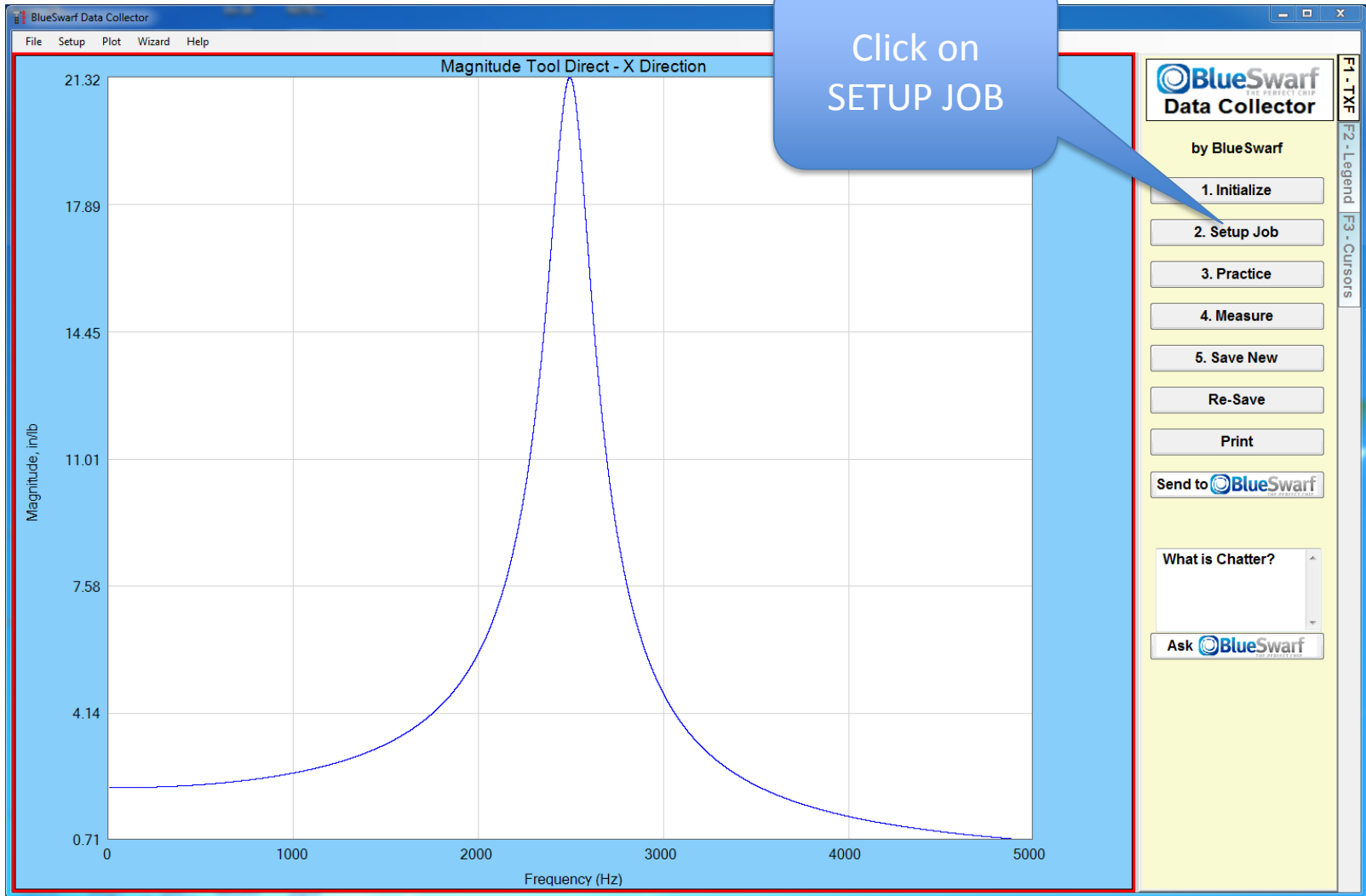


# Sensor Settings

This information is intended only for the person or entity to which it is addressed and may contain confidential, proprietary, and/or privileged material. Any review, retransmission, dissemination or other use of, or taking of any action in reliance upon, this information by persons or entities other than the intended recipient is strictly prohibited.

- **Check that the correct sensors are selected when you first use the kit.**
- **You will not have to refer to them again unless you add a mass to the hammer or purchase optional hammers or accelerometers.**



Click on  
SETUP JOB

The screenshot displays the BlueSwarf Data Collector interface. The main window shows a graph titled "Magnitude Tool Direct - X Direction" with "Magnitude, in/lb" on the y-axis (ranging from 0.71 to 21.32) and "Frequency (Hz)" on the x-axis (ranging from 0 to 5000). A blue curve shows a peak at approximately 2500 Hz. A dialog box titled "Data Collector Setup for Milling" is open, with the "Sensors" tab selected. A blue callout bubble points to the "Sensors" tab with the text "Click on SENSORS tab".

**Data Collector Setup for Milling**

Job	Current Conditions	Measurement	Sensors
FileName: October.21.2016.103PM.591661			
Data Collector's E-Mail: jcdobrin@gmail.com		Date: 2/22/16 1:57:46 PM	
Customer: Pan Metal		Stackup No.: (I don't know)	
Remarks:			
<b>Machine</b>			
Manufacturer: Grob G-550		Customer No.: Machine 211	
Machine Search   New Machine Details			
<b>Holder and Tool</b>			
Manufacturer: Seco		Customer No.: (I don't know)	
Holder Search   New Holder Details			
Manufacturer: LMT Onsrud		Customer No.: (I don't know)	
Tool and Holder Offset   Tool Search   New Tool Details			
(Stickout Length.): 3.196 inches		Pocket No.: (I don't know)	
<b>Material : Tool Geometry</b>			
Material: Aluminum Alloys			
Material No.: 7050		Speed: 1476.4 sfm	
Chipload: 0.0059 inches			

**BlueSwarf**  
Data Collector

by BlueSwarf

1. Initialize
2. Setup Job
3. Practice
4. Measure
5. Save New

Re-Save

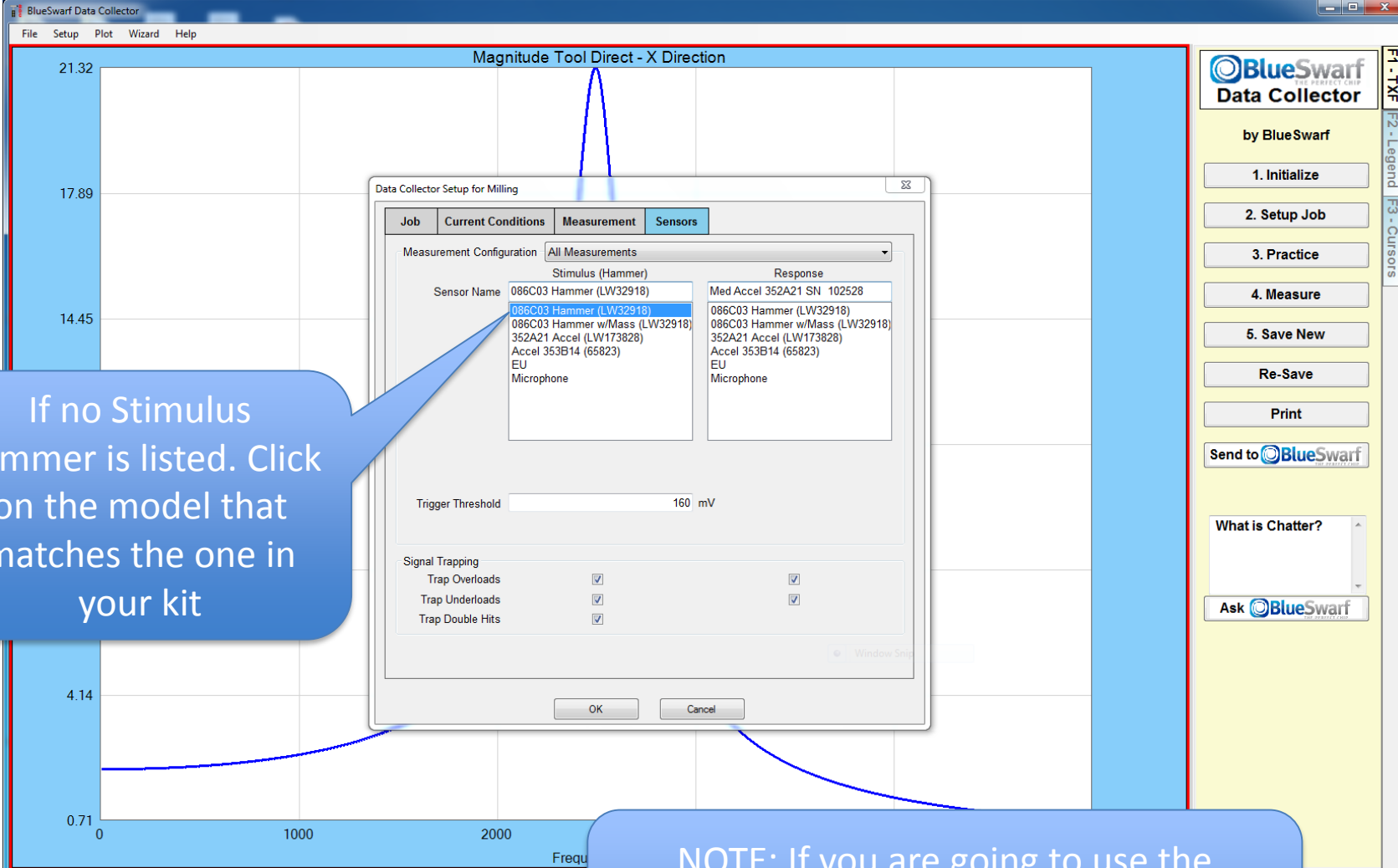
Print

Send to **BlueSwarf**

What is Chatter?

Ask **BlueSwarf**

F1 - TXF  
F2 - Legend  
F3 - Cursors



The screenshot shows the BlueSwarf Data Collector interface. The main window displays a graph titled "Magnitude Tool Direct - X Direction" with a blue curve. The y-axis ranges from 0.71 to 21.32, and the x-axis is labeled "Frequency". A dialog box titled "Data Collector Setup for Milling" is open, showing the "Sensors" tab. The "Measurement Configuration" section has a dropdown set to "All Measurements". Below it, there are two columns: "Stimulus (Hammer)" and "Response". The "Sensor Name" list includes "086C03 Hammer (LW32918)", "086C03 Hammer (LW32918)", "086C03 Hammer w/Mass (LW32918)", "352A21 Accel (LW173828)", "Accel 353B14 (65823)", "EU", and "Microphone". The "Response" column lists "Med Accel 352A21 SN 102528", "086C03 Hammer (LW32918)", "086C03 Hammer w/Mass (LW32918)", "352A21 Accel (LW173828)", "Accel 353B14 (65823)", "EU", and "Microphone". A "Trigger Threshold" is set to 160 mV. The "Signal Trapping" section has checkboxes for "Trap Overloads", "Trap Underloads", and "Trap Double Hits", all of which are checked. The dialog box has "OK" and "Cancel" buttons at the bottom.

**Magnitude Tool Direct - X Direction**

**Data Collector Setup for Milling**

Job: Current Conditions: Measurement: Sensors

Measurement Configuration: All Measurements

Sensor Name	Stimulus (Hammer)	Response
086C03 Hammer (LW32918)	086C03 Hammer (LW32918)	Med Accel 352A21 SN 102528
086C03 Hammer (LW32918)	086C03 Hammer (LW32918)	086C03 Hammer (LW32918)
086C03 Hammer w/Mass (LW32918)	086C03 Hammer w/Mass (LW32918)	086C03 Hammer w/Mass (LW32918)
352A21 Accel (LW173828)	352A21 Accel (LW173828)	352A21 Accel (LW173828)
Accel 353B14 (65823)	Accel 353B14 (65823)	Accel 353B14 (65823)
EU	EU	EU
Microphone	Microphone	Microphone

Trigger Threshold: 160 mV

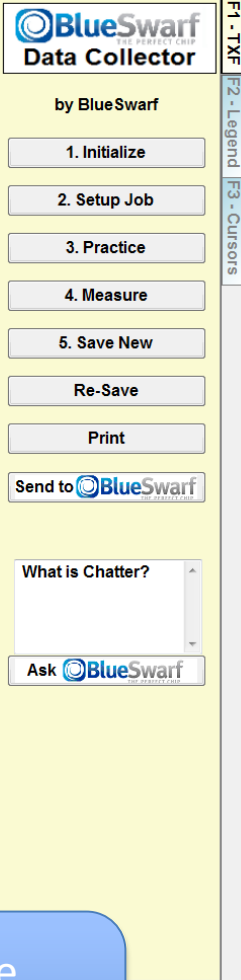
Signal Trapping

Trap Overloads	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Trap Underloads	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
Trap Double Hits	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

OK Cancel

If no Stimulus hammer is listed. Click on the model that matches the one in your kit

NOTE: If you are going to use the hammer with the screw on mass you will change the configuration here.



**BlueSwarf Data Collector**

by BlueSwarf

1. Initialize
2. Setup Job
3. Practice
4. Measure
5. Save New

Re-Save

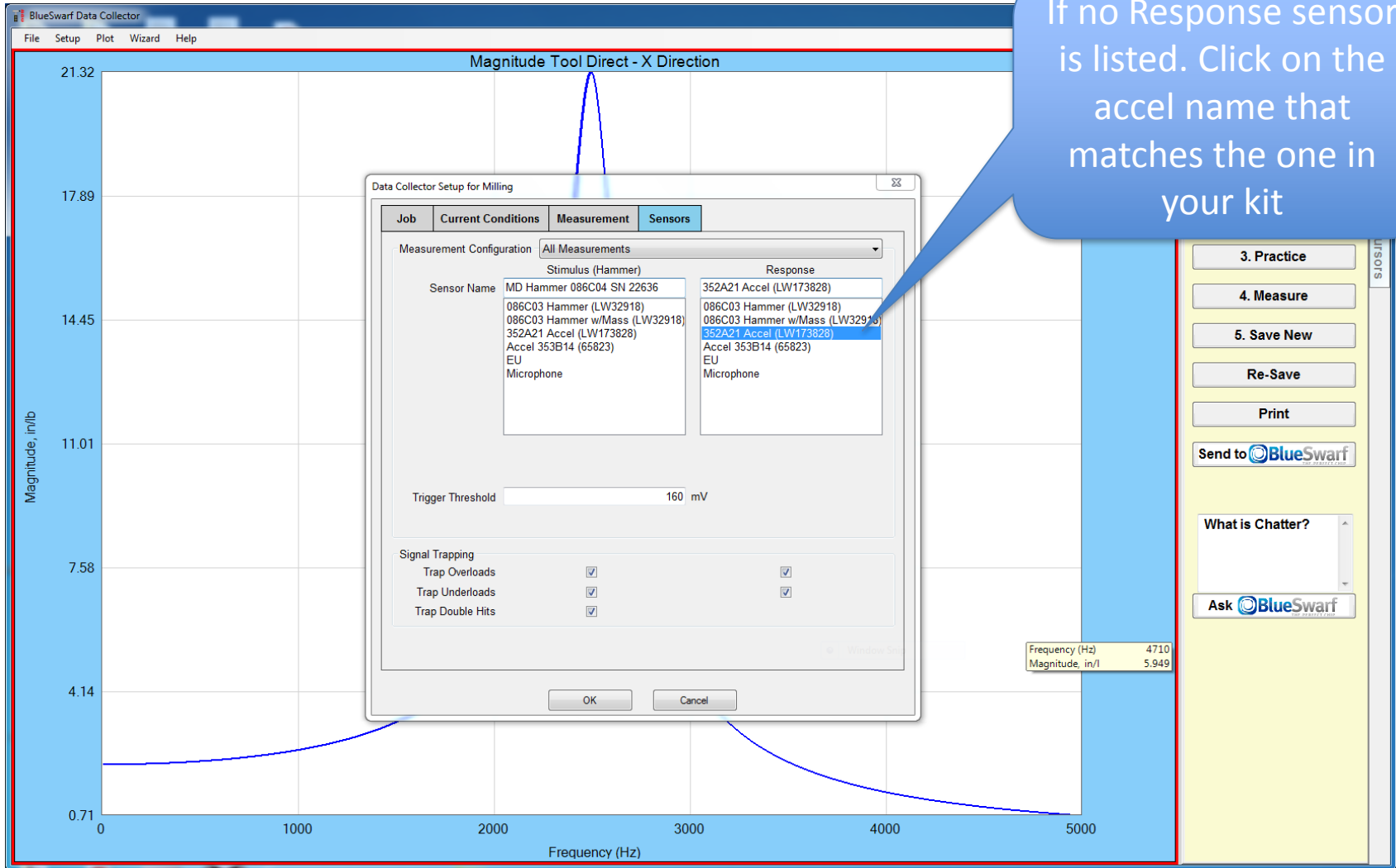
Print

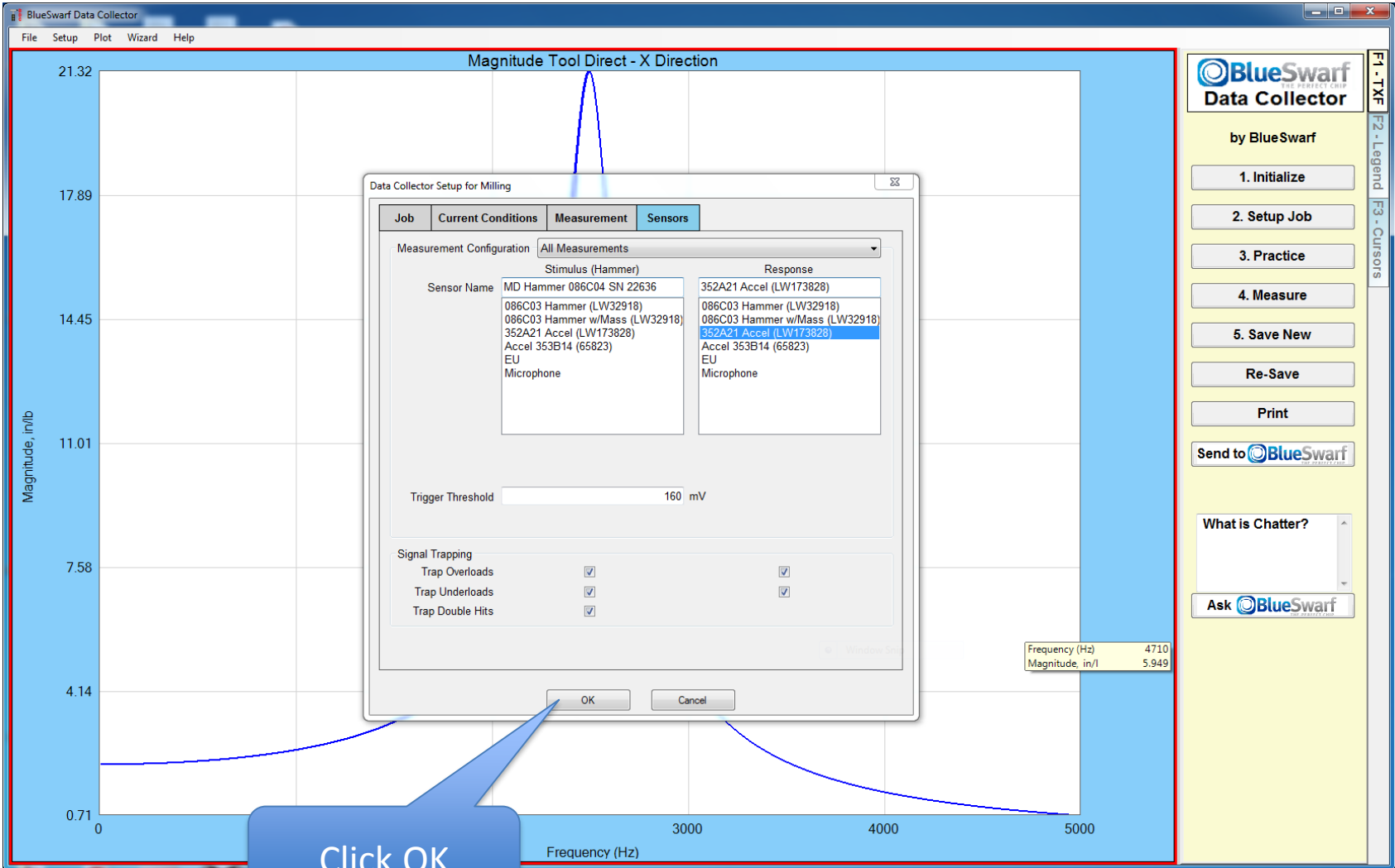
Send to BlueSwarf

What is Chatter?

Ask BlueSwarf

F1 - TXF  
F2 - Legend  
F3 - Cursors





The screenshot displays the BlueSwarf Data Collector interface. The main window shows a graph titled "Magnitude Tool Direct - X Direction" with Magnitude (in/lb) on the y-axis (0.71 to 21.32) and Frequency (Hz) on the x-axis (0 to 5000). A blue curve shows a peak at approximately 4710 Hz. A dialog box titled "Data Collector Setup for Milling" is open, showing the "Sensors" tab. The "Measurement Configuration" section is set to "All Measurements" with a "Stimulus (Hammer)" and "Response" list. The "Response" list includes "352A21 Accel (LW173828)", which is highlighted. The "Trigger Threshold" is set to 160 mV. The "Signal Trapping" section has checkboxes for "Trap Overloads", "Trap Underloads", and "Trap Double Hits", all of which are checked. A blue callout box with the text "Click OK" points to the "OK" button in the dialog box. A small data box in the bottom right corner of the graph area shows "Frequency (Hz) 4710" and "Magnitude, in/l 5.949".

**Click OK**

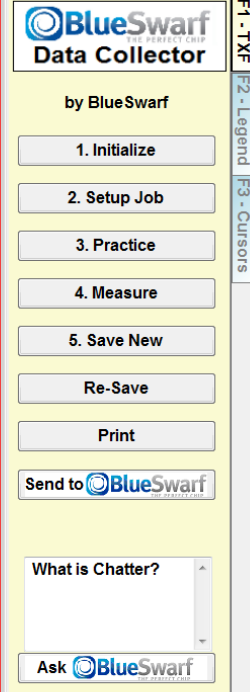
Job	Current Conditions	Measurement	Sensors
Measurement Configuration: All Measurements			
Stimulus (Hammer)		Response	
Sensor Name	MD Hammer 086C04 SN 22636	352A21 Accel (LW173828)	
	086C03 Hammer (LW32918)	086C03 Hammer (LW32918)	
	086C03 Hammer w/Mass (LW32918)	086C03 Hammer w/Mass (LW32918)	
	352A21 Accel (LW173828)	352A21 Accel (LW173828)	
	Accel 353B14 (65823)	Accel 353B14 (65823)	
	EU	EU	
	Microphone	Microphone	

Trigger Threshold: 160 mV

Signal Trapping:

- Trap Overloads:
- Trap Underloads:
- Trap Double Hits:

Frequency (Hz) 4710  
Magnitude, in/l 5.949




**BlueSwarf**  
Data Collector

by BlueSwarf


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4. Measure
5. Save New

Re-Save

Print

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What is Chatter?

Ask  BlueSwarf

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