but the reference line is moved to the highest measurement point.





Select  and  to calculate the best fit with all measurement points below 0. Select one or all circles.



# Taper result

If you have measured two or more circles, you can calculate taper. Taper values can be displayed as graph or table. The taper values are recalculated when you select a different Best fit.


From the Result view, select  and  or . As default, the taper value of outer circle minus inner circle is displayed. To calculate a different taper value, select .

## Taper table



Select  and  to display Taper table. Here you get a good overview of the inclination of the flange, between the measured circles. Use navigation buttons to move in the table.

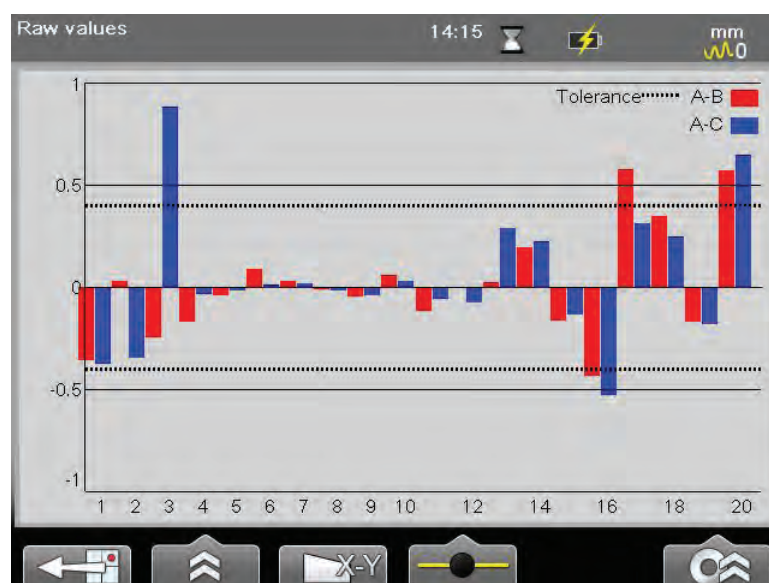
Best fit around 0, all circles 14:11  mm 

#	°	A-B	A-C
1	0.0	-0.42	-0.51
2	18.0	0.05	-0.30
3	36.0	-0.13	1.10
4	54.0	0.02	*0.34
5	72.0	*0.21	*0.48
6	90.0	*0.37	*0.57
7	108.0	0.32	0.59
8	126.0	*0.26	*0.52
9	144.0	0.18	0.40
10	162.0	0.21	0.33
11	180.0	*-0.04	*0.08
12	198.0	-0.02	-0.11
13	216.0	-0.09	0.07
14	234.0	0.01	-0.15



## Taper graph





Select  and  to display Taper graph. Use the navigation buttons to move around in the graph.



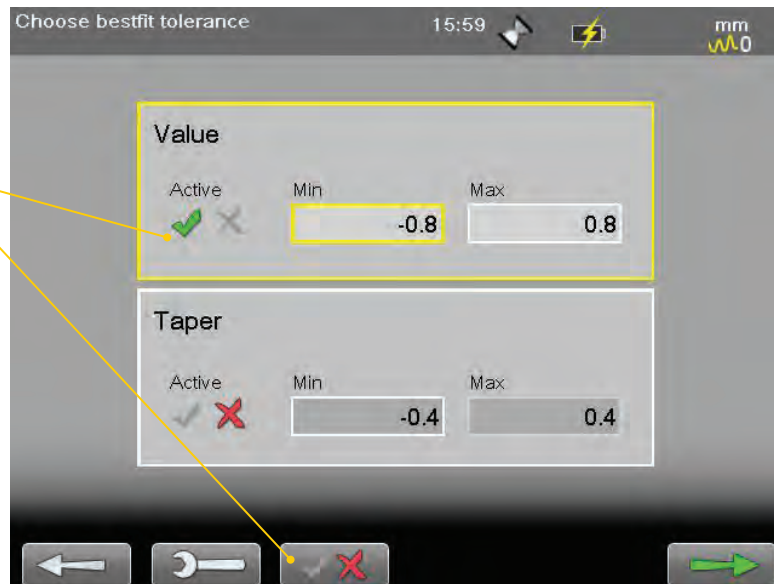


# Tolerance

It is possible to set tolerance on Taper and/or Best fit.

1. Select  and .
2. Enter tolerance values for Best fit and/or Taper.
3. Turn the tolerance on/off by  .

Activate/deactivate tolerance



Tolerance is displayed both in graph and table view.



# PARTIAL FLANGE FLATNESS

---



The program Partial Flange Flatness is primarily used when you want to measure only a part of a large flange. For example when a large wind tower is split in half before transportation.

## Preparations

- Ensure a good measurement environment. Strong sunlight, warning lights, vibrations and temperature gradients can affect the readings.
- Make sure the surface is clean.
- Use the program Values, Flange flatness or targets for the set up. The tighter the tolerances you require, the more important is an accurate set up and levelling.
- Fasten the laser transmitter using the safety strap.

---

### ***Note!***





*The M-unit can be used as a detector together with a laser transmitter.  
Do not use the S-unit for this.*

---



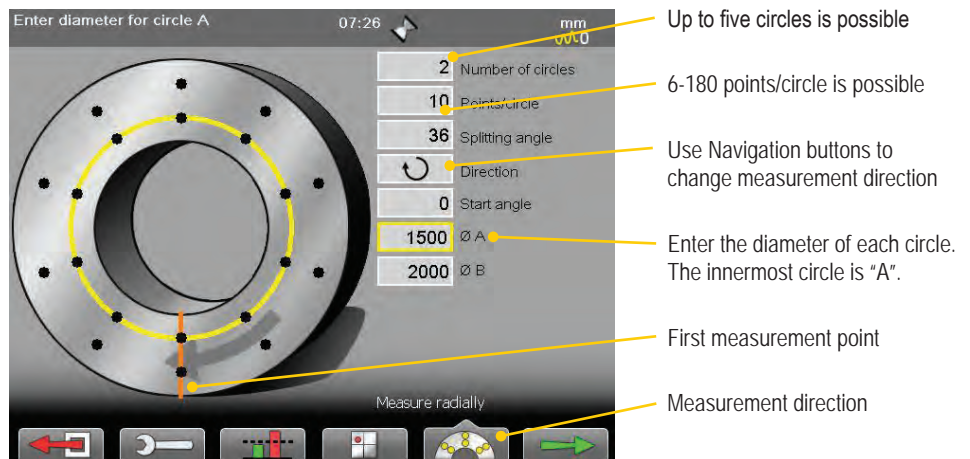
## Enter distances

You can measure 1 to 5 circles of measurement points, for example inner, middle and outer circles, in order to see the taper of the flange. Each circle can have 6 – 180 measurement points. It is possible to measure the points in different orders, inner or outer circle first, or radially.

1. Select  and  to open the Partial Flange Flatness.
2. Enter distances, confirm with . Enter number of points on the **whole** flange.
3. Select  to continue to measuring view.

### Note!

Enter number of points on the **whole** flange, not only the ones you will measure.













## Splitting angle

The splitting angle is automatically calculated when you enter the number of measurement points. If you know the splitting angle, it is possible to enter this and get the number of measuring points.



## Start angle

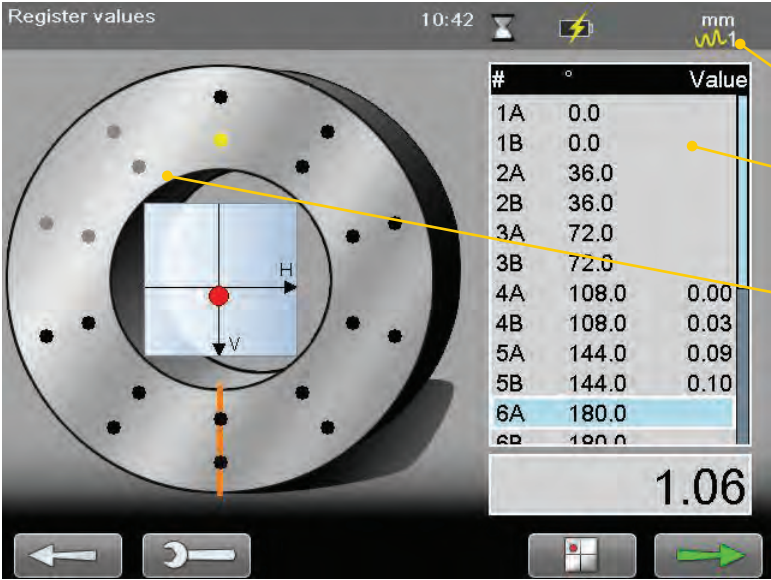
As default, the first measurement point is set to 0°. Select a start angle if you want to start somewhere else.

## Function buttons

	<b>Back.</b> Leave program.
	Open Control panel.
	See “Tolerance” on page 104.
	Show target.
	The measuring order you select is saved and used if you open the file as template or favourite.
	Measure all points on the inner circle first.
	Measure all points on the outer circle first.
	Measure radially, inner point first.
	Measure radially, outer point first.
	Continue to measure.




# Measure

- 1. If you are measuring a flange vertically, secure the laser transmitter with a safety strap. (Part no. 12-0554)
- 2. Press  to register measurement values. Registered points are greyed out. Active point is yellow.
- 3. When you have measured the points you need, select  to continue to Result view.








See "Filter" on page 15.

Points that has been skipped

-  Active point
-  Measured point
-  Unmeasured point

## Function buttons

	<b>Back.</b> Press and hold to leave program completely.
	Open Control panel.
	Delete point.
	Show target.
	Continue to result. Available when you have measured enough points.

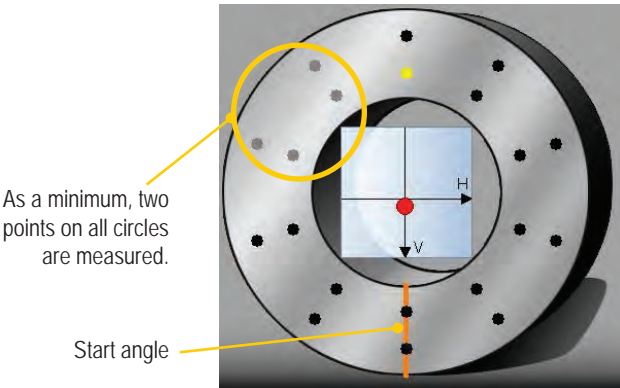
## Start angle and first measurement

If you do not want to start to measure where the start angle is, simply use the navigation buttons to move to where you want to measure. You can skip points, but you can not leave "holes" in the area where you want to measure.

## Minimum no. of measurements points

One circle:  
as a minimum, you need to measure four points.

Two or more circles:  
as a minimum, you need to measure two points on all circles, see image.

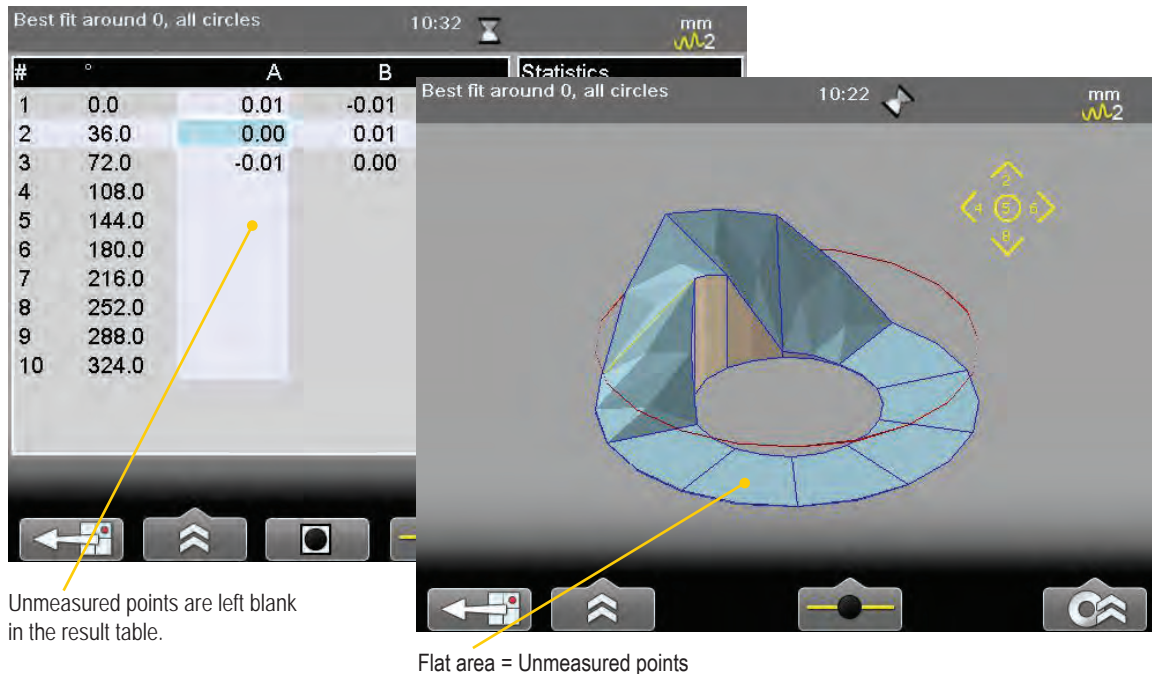


# Result

The result can be shown as table, graph or 3D.

See *Flange Flatness “Result”* on page 98.

The only thing that differs from the Flange Flatness result, is that the unmeasured points are left blank.



## Reference points

It is possible to set custom reference points or to select three reference points automatically.

See *“Reference points”* on page 100.

## Best fit

When you perform a best fit calculation, the flange is tilted to the lowest peak to peak value. It is fitted as flat as possible between two planes.

See *“Best fit”* on page 101.

## Taper

If you have measured two or more circles, you can calculate taper.

See *“Taper result”* on page 103.

## Tolerance

It is possible to set tolerance on Taper and/or Best fit.

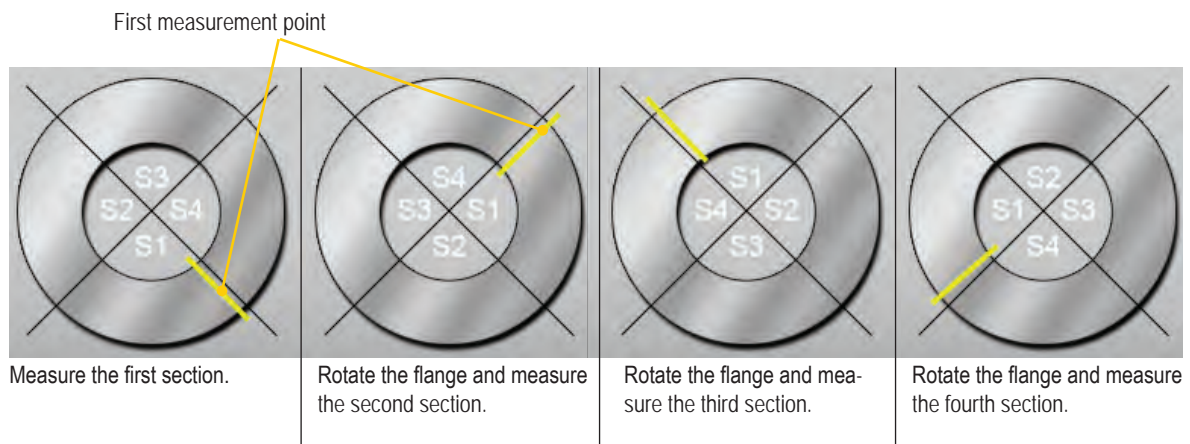
See *“Tolerance”* on page 104.

# FLANGE FLATNESS SECTION

---



The program Flange Flatness Section is primarily used for large flanges. The flange is divided into four sections and rotated for easy measuring. Thanks to the fact that you only measure the lower part of the flange, there is no need to climb to fasten detectors or laser transmitters.



You can measure 1 to 5 circles of measurement points, for example inner, middle and outer circles, in order to see the taper of the flange. Each circle can have 16 – 180 measurement points. The program guides you graphically step-by-step through the entire measurement.

---

### **Note!**

*The M-unit can be used as a detector together with a laser transmitter.  
Do not use the S-unit for this.*

---



### **Note!**

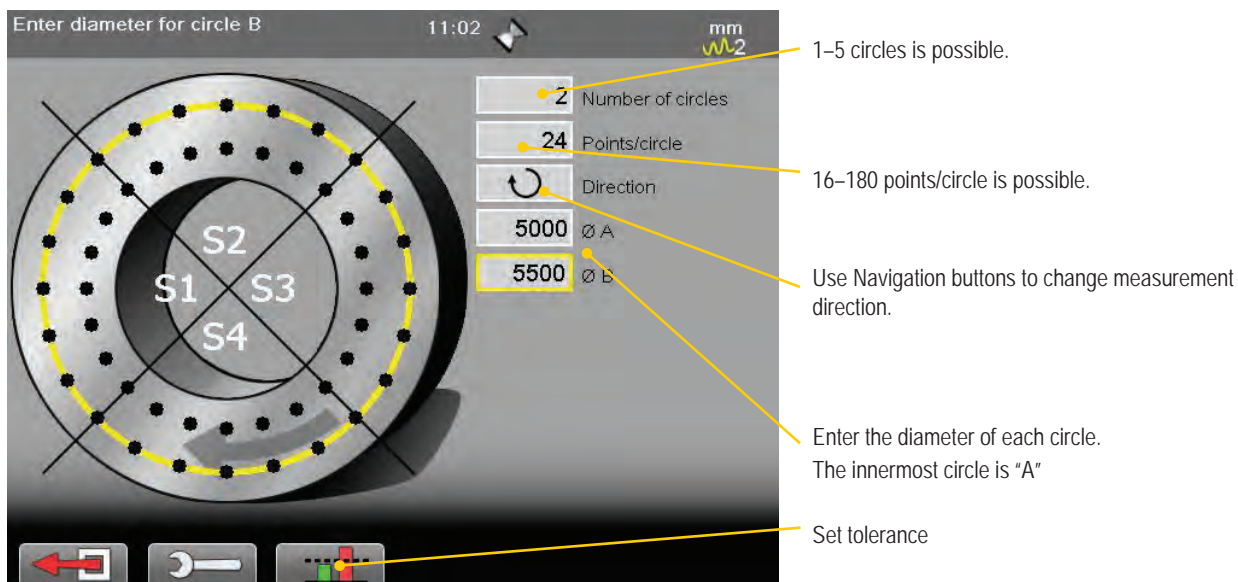
**International patent pending (PCT/EP2014/052631)**



# Preparations

## Enter distances

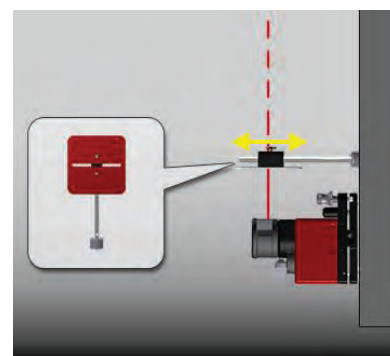
1. Select  and  to open the Flange flatness section program.
2. Enter distances, confirm with .



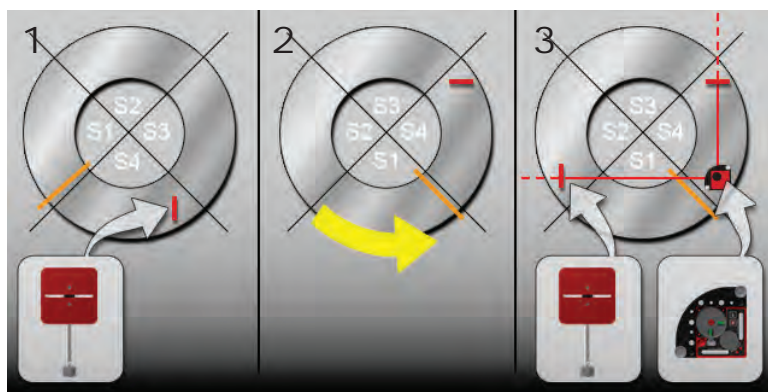
## Visual targets

Adjust all three visual targets; place the target close to the laser transmitter and make sure that the laser beam goes through the slit.

1. Mount a target on the flange. Where you place it depends on which measurement direction you have chosen. Follow the instructions on screen.
2. Rotate flange. Note the direction on the screen.
3. Mount the laser transmitter and a laser target as shown on screen. Secure the laser transmitter with a safety wire. (Part no. 12-0535). Adjust laser transmitter if needed.





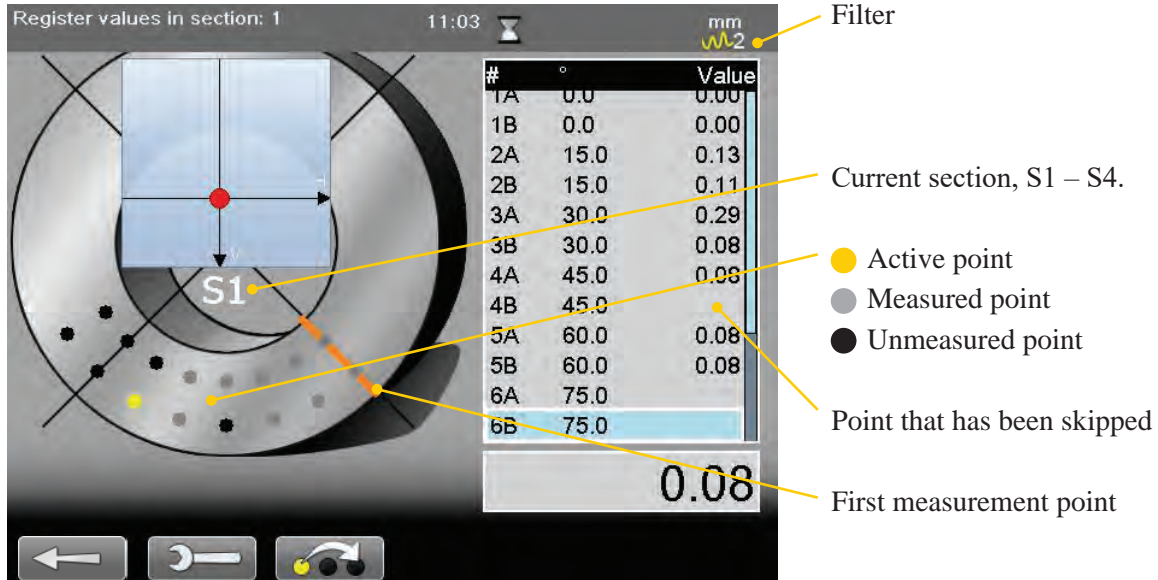
Adjust all three targets







Follow instructions on the screen

# Measure

1. The first measurement point is marked with a line. Active point is yellow.
2. Press  to register measurement values. Registered points are greyed out.
3. Select  to continue to next section.



## Function buttons

	<b>Back.</b> Press and hold to leave program completely.
	<b>Open Control panel.</b>
	Skip point. Only available when it is possible to skip the selected point. Some measurement points are mandatory to ensure an accurate measurement result.
	Available when you have measured all mandatory points. <b>When you leave the current section, it is not possible to go back to remeasure.</b>

## Filter

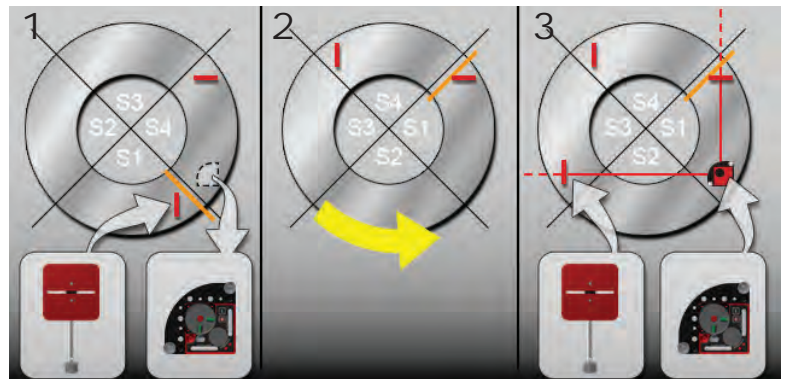
The filter is increased by two steps when measuring merge points. It is possible to override this. See “Filter” on page 15.

### Note!

The merge points are analyzed and if uncertain points are found, a warning is displayed in the result. Uncertain merge points are also noted in the report.

## Rotate flange

1. Remove laser transmitter and place a target as shown on the screen.
2. Rotate flange. Note the direction on the screen, it is contrary to the selected measurement direction.
3. Mount the laser transmitter and a laser target as shown on screen. Secure the laser transmitter with a safety wire. Adjust laser transmitter if needed.





## Result

The result can be shown as table, graph or 3D. If you have measured two or more circles, you can see Taper result.

See *Flange Flatness “Result” on page 98.*

## Reference points

It is possible to set custom reference points or to select three reference points automatically.

See *“Reference points” on page 100.*

## Best fit

When you perform a best fit calculation, the flange is tilted to the lowest peak to peak value. It is fitted as flat as possible between two planes.

See *“Best fit” on page 101.*

## Taper

If you have measured two or more circles, you can calculate taper.

See *“Taper result” on page 103.*

## Tolerance

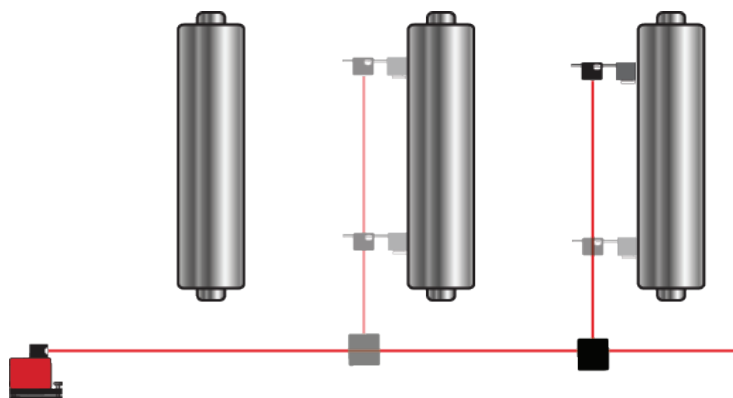
It is possible to set tolerance on Taper and/or Best fit.

See *“Tolerance” on page 104.*

# PARALLELISM A



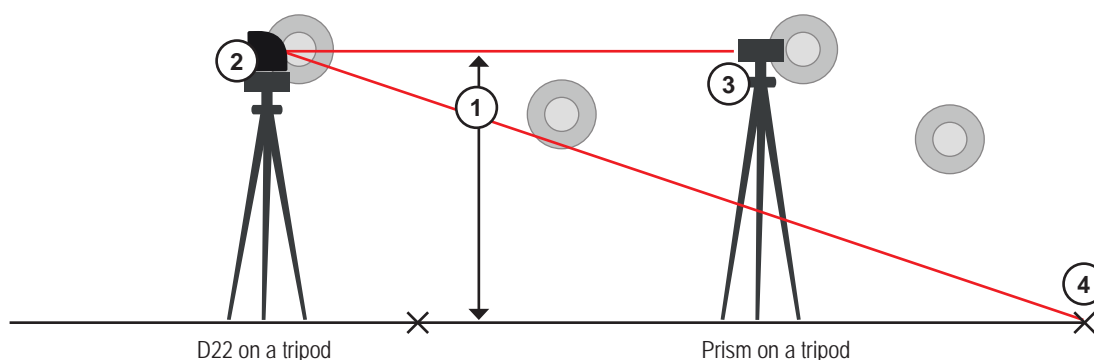
Examples of parallelism measurement include parallelism between rolls and other surfaces in papermaking machines, printing presses, rolling mills, etc. Other examples include overhead tracks, rails, press machine tables.



## Laser setup

To establish a good reference line, it is important to set up the laser correctly. The reference line is often a line alongside the machine, but can also be a fixed object in the machine.

1. Mount the laser on the same height as the prism.
2. Level the laser according to the spirit level.
3. Adjust the prism so that the laser beam hits the centre of the target. See “*Prism set up*” on page 8.
4. Direct the laser beam along the machine, and perpendicular to the measurement object. Use targets, or mount detectors to set up the reference line.



## Align the D46 prism

The penta prism in the D46 deflects the laserbeam  $90^\circ$ . To keep the accuracy of the prism when measuring, the prism should be aligned to the center of and parallel to the laser beam.

### Mount the equipment

1. Mount the D22 on a tripod.
2. Mount the angular prism on a sliding table and then on a tripod.

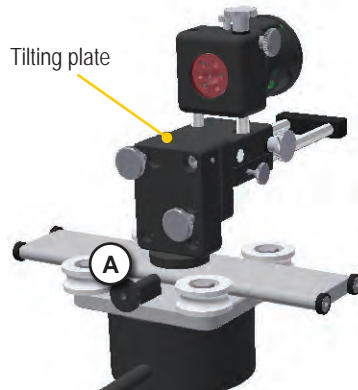


Image showing the prism close to the tilting plate.

### Rough align

Keep the yellow cover on the prism.

3. Adjust the tripod until the prism is on the same height as the laser transmitter.
4. Slide the prism **close** to the tilting plate. Adjust sideways using (A).
5. Slide the prism **away** from the tilting plate. Adjust the height and angle using the tripod functions.

Repeat step 4 and 5 until the laser beam hit the centre of the cover in both positions.

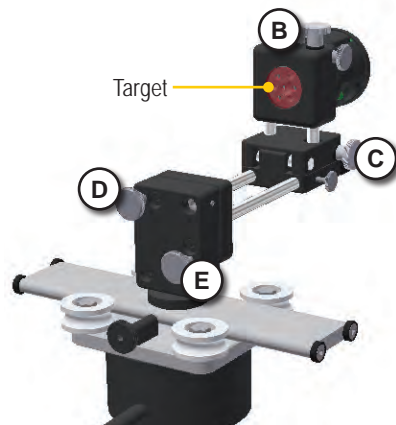
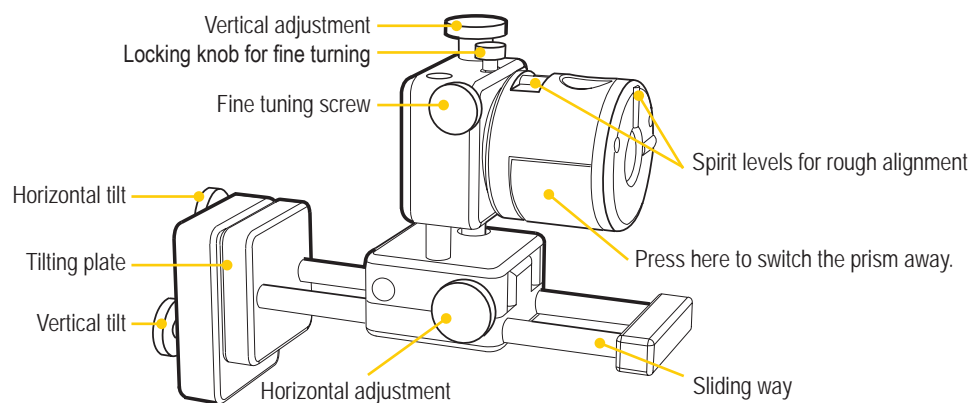


Image showing the prism away from the tilting plate.

### Fine adjustment

6. Switch the prism to let the laser beam hit the target on the back.
7. Slide the prism **close** to the tilting plate. Adjust the offset using (B) and (C).
8. Slide the prism **away** from the tilting plate. Adjust the angle using (D) and (E).
9. Repeat step 7 and 8 until the laser hit the centre of the target in both positions.

Now the angular prism can be moved along the sliding way to aim the laser beam to the detector.

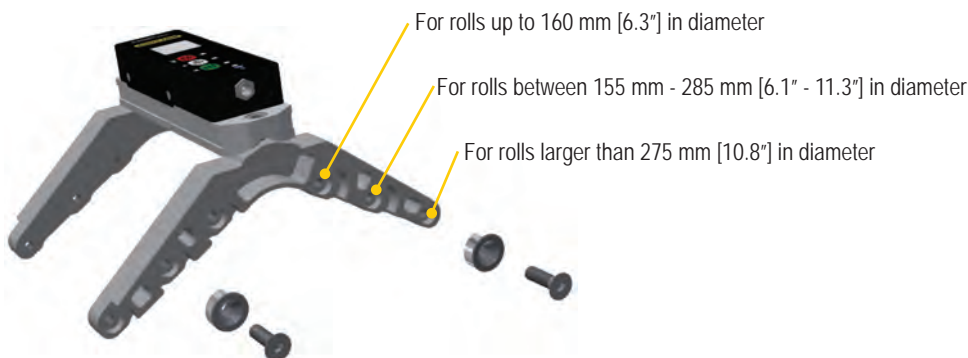


# Precision level

The precision level is used to measure the vertical value. It is possible to skip the Precision level for all or single rolls. See also “*Precision level E290*” on page 223.

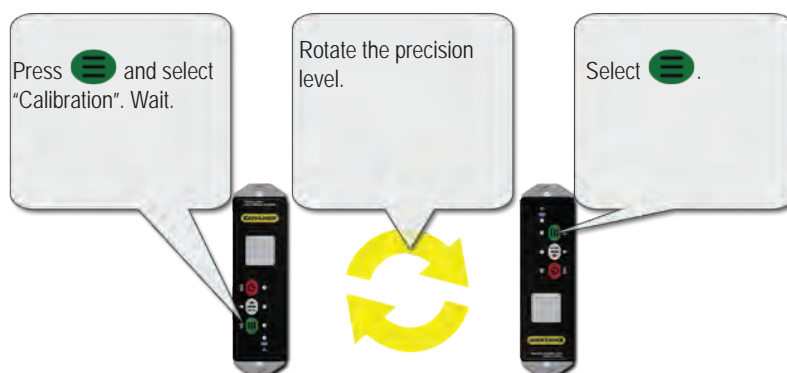
## Bracket for different roll sizes

Use the bracket to ensure that the Precision level lands firmly on the roll. Mount the wheels in the appropriate position and then calibrate the Precision level. If you change position of the wheels, you need to calibrate the Precision level again.



## Calibrate the precision level

1. Place the Precision level on the reference roll. Make a mark on the roll to ensure that you place it in the same position.
2. Press and select “Calibration”.
3. Wait approx 15 seconds, until the value has stabilized. Press .
4. Rotate the Precision level 180°.
5. Wait approx 15 seconds, until the value has stabilized. Press . The Precision level has been calibrated. The calibration is saved even when the Precision level is switched off.



### **Note!**

When you use the Precision level, it has to be switched on during the whole measurement.

## Set up wireless connection



Make sure that the Precision level is connected to the Display unit via wireless connection.

1. Select and to open the Control panel.
2. Select .
3. Select to search for wireless units.

See also “*Set up wireless connection*” on page 21.

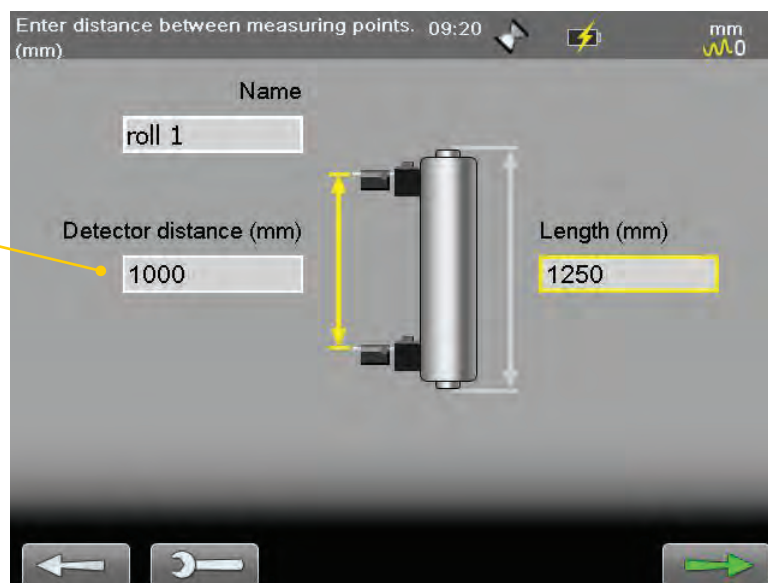
# Measure

## Enter distances

1. Enter a name or keep the default name. Press .
2. Enter the distance between the detectors. Measure between the rods.
3. Press  to continue to Measure view, or use navigation button to enter the distance between the adjustment points.


The distance between adjustment points is not mandatory. If you leave the space empty, it will be filled in with the same length as the detector distance.

Make this distance as far as possible.  
This will give an even more accurate measurement.



## Measure vertical position

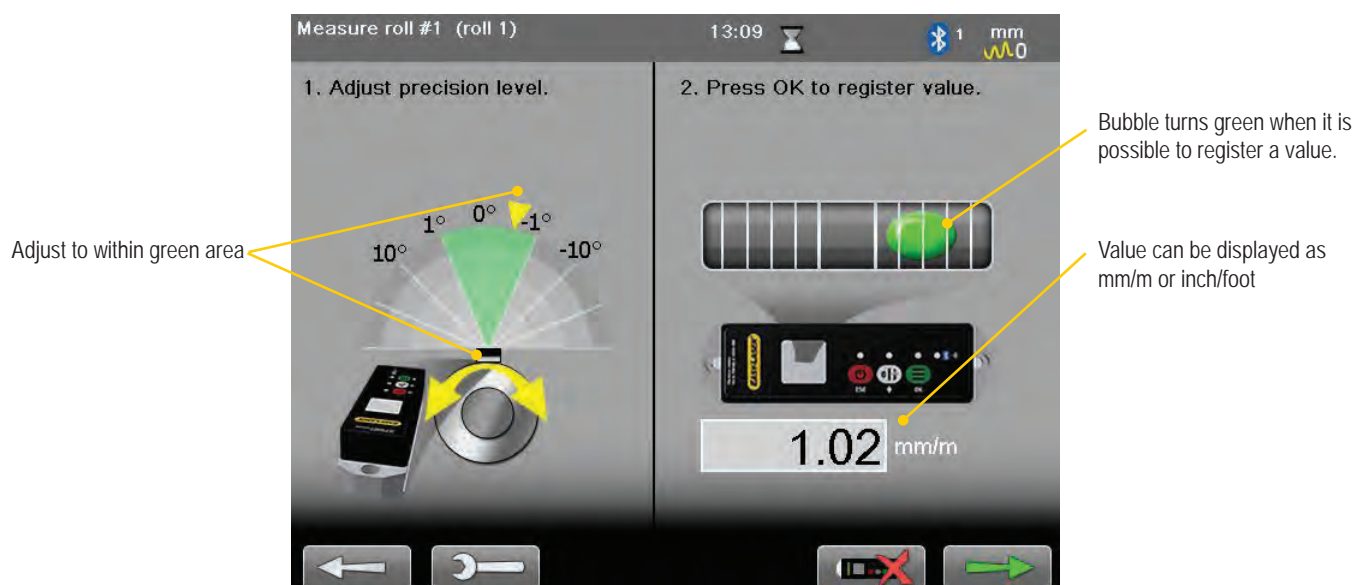
The vertical position of the object is measured with the Precision level. For a correct measurement result, it is very important that you place the Precision level in the same direction on all rolls.

1. Adjust the Precision level until the yellow arrow is within the green area.
2. Wait until the value has stabilized (approx. 15 sec.)
3. Press  to register measurement value.







Place the Precision level in the same direction on all rolls!

The value is shown as mm/m or inch/foot. When it is not possible to register a value, the bubble turns red and the value is shown in degrees. To change unit, see “Unit and resolution” on page 16.



### Function buttons

	Back to Distance view.
	See “Control panel” on page 15.
	Skip measuring with the Precision level for <b>all rolls</b> . It is possible to turn it back on again from the result view.
	Continue. Skip measuring with the Precision level for <b>this roll</b> .

### Skip Precision level

It is possible to skip measuring with the Precision level. When you do, you will not have a vertical value in the result view.






#### Note!

If you use cables to your detectors, remove the cable from the Display unit before measuring using the Precision level.

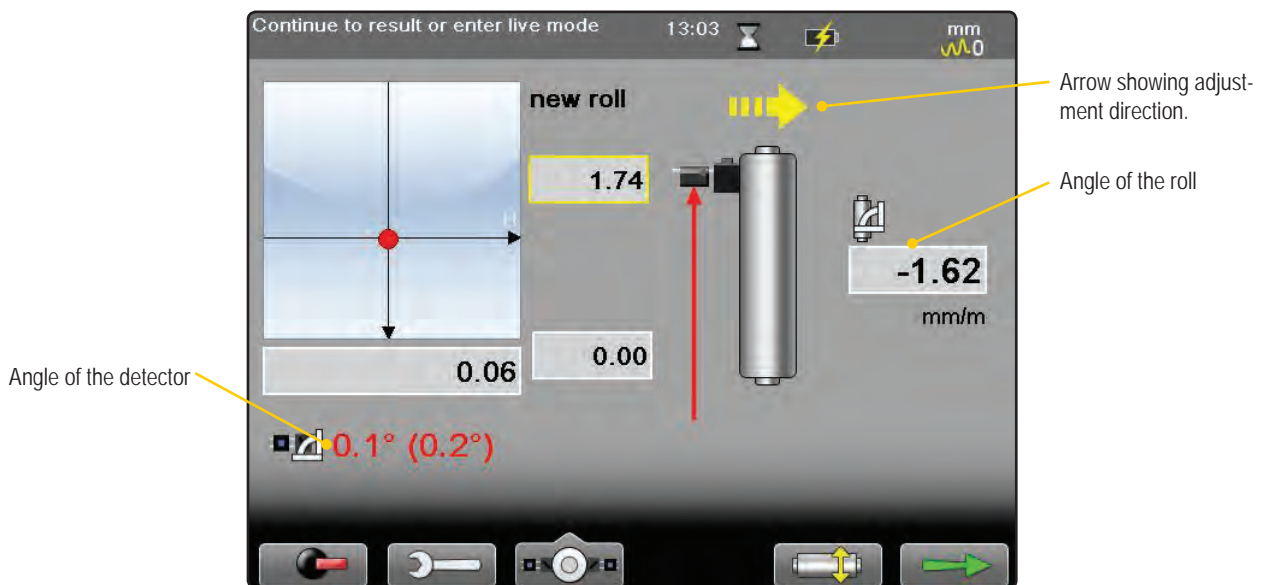


## Measure horizontal position






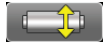


The horizontal position of the object is measured with the detector.

1. Place the detector on the roll. The Display unit will recognize how the detector is placed. If you want to change it, use .
2. Use the navigation buttons to change the active measurement position.
3. Angle the laser beam along with the roll. See *“Align the D46 prism” on page 114*.
4. Adjust the laser beam via the prism until you hit the centre of the target.
5. Press  to register the first position.
6. Move the detector to the second position.
7. Press  to register the second position. The angle of the roll is displayed.
8. Press  to go to Result view. Or select  to adjust the roll.




From the result view, select  and  to add a new roll.

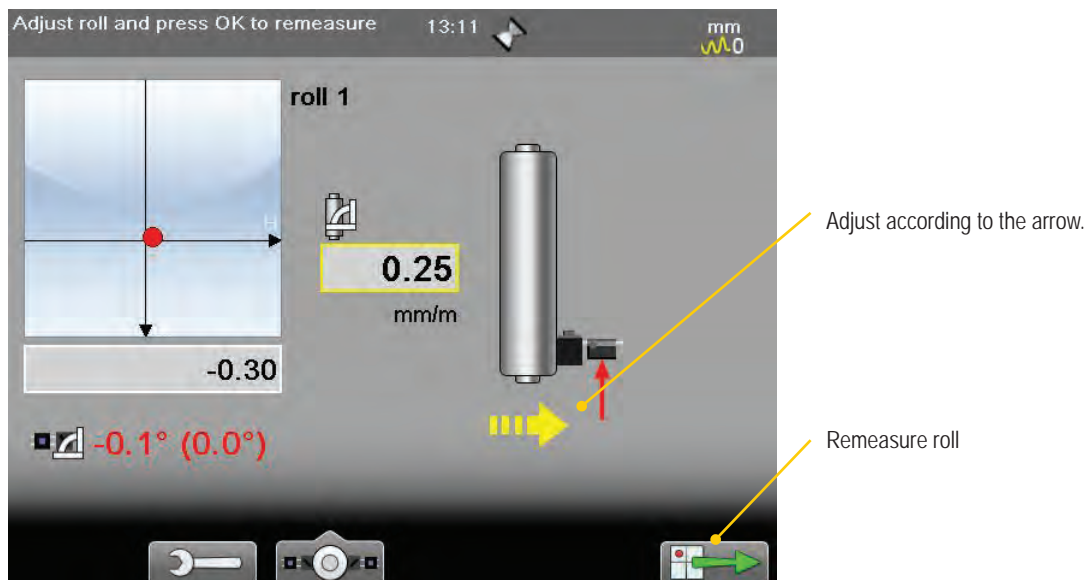


### Function buttons

	Remove latest registered measurement point.
	See <i>“Control panel” on page 15</i> .
	Automatic recognition, the Display unit recognizes how the detector is placed.
	The detector is placed on the right side.
	The detector is placed on the left side.
	Go to live adjustment view. See <i>“Adjust roll live” on page 119</i> .
	Forward to Result view.
	Forward from Adjust view. When you have adjusted a roll, you need to remeasure the roll.

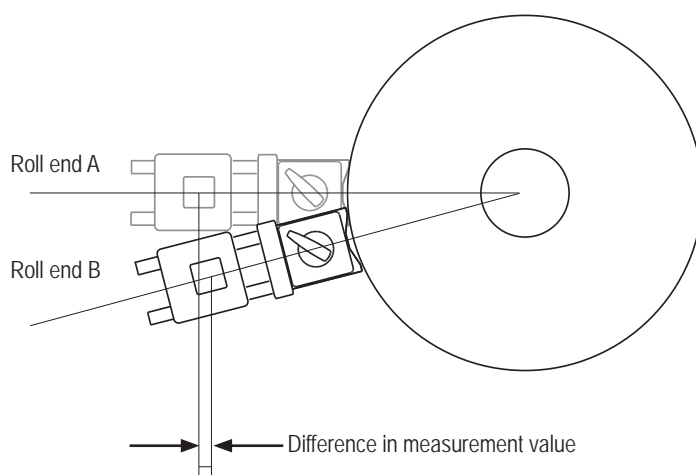
## Adjust roll live

1. From the Measure view, select  to adjust the roll live.
2. Adjust the roll according to the arrow.
3. Press  or  to continue. The Measuring view is displayed and you are prompted to remeasure the adjusted roll before you can continue.



## Detector angle

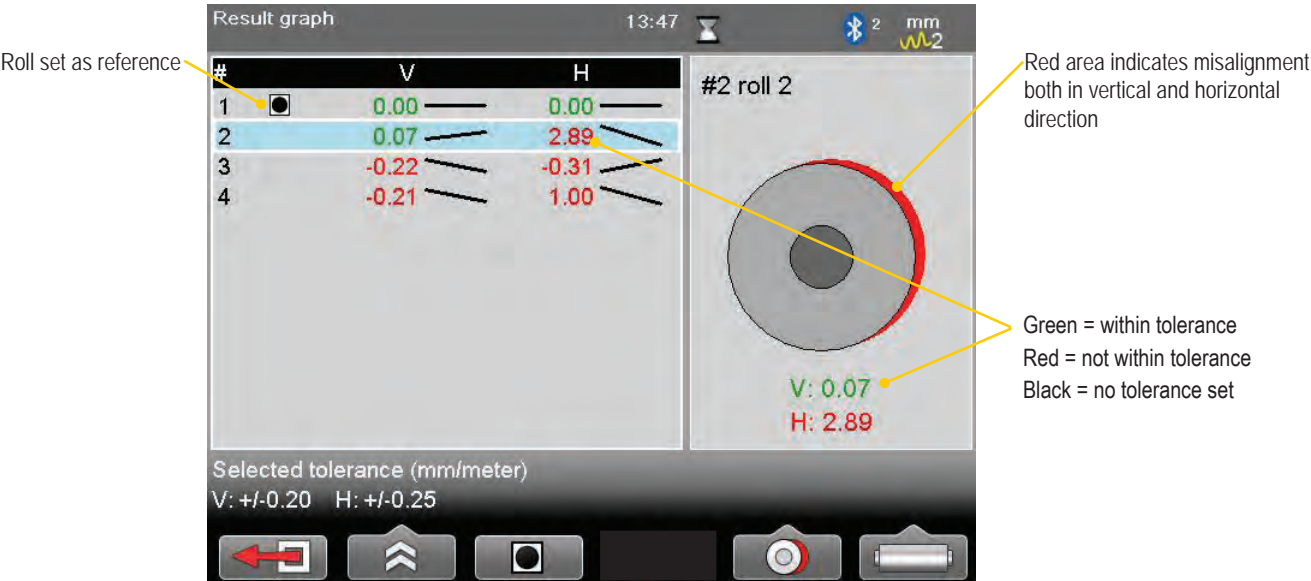
The position of the detector affects the measurement value when measuring parallelism. Therefore it is important to place the detector at the same angle at measurement position 1 and 2. At a 500 mm radius an angular deviation of 1° will cause a 0.1 mm difference in the measurement value.



# Result

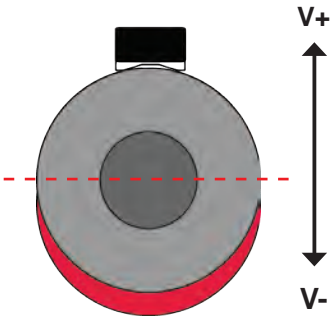
## Table view

By default, the table view is displayed.



### Vertical

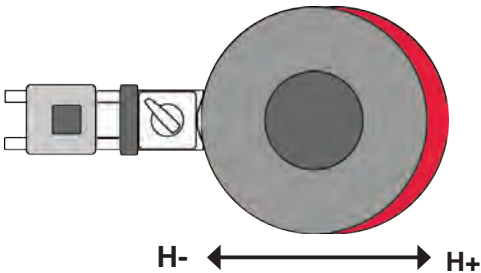
The vertical position is measured with the Precision level.



In this example, the roll has a negative vertical value.

### Horizontal

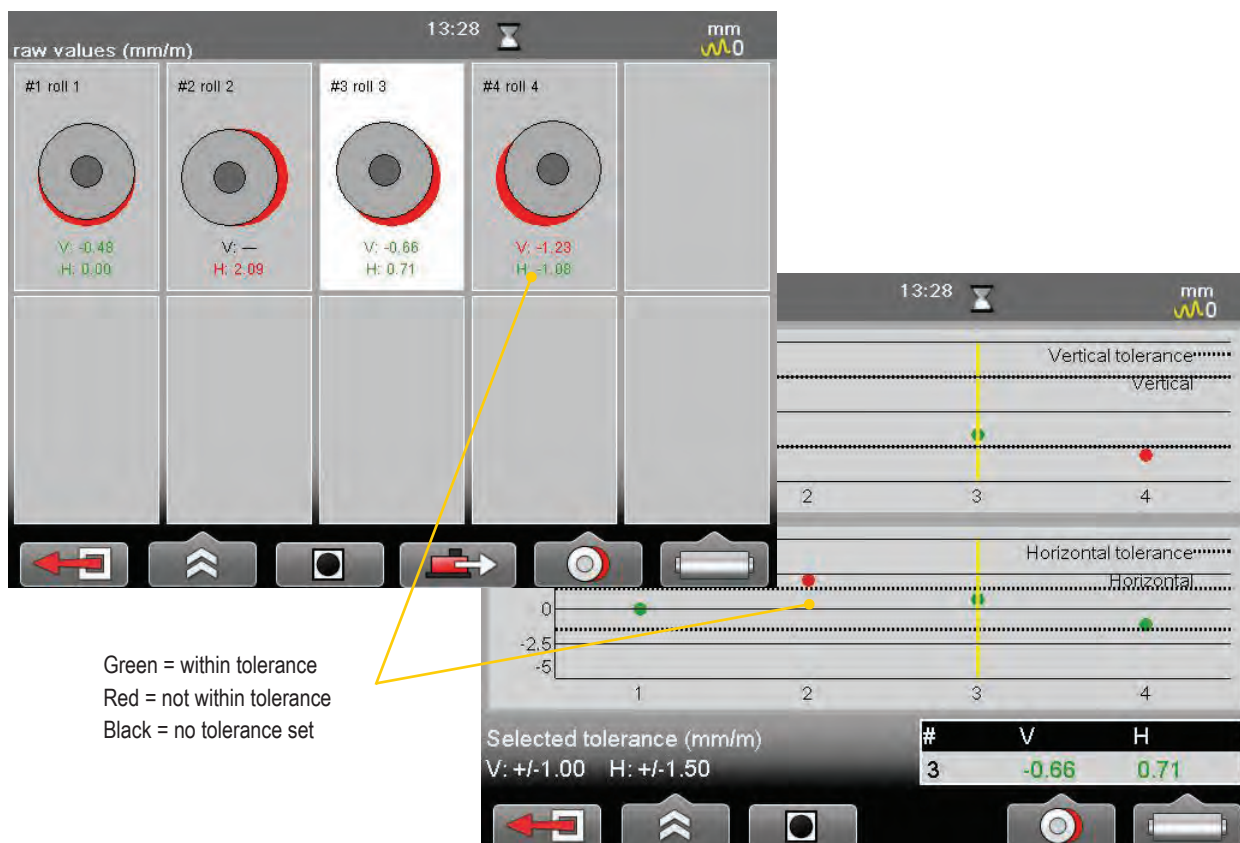
The horizontal position is measured with the Detector. When reading the horizontal value, face the laser transmitter from the roll. Then the value correspond to the measurement program.



In this example, the roll has a positive horizontal value.

## Side and Graph view

The Side view and Graph view are great when you want to get an overview of all rolls.



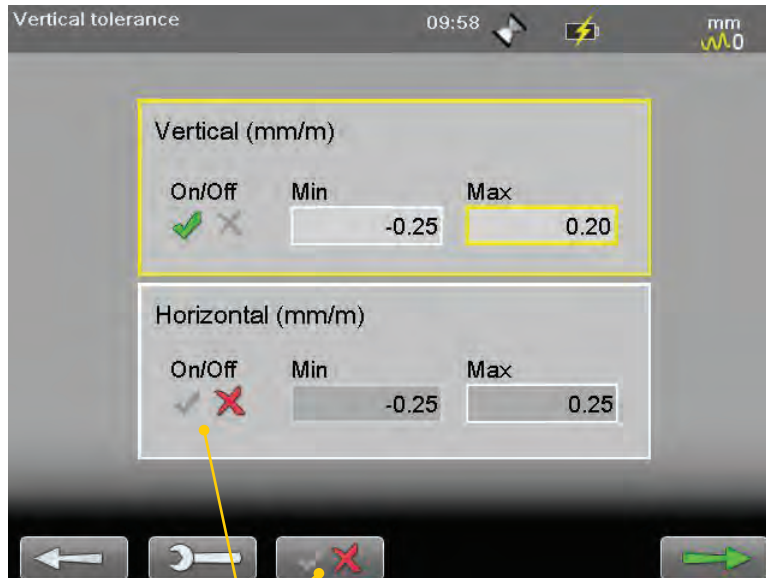
## Function buttons

	Leave program.
	See "Control panel" on page 15.
	See "Measurement file handling" on page 11.
	See "Tolerance" on page 122.
	Alter distance and/or name on roll.
	Turn the Precision level on/off.
	Toggle button. Set selected roll as reference. Or press .
	Show Result table view.
	Show Result side view.
	Show Result graph view.
	Add a new roll and measure it.
	Adjust and/or remeasure selected roll.

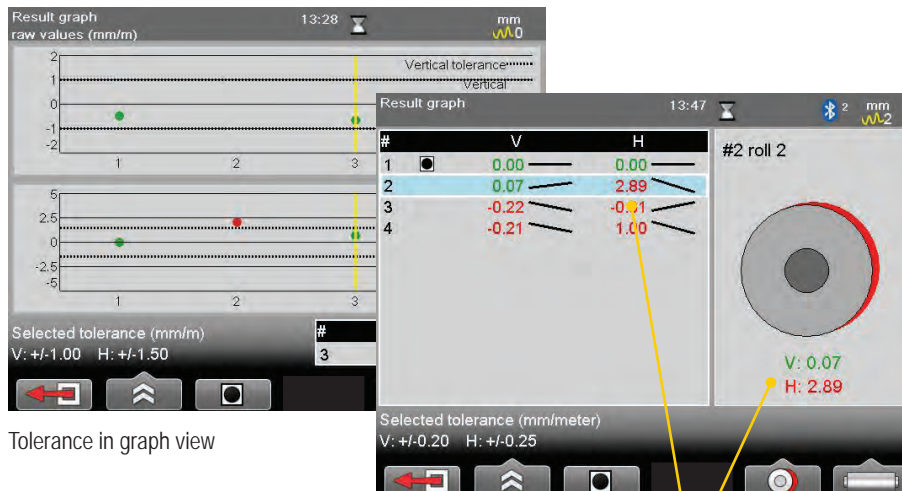
## Tolerance

Select  and  to set tolerance.

- The maximum value has to be greater than the minimum value.
- When you use Metric (mm) two decimals is possible
- When you use Imperial (inch/foot), four decimals is possible



It is possible to set tolerance and then deactivate it.  
A deactivated tolerance is not used in the measurement.



Tolerance in graph view

Tolerance in table view

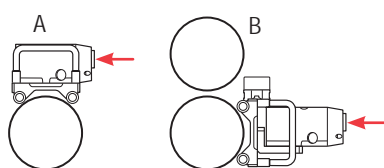


# PARALLELISM B



Parallelism B is used for fast replacement and alignment of rolls in, for example, printing presses, paper machines and converting machines. Easy-Laser® E975 offers precision of  $\pm 0.02$  mm/m (0.001 degree).

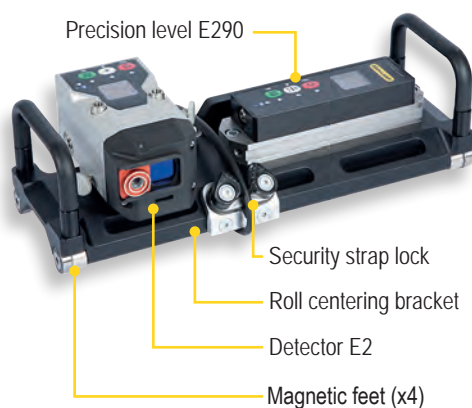
First you measure the vertical angle, then the horizontal. Maximum distance between transmitter and detector is 20 metres. The rolls can be mounted at different heights.



Alternative mounting of units:

A: Top attachment

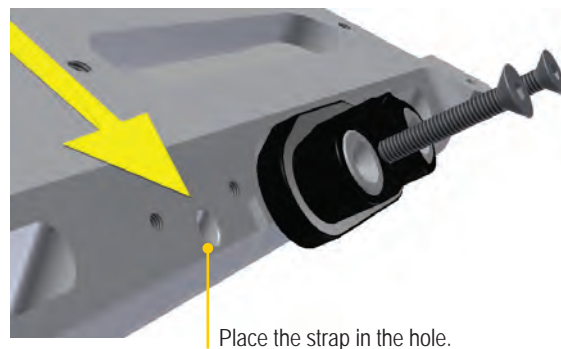
B: Front attachment. If space on top is limited.



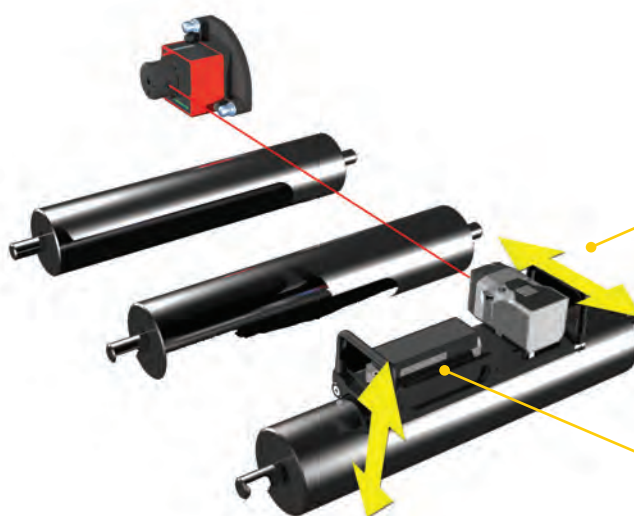
## Mount the security strap

1. Unscrew the security strap lock.
2. Place the end of the security strap in the hole.
3. Screw the lock back in place. Make sure that the strap is securely in place.

Before each measurement, make sure that the security strap is undamaged.



Place the strap in the hole.



### Horizontal values

The horizontal value is measured with the Detector E2.

### Vertical values




The vertical value is measured with the Precision level.

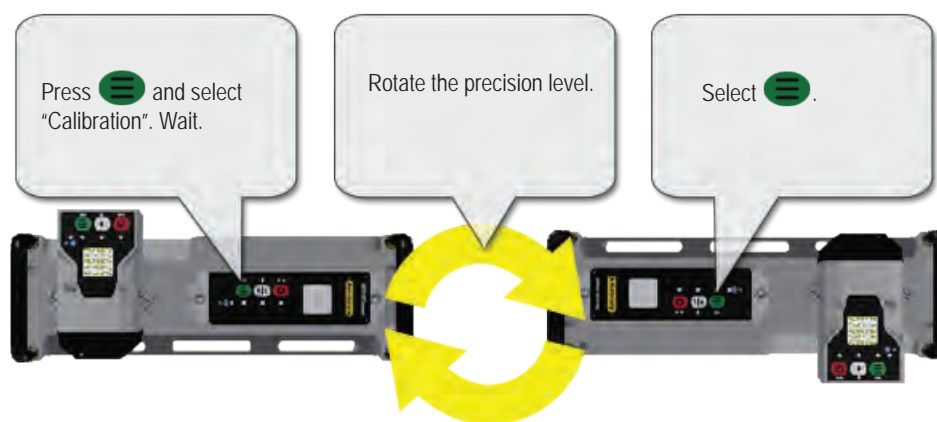


# Preparations

The precision level is used to measure the vertical value. It is possible to skip the Precision level for all or single rolls. When you use it, the Precision level has to be switched on during the whole measurement.

## Calibrate the precision level

1. Place the bracket with the Precision level on the reference roll. Make a mark on the roll to ensure that you place it in the same position.
2. Press  and select "Calibration". Wait.
3. Wait until the value has stabilized. Press .
4. Rotate the Precision level 180°.
5. Wait until the value has stabilized. Press . The Precision level has been calibrated. The calibration is saved even when the Precision level is switched off.







See also "Precision level E290" on page 152.

### Note!









When you use the Precision level, it has to be switched on during the whole measurement.

## Set up wireless connection

Make sure that the Precision level is connected to the Display unit.

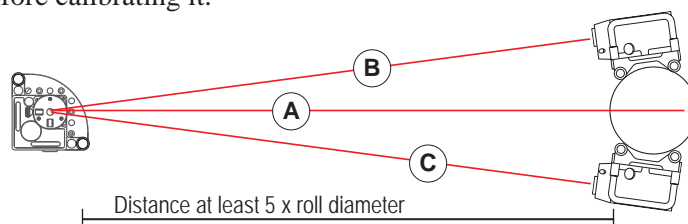
1. Select  and  to open the Control panel.
2. Select .
3. Select  to search for wireless units.





See also "Set up wireless connection" on page 21.

Unit serial	Connect	
75864		
95456		
72409		
59048		

## Calibrate E2 detector

The detector is mounted and calibrated on the factory. If you loosen the detector, you need to calibrate it on site. If you have zero set the E2 detector, you must restart it before calibrating it.



1. Place the laser transmitter parallel to the roll (A) and level it according to the spirit level. The distance between the roll and the laser transmitter should be at least five times the diameter of the roll.
2. Place the bracket with detector on the top of a roll (B). The green diode on the detector lights up when the laser beam hits the detector.
3. Level the laser to H value  $\pm 1\text{mm/m}$  using the tilting screw.
4. Press  and select "Calibration".
5. Select Horizontal and press  to register a value.
6. Place the bracket with detector under the roll (C).
7. Press  to register a value.
8. Press  to accept the offset value.

The detector has been calibrated and the sign **Hc** is shown in the display. The calibration is saved even when the detector is switched off.



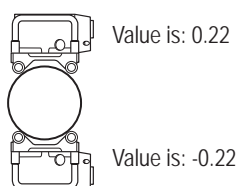
Level the laser transmitter



Press  and select "Calibration".


## Check calibration

You can easily check the calibration. Place the detector on the top of a roll. Note the value. Place the detector under the roll and read the value. If the value is for example 0.22 on the top, a calibrated detector will then display -0.22 ( $\pm 0.05\text{mm}$ ) on the bottom.



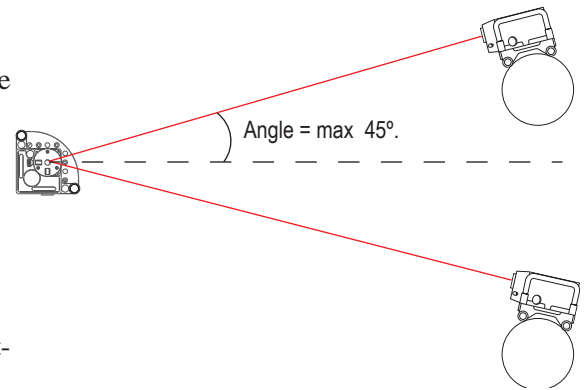
The detector is calibrated when the value is within  $\pm 0.05\text{mm}$ .

## Reset


Press  and select "Reset" to return to factory settings.

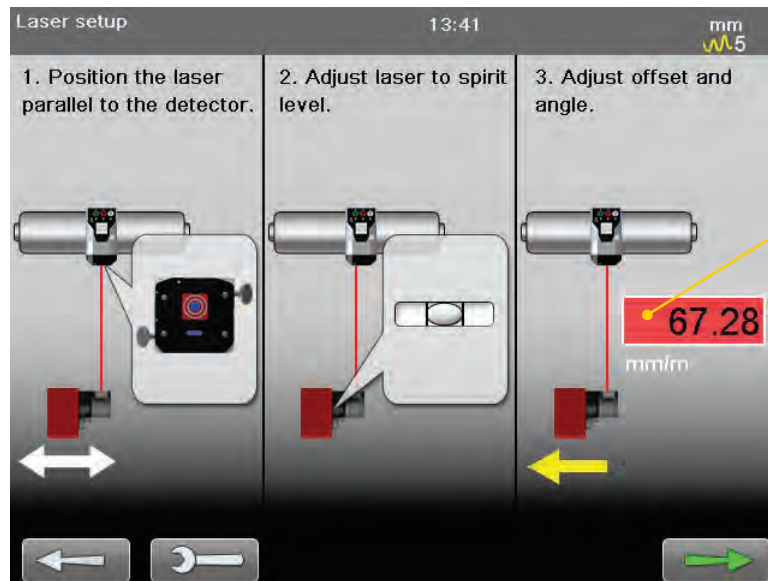
## Laser setup

To establish a good reference line, it is important to set up the laser correctly. The green diode on the detector is lit up when the laser beam hits the detector.




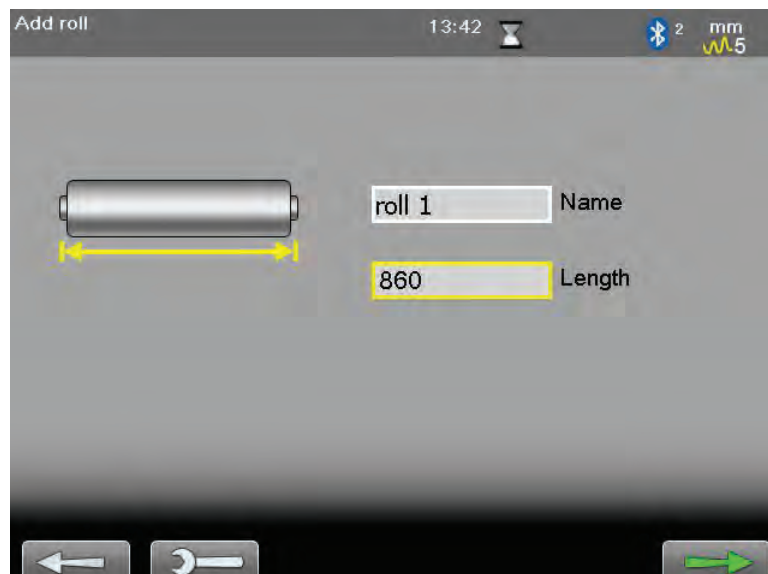
The angle between the rolls should be no more than  $\pm 45$  degrees, see image.

1. Adjust the offset by moving the laser transmitter.
2. Adjust the laser transmitter to spirit level.
3. Adjust the offset and angle. When the value box is green, it is OK to continue.
4. Select  to continue.



## Enter distances



1. Enter a name or keep the default name.
2. Enter the distance between the adjustment points. It is not mandatory.
3. Press  to continue.



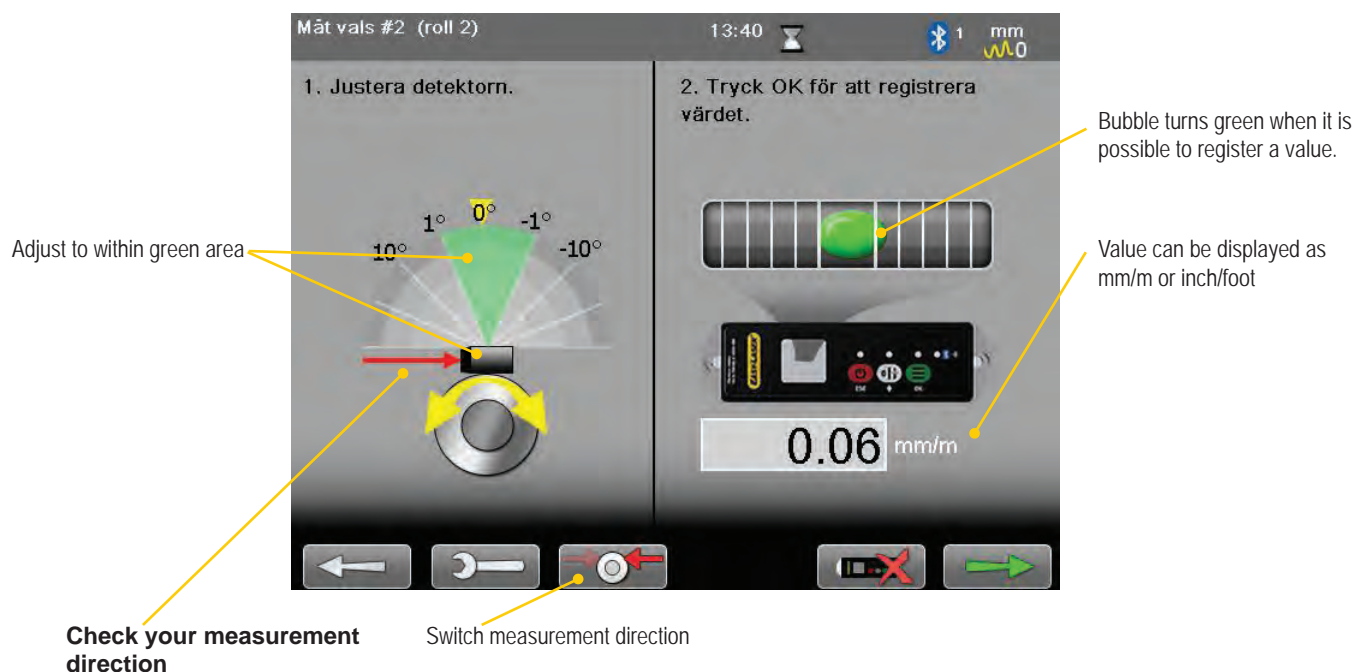
# Measure

## Measure vertical value






The vertical value is measured with the precision level.

1. Check your measurement direction. Use  to **switch direction** if needed.
2. Adjust the fixture until the yellow arrow is within the green area. See image.
3. Wait until the value has stabilized (approx. 15 sec.)
4. Press  to register measurement value.

The value is shown as mm/m or inch/foot. When it is not possible to register a value, the bubble turns red and the value is shown in degrees. To change unit, see “Unit and resolution” on page 16.




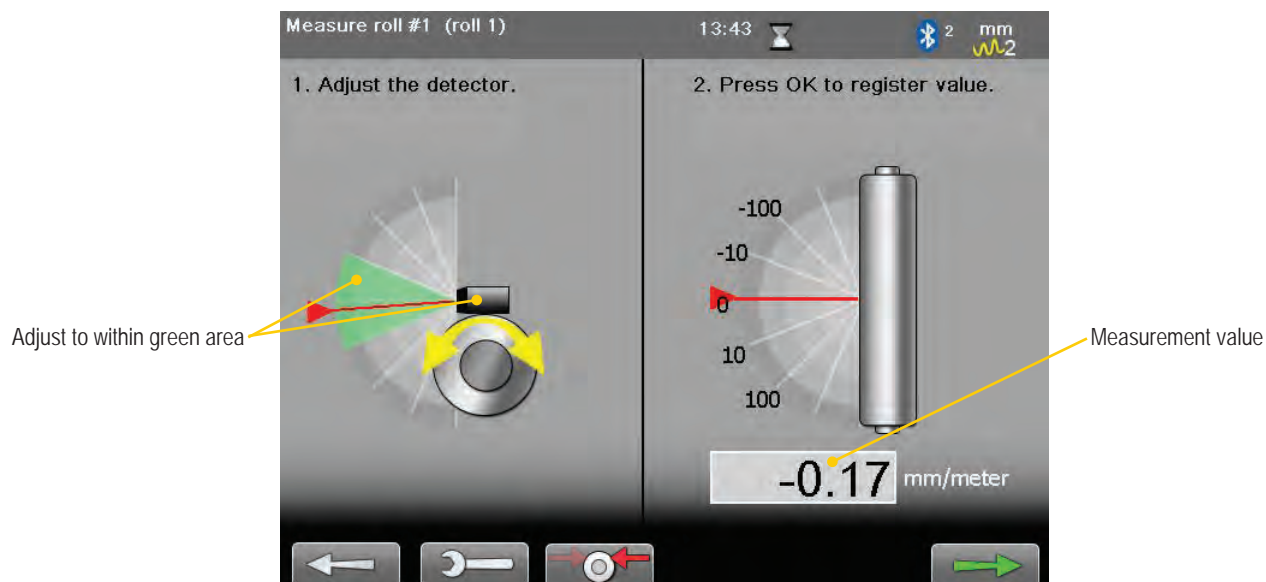
## Function buttons

	Back to Distance view.
	See “Control panel” on page 15.
	See “Switch measurement direction” on page 128.
	Skip measuring with the Precision level for <b>all rolls</b> . It is possible to turn it back on again from the result view. Use with care, the value from the level is used to calculate the horizontal value.
	Select to continue without measuring <b>this roll</b> using the Precision level.

## Measure horizontal value

The horizontal value is measured with the E2 detector.

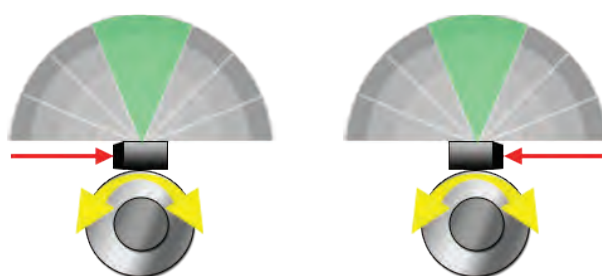
1. Adjust the bracket/roll until the laser beam hits the detector. You need to be within the green area to measure.
2. Press  to register measurement value. The result view is displayed.



## Switch measurement direction

It is possible to switch measurement direction. To ensure an accurate measurement when you switch direction, it is important that the precision level has been indexed. See *“Calibrate the precision level”* on page 124.

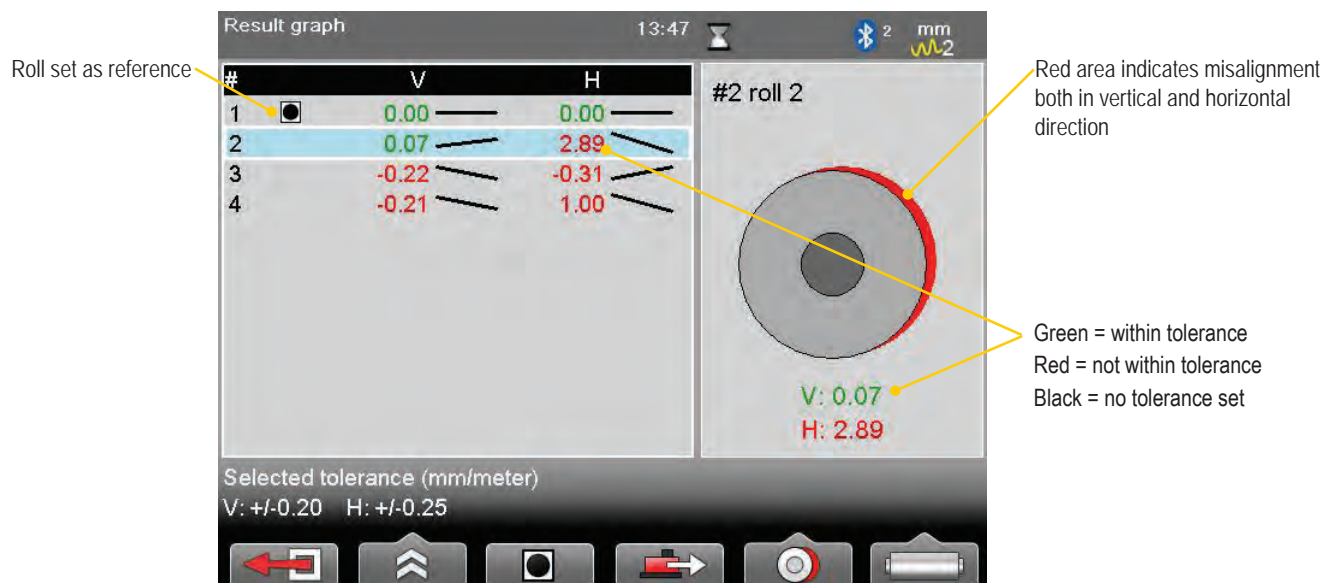
Select  to switch direction.



# Result

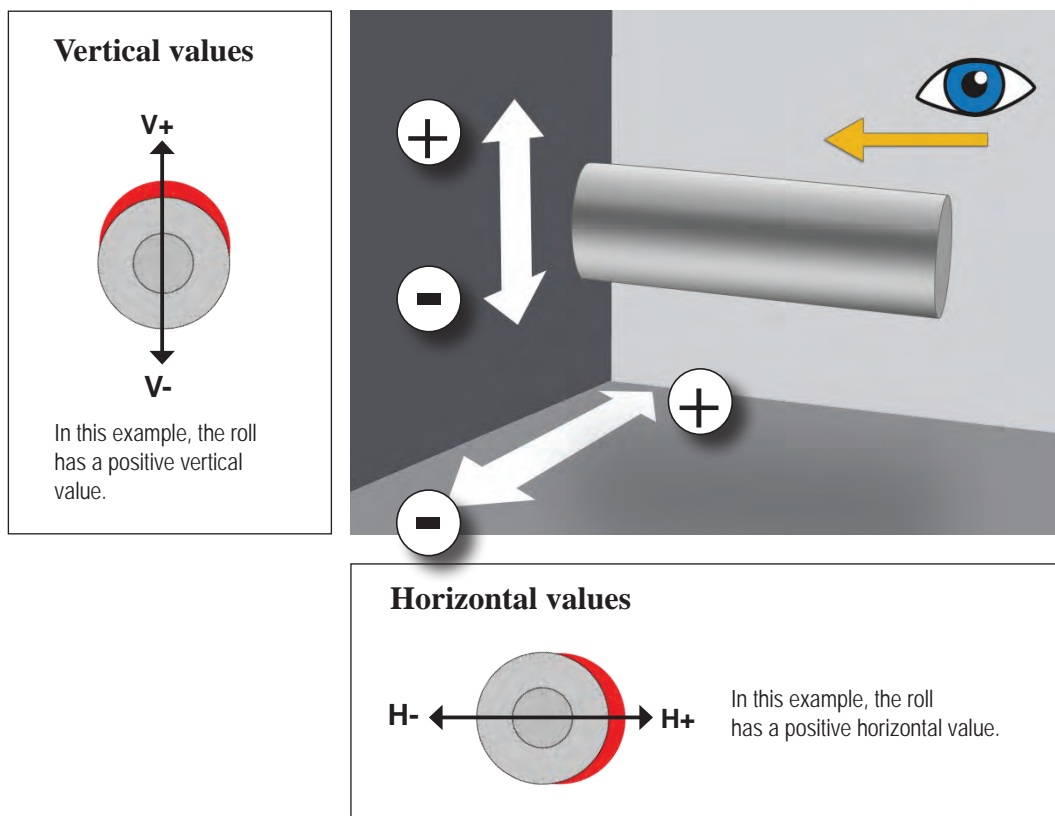
## Table view

By default, the table view is displayed.



## Reading the values

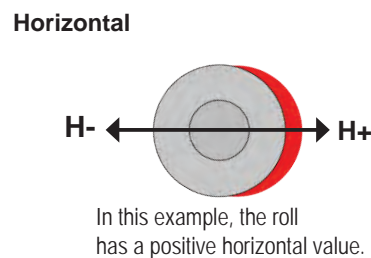
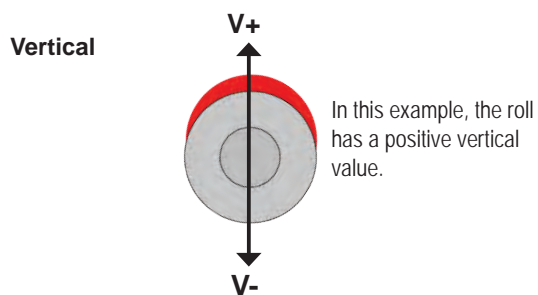
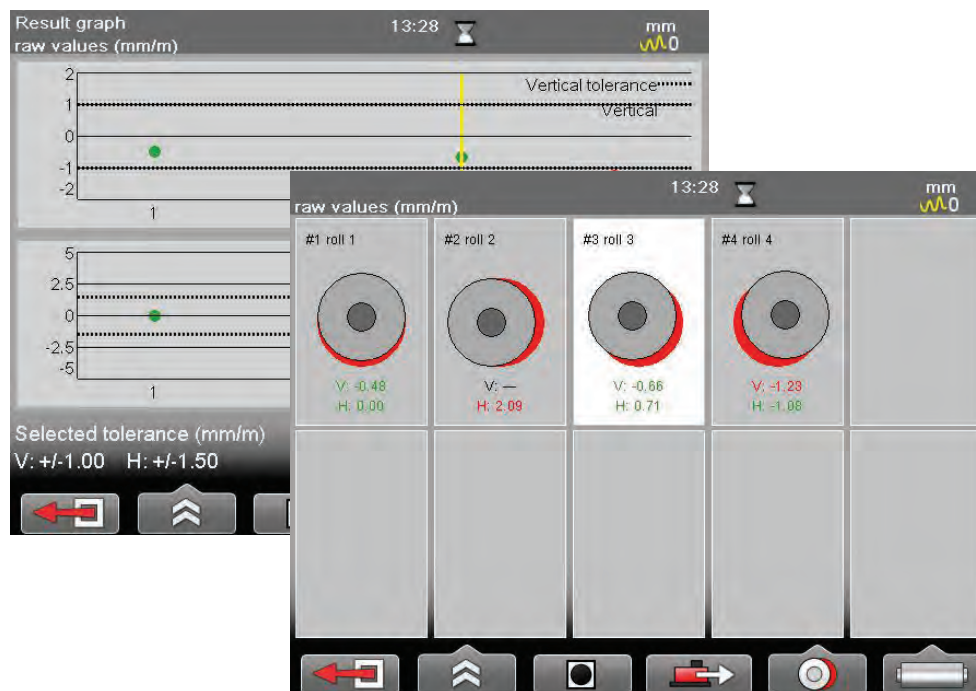
When reading the values, face the roll as shown below. Then the value corresponds to the measurement program.





## Side and Graph view

The Side view and Graph view are great when you want to get an overview of all rolls.



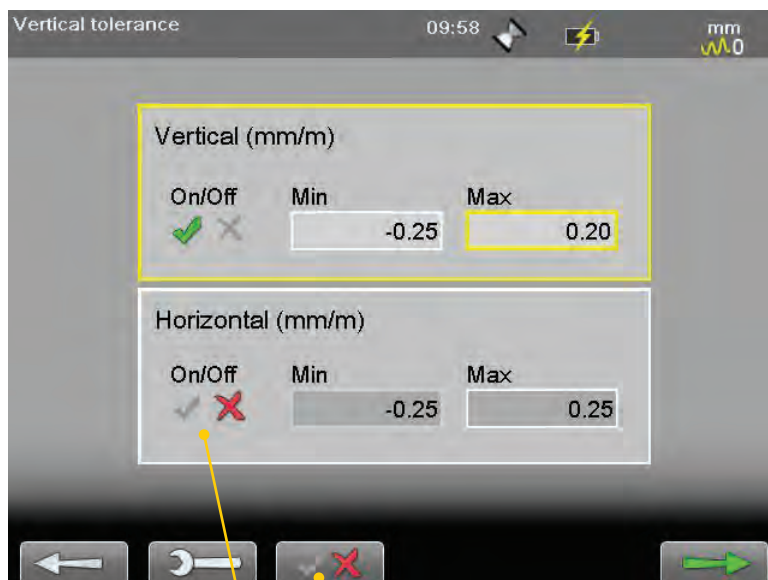
## Function buttons

	<b>Leave program.</b> To remeasure roll, use  and
	See "Control panel" on page 15.
	Save file, see "Measurement file handling" on page 11.
	"Tolerance" on page 131.
	Alter distance and/or name on roll.
	Turn the Precision level on/off.
	Set selected roll as reference. Or press
	See "Move laser" on page 132.
	Show Result table view.
	Show Result side view.
	Show Result graph view.
	Add a new roll and measure it.
	Adjust or remeasure selected roll.

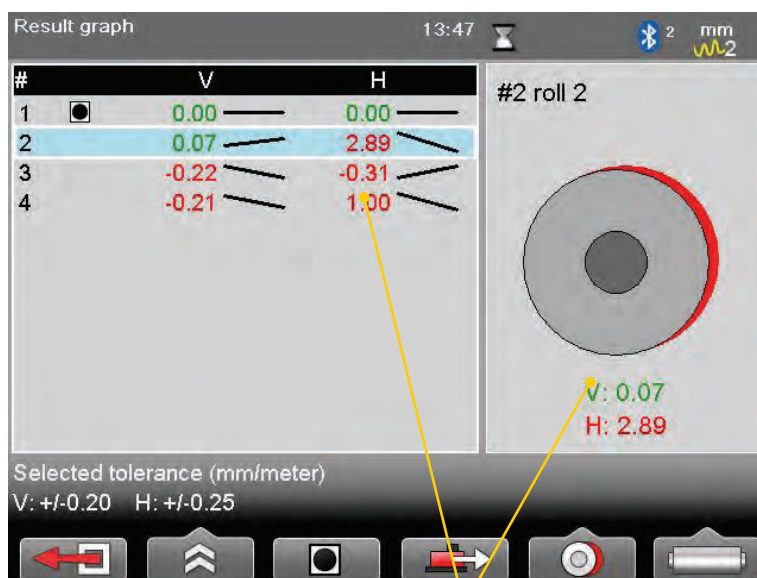
## Tolerance

Select  and  to set tolerance.

- The maximum value has to be greater than the minimum value.
- When you use Metric (mm) two decimals are possible
- When you use Imperial (inch/foot), four decimals are possible



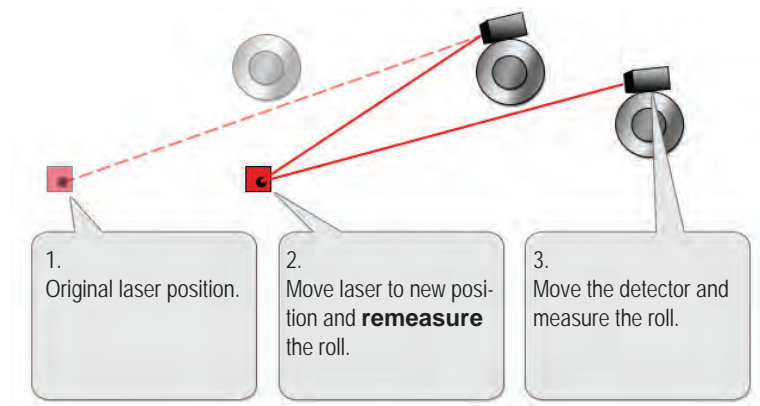
It is possible to set tolerance and then deactivate it.  
A deactivated tolerance is not used in the measurement.








Tolerance in table view

## Move laser

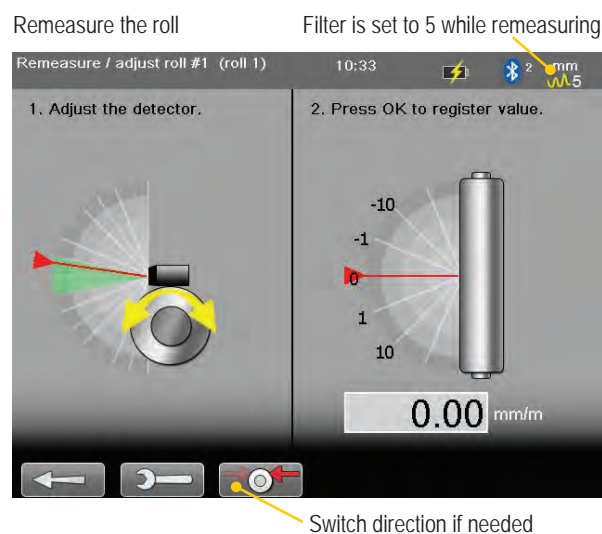
From the Result view, it is possible to select Move laser. You need to remeasure the roll after the move.



1. Select . An information view is displayed. If the roll was measured with a filter lower than 5, a warning is displayed.
2. Select  to continue.
3. Move the laser to the new position. Do not move the detector yet!
4. Remeasure the roll. If needed, select  to switch direction.  
See “Switch measurement direction” on page 128.
5. Select  and  to add a new roll.
6. Move the detector and measure the new roll.

## Filter

- If the roll was measured with a filter lower than 5, a warning is displayed when you select Move laser. You can choose to remeasure with a higher filter, or continue anyway.
- When you remeasure a roll after a move, the detector filter is set to 5 if a lower filter has been set. This is to ensure an accurate result.
- After the move, the filter is restored to the previous setting.





Easy-Laser® BTA system consists of a laser transmitter and a detector. Magnetic mountings on laser and detector make it easy to mount the equipment. Non-magnetic sheave/pulleys can be aligned as the units are very light and can be mounted using double-sided tape.

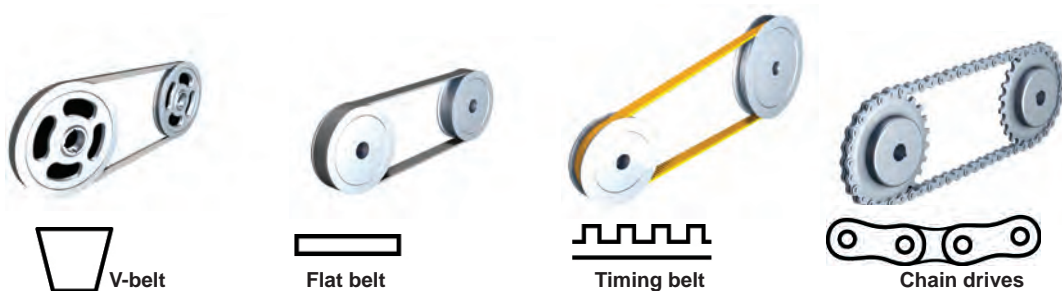
### Note!

BTA is not included in the Shaft or Geo systems but bought as an option. For technical information, see “BTA E180 (Optional)” on page 150.

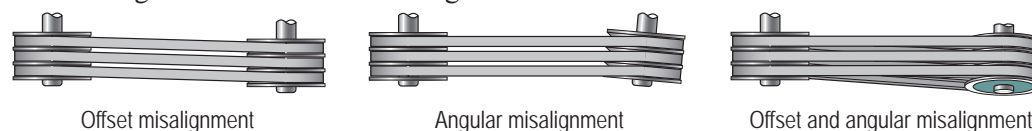


Image showing BTA E180

All types of sheave/pulleys can be aligned, regardless of belt type. You can compensate for sheaves of varying widths.



The misalignment can be offset or angular. It can also be a combination of both.

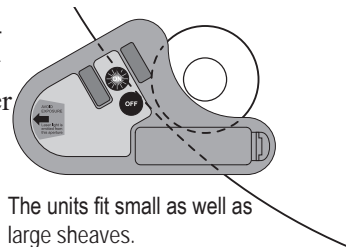


## Preparations

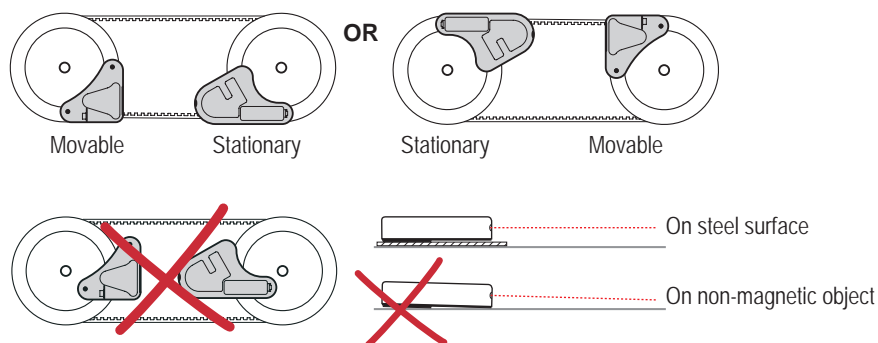
- Check the sheaves for radial runout. Bent shafts will make it impossible to perform an accurate alignment.
- Check the sheaves for axial runout. If possible, adjust with the mounting screws of the bushings.
- Make sure that the sheaves are clean from grease and oil.

## Mount the units

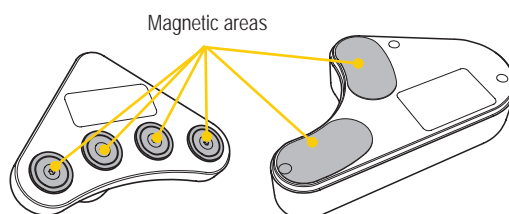
The units are mounted on a flat machined surface with magnets. The magnets are very strong, try to soften the touch by putting just one magnet to sheave first, then turning the other ones in. Non-magnetic sheave/pulleys can be aligned as the units are very light and can be mounted using double-sided tape.



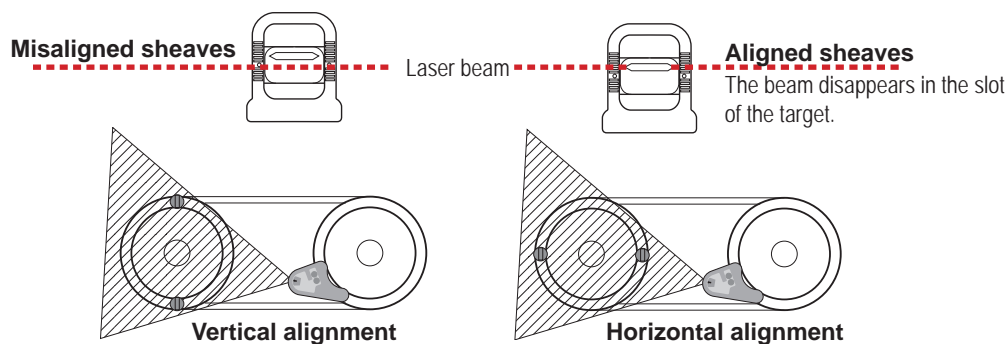
1. Mount the laser transmitter on the stationary machine.
2. Mount the detector on the movable machine.
3. Make sure all magnetic surfaces are in contact with the sheave.



**All** of the magnetic surfaces must be in contact with the object.



## Align with targets





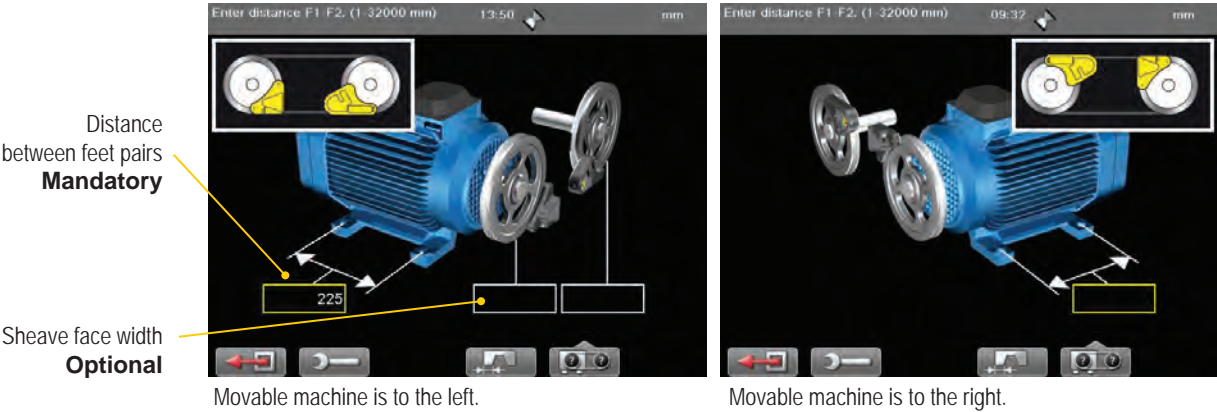


# Measure using Display unit








The E180 BTA can be used as a separate tool, see “Measure without Display unit” on page 138.

## Enter distances

- 1. Connect to the Display unit.
- 2. Press the ON button on the laser transmitter.
- 3. Select  to open the BTA program.
- 4. Select  if you want to enter sheave face width. Press **OK**.
- 5. Enter distance between feet pairs. Press **OK**.




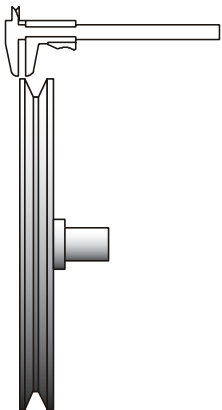
## Function buttons

	<b>Leave program.</b>
	See “Control panel” on page 15.
	<b>Sheave face width.</b> Select to activate fields if the sheaves have different face widths.
	Contains a sub menu. The Display unit automatically recognize where the units are placed. However, you can do this manually as well.  Set M-unit to the left.  Set M-unit to the right.  Return to Automatic configuration.

## Sheave face width

The distance from the belt to the axial face of the sheave can be different on the two sheaves. To calculate a possible offset the system requires both sheave face widths.

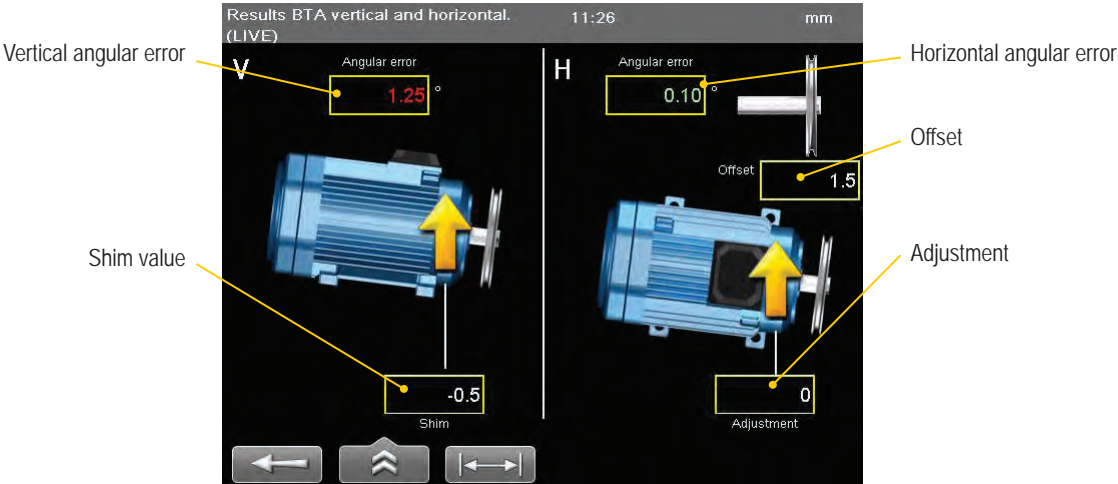
- 1. Measure the distance from the belt to the axial face of the sheave.
- 2. Select  to activate fields and enter distances.





## Measure

Make sure that the laser line hits the detector aperture. The Display unit shows the offset and angular misalignment.



### Function buttons

	<b>Back.</b> Return to enter distances.
	See “Control panel” on page 15. Save, see “Measurement file handling” on page 11. <b>Set tolerance.</b> See also <i>Tolerance</i> on next page. <b>Print on thermal printer</b> (Optional equipment). Available when you have saved the measurement.
	<b>Edit distance.</b>

### Values – colours

White	No tolerance set.
Green	Value within tolerance.
Red	Value outside tolerance.
++++	Loss of signal, laser beam interrupted for example.

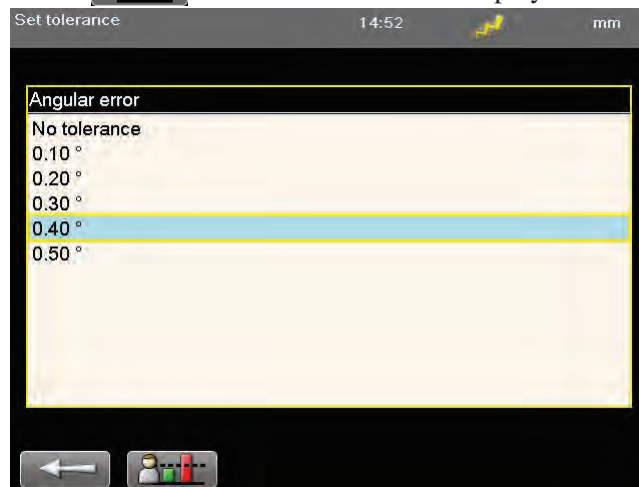
### Note!

The laser transmitter flashes when the battery is low. Change the batteries before you continue to measure.

## Tolerance

Recommended maximum tolerances from manufacturers of belt transmissions depends on type of belt, usually between 0.25–0.5°.

1. Select . The tolerance view is displayed.



<°	mm/m mils/inch	
0.1	1.75	
0.2	3.49	
0.3	5.24	
0.4	6.98	Recommended
0.5	8.73	
0.6	10.47	
0.7	12.22	
0.8	13.96	
0.9	15.71	
1.0	17.45	

2. Select  to set user defined tolerance.

## Adjust

Start by adjusting the sheave, and then the machine.

- Correct offset by moving the movable machine with axial jackscrews, or by repositioning one of the sheaves on its shaft.
- Correct vertical angular error by shimming the movable machine.
- Correct horizontal angular error by adjusting the movable machine with lateral jackscrews.

When you adjust the machine one way, it often affects the machine's other alignment conditions. Which means this process may have to be repeated several times.


### **Note!**

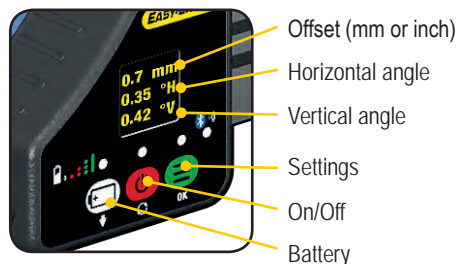
*If not using the system for a long period of time, remove the batteries.*

# Measure without Display unit

The E180 BTA can be used as a separate tool.

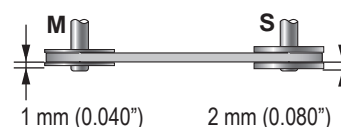
## Measure

1. Press  to start the detector and ON to start the laser transmitter.
2. Read the values. Offset, horizontal angle and vertical angle are displayed.
3. Adjust machine, see previous page.





## Different sheave width

If the sheaves have different face widths, just add or subtract the difference from the zero value to get the value for perfect alignment.





## Settings


Press  to open the settings view. Use  to move up and down in the menu.


- Press  to switch position on the M and S-unit.
- Toggle between mm and inch with .

## Battery

Press  to see the battery status of the detector. While the battery is charging, there is a green flashing light. The laser transmitter flashes when the battery is low. Change the batteries before you continue to measure.

 Red, flashing once: Battery empty.

 Red, flashing twice: Battery needs charging.

 Green, flashing three times: Good.

 Green, fixed light: Battery full.

### **Note!**

*If not using the system for a long period of time, remove the battery from the laser transmitter.*

# VIBROMETER

---



Easy-Laser® Vibrometer is used in preventive as well as active maintenance work on rotating machinery. It measures the vibration level and bearing condition of machinery.

When measuring vibration level, Easy-Laser® Vibrometer is measuring the effective velocity (mm/s or inch/s RMS) in the frequency range between 2 and 3200 Hz. This range covers most of the frequencies that will occur for the majority of mechanical malfunctions and imperfections, for example unbalance and misalignment.

When used to measure bearing condition the Easy-Laser Vibrometer is measuring the effective acceleration (RMS) in the frequency range between 3200 and 20000 Hz. Trend analysis of the bearing condition value can be used to determine wear and tear of machine bearings.



See “Vibrometer (Optional)” on page 151.

## Mount directly on machine

It is possible to remove the magnetic tip and mount the probe directly to the machine, using the M6 threaded stud.

## Measuring tip

For measuring points that are hard to reach, use the measuring tip. Simply unscrew the magnetic tip and replace with the measuring tip. When measuring with the measuring tip, place it firmly against the measurement point and hold it as vertical, horizontal or axial as possible. When the measuring tip is used the frequency range is reduced to about 800 to 1500Hz.


---

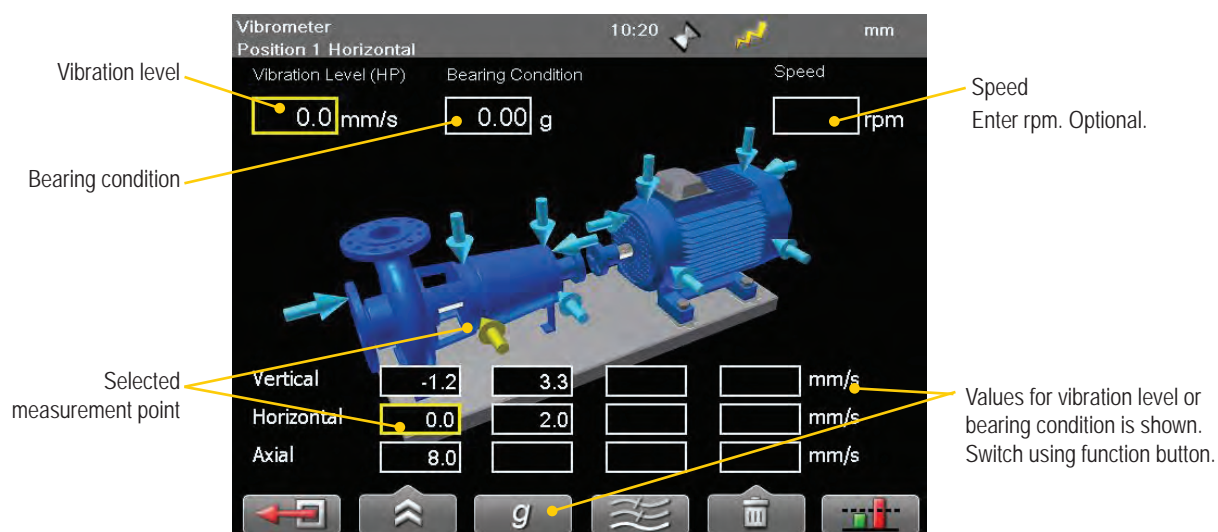
### **Note!**

*Vibrometer is not included in all Shaft systems.*


















---

## Measure

1. Use the standard red cable to connect the Vibrometer directly to the Display unit.  
Wireless units cannot be used.
2. Select  to open the Vibrometer program.
  - Enter rpm. Optional.
  - Use the navigation buttons if you want to register another point than is selected by default.
3. Place the vibrometer against the measurement point. Pressing more firmly should not change the reading. If this happens, adjust the measuring point.
4. Wait ten seconds for the value to stabilize.
5. Press **OK** to register value.




## Function buttons

	<b>Leave program.</b>				
	 See "Control panel" on page 15.  Save, see "Measurement file handling" on page 11.  Print report on thermal printer (optional equipment).  Generate report. Available when you open a saved measurement.				
 	Toggle button. Show values for bearing condition or vibration level.				
	Toggle button. Show high frequency (10–3200 Hz) or low frequency (2–3200 Hz).				
	Contains a submenu <table border="1"> <tr> <td></td><td>Clear selected measurement point.</td></tr> <tr> <td></td><td>Clear all measurement points.</td></tr> </table>		Clear selected measurement point.		Clear all measurement points.
	Clear selected measurement point.				
	Clear all measurement points.				
	<b>Tolerance.</b> Show tolerance table for vibration level and bearing condition value.				

## Vibration level

In the Display unit, a table from ISO 10816-3 standard is shown. This standard is used for machines with power above 15kW and nominal speeds between 120–15000 rpm.

1. Use navigation buttons to select a measurement point.
2. Select  to open the tolerance table. It displays the values for the selected point.



### Rigid or flexible

The ISO standard is classifying the machines differently if the machines have flexible or rigid foundations. Usually this is determined from drawings and calculations of the machine.

### Groups

- Group 1. Large machines with rated power above 300kW. Electrical machines with shaft height  $H > 315$ mm. Operating speed ranges from 120 to 15000 rpm
- Group 2. Medium-sized machines with a rated power above 15kW up to and including 300kW. Electrical machines with shaft height between  $160 < H < 315$  mm. Operating speed normally above 600 rpm.
- Group 3. Pumps with multivane impeller and with separate driver with rated power above 15kW.
- Group 4. Pumps with multivane impeller and with integrated driver with rated power above 15kW.

### Guideline

Another standard you can use is ISO 2372 class 4, for large machines on flexible foundations.

0 – 3 mm/s 0 – 0.12inch/s	Small vibrations. None or very small bearing wear. Low noise level.
3 – 7 mm/s 0.12 – 0.27 inch/s	Noticeable vibration levels often concentrated to some specific part as well as direction of the machine. Noticeable bearing wear. Seal problems occur in pumps etc. Increased noise level. <b>Plan action during next regular stop.</b> Keep the machine under observation and measure at smaller time intervals than before to detect a deterioration trend if any. Compare vibrations to other operating variables.
7 – 18 mm/s 0.27 – 0.71 inch/s	Large vibrations. Bearings running hot. Bearing wear-out cause frequent replacements. Seals wear out, leakage of all kinds evident. Cracks in weldings and concrete foundations. Screws and bolts are loosening. High noise level. <b>Plan action soonest.</b>
> 18 mm/s > 0.71 inch/s	Very large vibrations and high noise levels. This is detrimental to the safe operation of the machine. <b>Stop operation</b> if technically or economically possible considering the plant stop cost.




## Bearing condition value

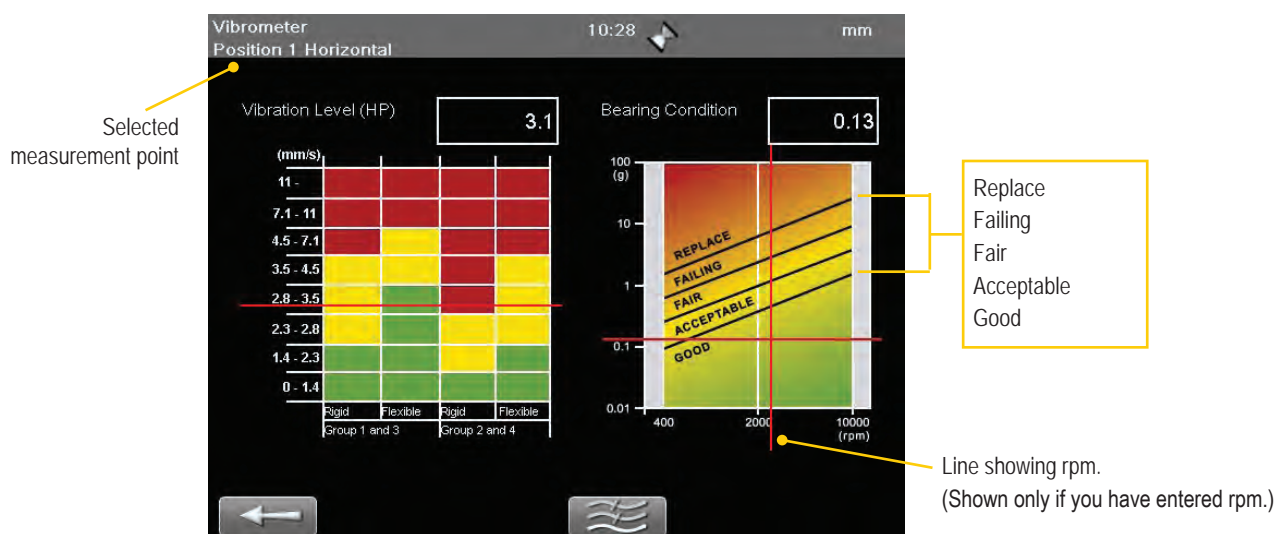
Bearing condition value is used for trend analysis. If the bearing condition value increases over time, it can be a sign that the bearing is poorly lubricated, overloaded due to misalignment or has a damaged surface. A high bearing condition value can however appear in gearboxes, converting machines with cutters and similar machines without any bearing fault. This is because this type of machinery naturally produces high frequency vibrations that are similar to the vibrations produced by a machine with a bearing fault.

The bearing condition value is the quadratic mean, RMS value, of all high frequency vibrations between 3200 Hz to 20000 Hz. This value is an acceleration average measured in multiples of the standard gravity constant, g.

The diagram below is only a guide to interpret the bearing condition value. A high bearing condition value should always be used as a request to make detailed frequency analysis. Do not change bearings before this is done.

### Open tolerance table for bearing condition

1. Select a measurement point.
2. Select  to open the tolerance table.

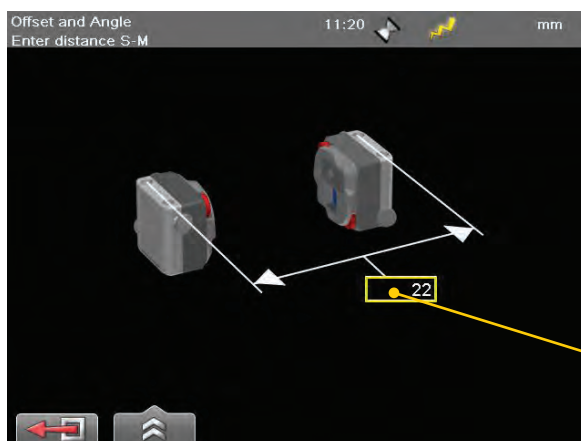


# OFFSET AND ANGLE

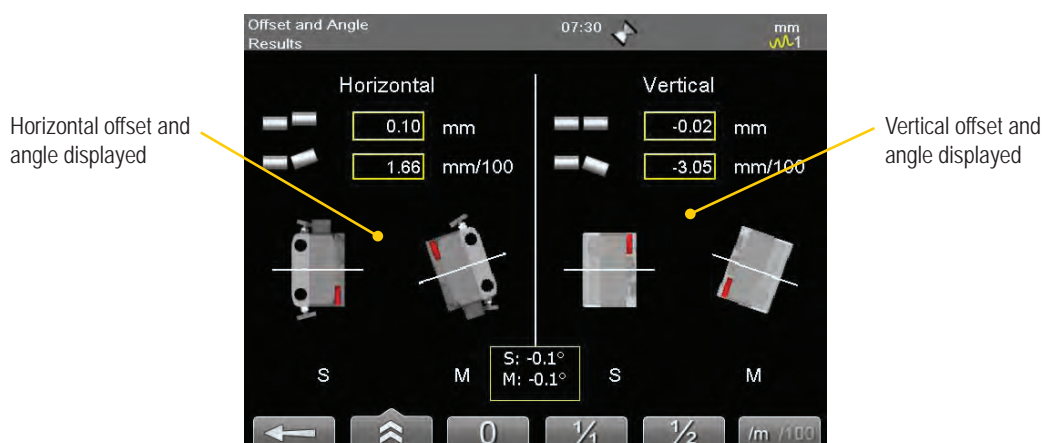


The Offset and Angle program displays measurement values from measuring units S and M. The measurement values can be zeroed and any offset and angular changes between the units that may occur are displayed.

1. Enter distance between measuring units.
2. Press **OK**.



Enter distance



## Function buttons

	<b>Leave program.</b>
	See "Control panel" on page 15.
	Show target. This is a quick way to see where the laser beam hits the target and how the measuring units are positioned.
	See "Streaming values".
	<b>Zero set.</b> Set current value to zero.
	<b>Absolute.</b> Return to absolute value.
	<b>Halve.</b> Halve the displayed value.
	Toggle between showing the value as <b>mm/100</b> or <b>mm/m</b> .



# BATTERY PACKS

When not using cable to the measuring units, you can use our chargeable battery pack. The battery pack comes in two versions, with or without built-in wireless connection.

## Battery pack

(Part No. 12-0617)

1. Place the battery pack on the rods.
2. Plug in the red cable to the measuring unit.

The measuring unit will charge and you can continue measuring.

This Battery pack does **not** have a built-in wireless functionality, you can however connect a wireless unit to the Detector/Measuring unit. To save energy, the wireless units will only connect when you are using a measurement program. There is no power switch on the wireless unit. To switch off, simply unplug it. The unit have a serial number that is shown in the wireless functionality view in the Display unit.

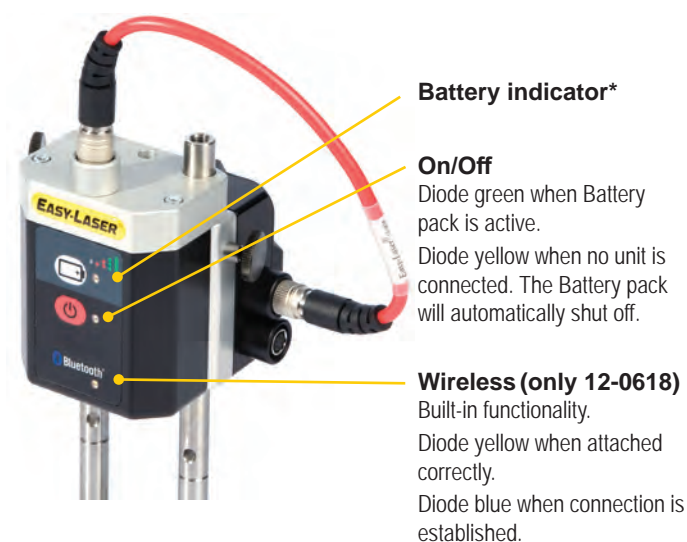
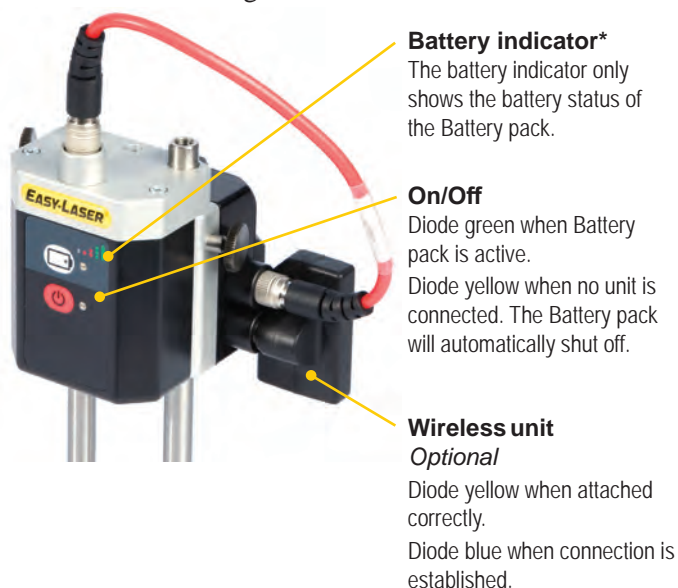
## Battery pack with wireless

(Part No. 12-0618)

This Battery pack has built-in wireless functionality. For more information on how to set up and search for units, see *“Set up wireless connection” on page 21.*

The Battery pack’s serial number is placed on the backside. This serial number is shown in the Display unit.

When the Battery pack run empty, the lights for Battery indicator and On/Off are switched off. However, the built-in wireless will still function as long as the Detector has some power left.



### \* Battery indicator

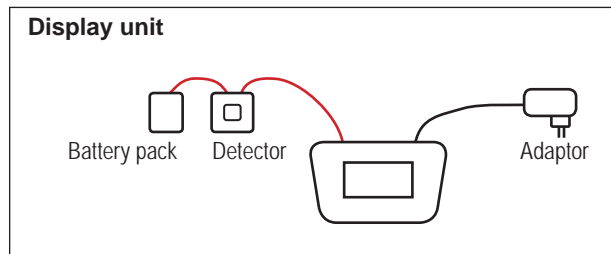
- Constant green light  
Battery pack full.
- Flashing green light  
Battery pack OK
- Flashing red light  
Battery pack low. Approx. 15 min. left to empty.
- Battery pack empty and will shut down.

## Charge battery pack

### Using Display unit

It is possible to charge battery packs **without** wireless functionality via the Display unit, one at a time. You can charge both a Detector and a battery pack by connecting the equipment as described in the image. If the Display unit is turned off while charging, the equipment will charge faster.

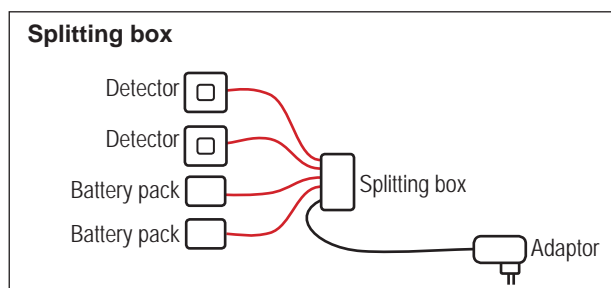
1. Connect the Display unit with the adaptor. The Display unit itself does not have enough power to charge the battery pack.
2. Use standard red cable to connect battery pack to the Display unit.



### Using splitting box

When you have two battery packs or battery packs with wireless BT, you can use our splitting box (Part No. 12-0597).

1. Plug in the power adaptor to the splitting box. Use the standard power adaptor delivered with your system. All lights are lit up on the splitting box.
2. Plug in the battery pack and Detectors to the splitting box. Corresponding light is switched **off**.
3. When the battery pack is fully charged, the light is switched **on** again.

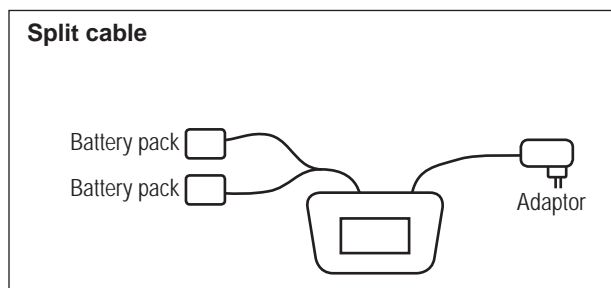


### Using split cable

For two Battery packs or Battery packs with wireless BT, you can also use our split cable (Part No. 12-0725).

The split cable can only be used to charge the Battery packs, not as a “red cable”.

1. Plug in the power adaptor and split cable to the Display unit.
2. Plug in the battery packs.
3. When the battery packs are fully charged, the light is constant green on the Battery pack.



# TECHNICAL DATA

System Easy-Laser® E710 Shaft, Part No. 12-0440

## A complete system contains

1	Measuring unit M
1	Measuring unit S
1	Display unit
2	Bluetooth® units
2	Cables 2 m
2	Shaft brackets with chains
2	Extension chains
2	Magnet bases
2	Offset brackets
1	Set of rods 4x60 mm, 4x120 mm [4.72", 2.36"]
1	Manual
1	Measuring tape 3 m
1	USB memory stick
1	USB cable
1	Power adaptor (100–240 V AC)
1	Toolbox
1	Cleaning cloth for optics
1	Carrying case



## System

Relative humidity	10–95%
Weight (complete system)	10 kg [22 lbs]
Carrying case	WxHxD: 500x400x200 mm [19.7x15.7x7.8"] Drop tested. Water and dust tight.



## Display unit E51

Part. no 12-0418

In the Display unit you are guided through the measurement procedure and can save and analyze the results.

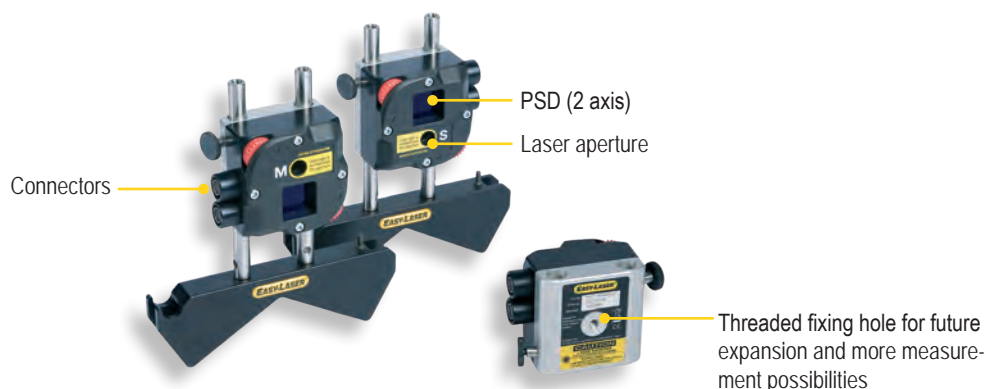


Display unit	
Type of display/size	VGA 5.7" colour
Displayed resolution	0.001 mm / 0.05 thou
Power management	Endurio™ system for unbroken power supply
Internal battery (stationary)	Li-Ion, Not restricted PI967, 3.7 volt, 43Wh, 11600 mAh
Battery compartment	For 4 pcs R 14 (C)
Operating time	Appro. 30 hours (Normal operating cycle)
Connections	USB A, USB B, Easy-Laser® units, charger
Storage memory	>100,000 measurements
Help functions	Calculator, Converter
Environmental protection	IP Class 65
Housing material	PC/ABS + TPE
Dimensions	WxHxD: 250x175x63 mm [9.8x6.9x2.5"]
Weight (without batteries)	1030 g [2.3 lbs]
Cables	
Type	With Push/Pull connectors
System cable	Length 2 m [78.7"]
Extension system cable	Length 5 m [196.8"]
USB cable	Length 1.8 m [70.8"]
EasyLink™ data base software for PC	
Minimum requirements	Windows® XP and newer. For the export functions, Excel 2003 or newer must be installed on the PC.

## Measuring units

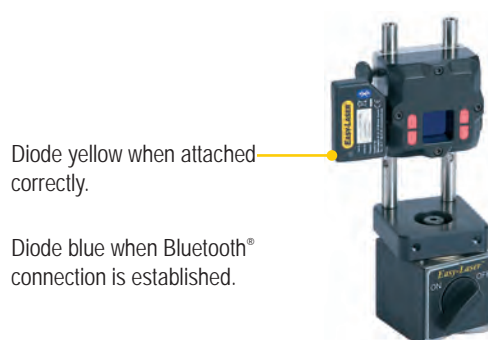
Part no. 12-0433

Part no. 12-0434



Measuring units	
Type of display/size	2-axis PSD 20x20 mm [0.78" sq]
Detector resolution	0.001 mm / 0.05 thou
Type of laser	Diode laser
Laser wavelength	635–670 nm
Laser safety class	Class 2
Laser output power	<1 mW
Inclinometers	0.1° resolution
Thermal sensors	± 1° C accuracy
Environmental protection	IP Class 66 and 67
Dimensions	BxHxD: 60x60x42 mm [2.36x2.36x1.65"]
Weight	202 g [0.45 lbs]
Internal battery	Li-Ion, 3.7 volt, 2.5Wh, 680mAh
Wireless connection unit (Not included for all systems)	
Wireless communication	Class I Wireless Technology
Operating temperature	-10–50 °C
Housing material	ABS
Environmental protection	IP Class 66 and 67
Dimensions	53x32x24 mm [2.1x1.2x0.9"]
Weight	25 g [0.06 lbs]

### Bluetooth®



#### **Note!**

The Bluetooth® unit is powered by the Detector. To save energy, **the Bluetooth® connection is only established when you are using a measurement program.**

## BTA E180 (Optional)

Part no. 12-0796

Clean the units and the windows at the apertures with a dry cotton cloth. If not using the system for a long period of time, remove the battery from the laser transmitter.



Laser transmitter E180	
Sheave diameter	> 60 mm [2.5"]
Laser class	2
Output power	<1 mW
Laser wavelength	635–670 nm
Beam angle	60°
Accuracy	Parallelity: < 0.05°, Offset < 0.2 mm [0.008"]
Battery type	1xR6 (AA) 1.5 V
Battery operation	8 hours cont.
Operating temperature	-10°C to +50°C
Material	ABS plastics / Hard anodized aluminium
Dimensions BxHxD	145x86x30 mm [5.7x3.4x1.2"]
Weight	270 g [9.52 oz]
Detector unit E180	
Sheave diameter	> 60 mm [2.5"]
Displayed resolution	(Changeable between mm/inch) Axial offset: 0.1 mm [0.005"] Angular value: 0.1°
Measurement distance	Up to 3 m [9.8'] between transmitter and detector
Measurement range	Axial offset: ±3 mm [0.12"] Angular value: ±8°
Display resolution	Offset: 0.1° Angle: 0.01°
Display type	Yellow OLED 96x96 pixels
Connection	Wireless technology
Battery type	Li-Ion
Battery operation	5 hours continuously
Housing material	ABS plastics / Anodized aluminium
Dimensions BxHxD	95x95x36 mm [3.7x3.7x1.4"]
Weight	190 g [6.7 oz]

Vibrometer (Optional)

Part no. 12-0654



Instrument/Software	
Measurement range	0–50 mm/s [0–2 inch/s] RMS
Resolution	0.1 mm/s [0.005 inch/s]
Frequency range	Total level: 2–3200 Hz (Lp), 10–3200 Hz (Hp) Bearing condition: 3200–20000 Hz
Probe	
Sensitivity	100 mV/g ±10%
Dimensions	Magnet: L=20 mm [4/5"], ø =15 mm [19/32"] Gauge tip: L=65 mm [2 1/2"9]

## Precision level E290

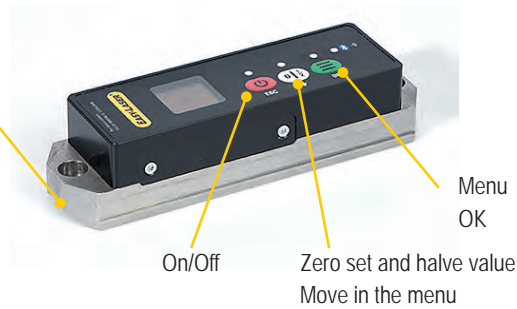
Part no. 12-0846

### Note!

Machined surface. Keep clean and dry. Grease surface when not in use.

### Note!

To reach full accuracy, make sure that the temperature of E290 has stabilized in the measurement environment.



### Change unit

Press and select "Unit". Choose from the following units: mm/m, inch/foot, degrees or arc sec. Use to move in the menu.

### Calibration

The Precision level is calibrated on the factory. To calibrated on site:

1. Place the Precision level on a roll (or the object you are going to measure). Make a mark to ensure that you place the Precision level in the same position.
2. Press and select "Calibration".
3. Wait until the value has stabilized. Press .
4. Rotate the Precision level 180°. Wait until the value has stabilized.
5. Press . The Precision level has been calibrated. The calibration is saved even when the Precision level is switched off.

### Factory recall

Press and select "Fac. recall" to return to factory settings.

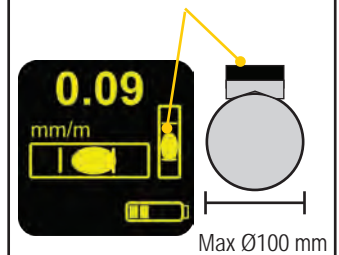
### Visible

By default the precision level is set to visible. This means it will be shown when searching for wireless units. To save energy, the precision level is set to not visible once a wireless connection is established.

### Connect to Display unit

Connect the Precision level to the Display unit.

Use the small indicator **only as a guide** to ensure that the Precision level is placed correctly on top of the measurement object.



When measuring a shaft using the Precision level, we recommend that the shaft is no larger than 100 mm in diameter.

### Safety strap

Use the safety strap to prevent equipment from falling and causing injuries.



Precision level E290	
Displayed resolution	0.01 mm/m (0.001°)
Range	± 2 mm/m
Measurement error	Range ±1mm/m: accuracy within ±0.02mm/m of displayed value. Range ±2mm/m: accuracy within ±0.04mm/m of displayed value.
Type of display	OLED
Wireless communication	Class I wireless technology
Environmental protection	IP Class 67
Operating temperature	-10–50 °C
Internal battery	Li-Ion, 3.7 V, 2.5 Wh, 680 mAh
Material	Hardened, polished and corrosion resistance steel, ABS plastics
Dimensions	WxHxD: 149x40x35 mm [5.9x1.6x1.4"]
Weight	530 g [18.7oz]