



Larson Systems Inc.

13847 Aberdeen Street NE
Ham Lake, MN 55304-6789
www.larsonsystems.com

Phone:

763-780-2131

Fax:

763-780-2182

Email:

info@larsonsystems.com

How to Use SDHT Pass Through Testing

When using Pass Through Testing, a target value (either in Force or Length), must be preset. If using a Two Point mode then two target values must be preset.

There are two limitations when using Pass Through Testing:

- First, Pass Through Testing data storage is finite. When performing a test, the amount of storage used will be displayed. When storage reaches 100%, the test will finish even if the target has not been passed.
- Second, to get the best readings the rate of force change must be below a certain level. This changes with the rate of the part being tested. If the tester detects the rate of change of the force is too high a message will be displayed suggesting to slow down.

Setup

Each testing mode, **Manual** or any of the **Two Point with Rate** modes, has its own target values. The mode to be used must be selected using the **MODE** button *before* accessing the **Pass Through Testing** setup menu.

- 1) Press the **OPTION** button until the screen shows "Pass Through".
- 2) Press **F1** to enter the "Setup" menu.
- 3) Using the **F1** button select the target measurement: **Force** or **Length**.
- 4) Press **OPTION** to go to the next menu.
- 5) Using the **F1** and **F2** buttons, enter the target value.
- 6) Press **OPTION** to go to the next menu.
- 7) If the current mode is a **Two Point** mode then a second target can be entered.
- 8) When all target points are set press the **OPTION** button to scroll back to the 1st target point.
- 9) Press the **ON/CLEAR** button to exit back to the primary display. If you want to immediately start the **Pass Through Testing** mode, press the **SEND** button to move up a menu level and press **F2** to **Start** using **Pass Through Testing**.



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Using Pass Through Testing

- 1) Use the **MODE** button to select the testing mode to be used.
- 2) If **Pass Through Testing** setup has not been performed already, preset the **Pass Through Testing** targets as described above.
- 3) Start the **Pass Through Test**.
 - a. If the **Pass Through** menu is not being displayed, press the **OPTION** button until the screen shows "**Pass Through**".
 - b. Press the **F2** button to **Start Pass Through Testing**.
 - c. The menu display will close and the display will return back to the primary display.
- 4) The message "**Hit F1 to Start**" will flash on the screen.
- 5) Prepare the part for testing by placing it on the tester, then press the **ZERO FORCE** button to remove the weight of the spring from the reading.
- 6) Press the **F1** button to start the test.
- 7) The **Pass Through Testing** data storage usage buffer will show as a percentage in the upper left corner of the display. Before the display reaches 100% move the upper platform to pass through the target position(s).
- 8) When the target has been passed or when the display hits 100% the result will be shown.
- 9) At this point result can be written down, stored, or sent out the printer port.
- 10) If the rate of change of the force was too fast, a message will be shown suggesting to slow down the testing.
 - a. The rate of change is only checked near the target. It is possible to rapidly move the platform to a point near the target. This is useful when passing through the second point of a two point test.
- 11) Press the **ON/CLEAR** button to clear the measurement to prepare for the next test.
- 12) When finished using **Pass Through Testing**, the feature must be turned off.
 - a. Press the **OPTION** button until "**Pass Through**" shows, then press **F2** to **Stop the Pass Through Testing** mode. Press the **ON/CLEAR** button to return to the primary display.