

## AA-01: Set and Check Size

### SAFETY FIRST

- Follow all Caterpillar facility safety standards when performing this task.

### EQUIPMENT

- required holding device

### RESOURCES

- manufacturer's manual
- print, if available



## Set and Check Size

### 1. Verify the machine setup.

- Check to make sure the part is secured to the holding device and will not move during measurement.

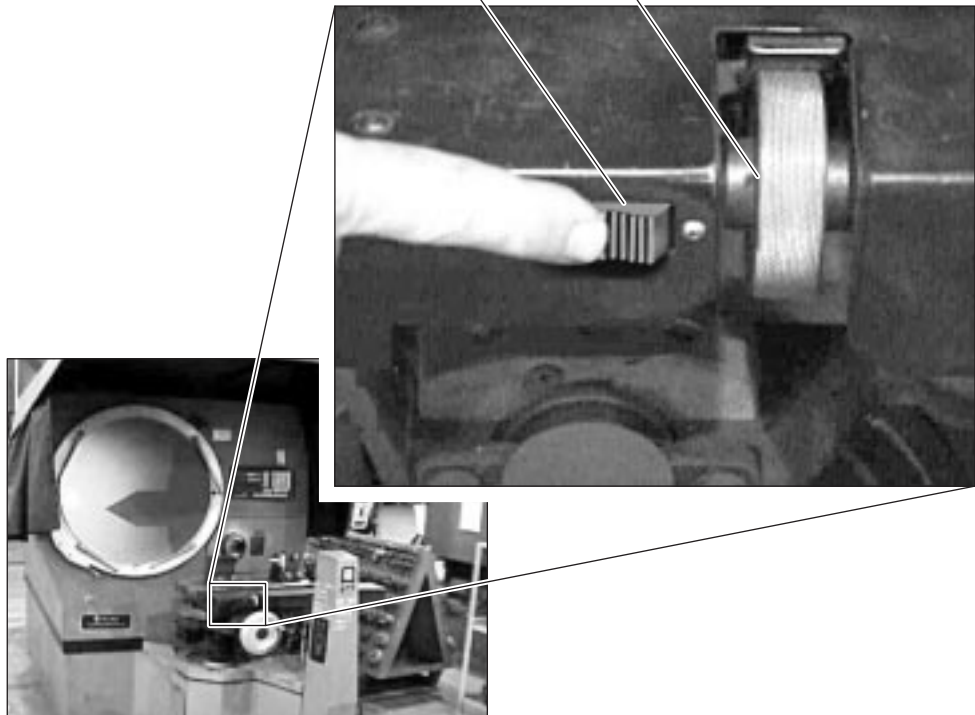
### 2. Move the part in front of the lamp.

- Press the X-axis rapid feed button until the image of the section you are measuring appears.
- Set the part to the reference lines on the view screen.



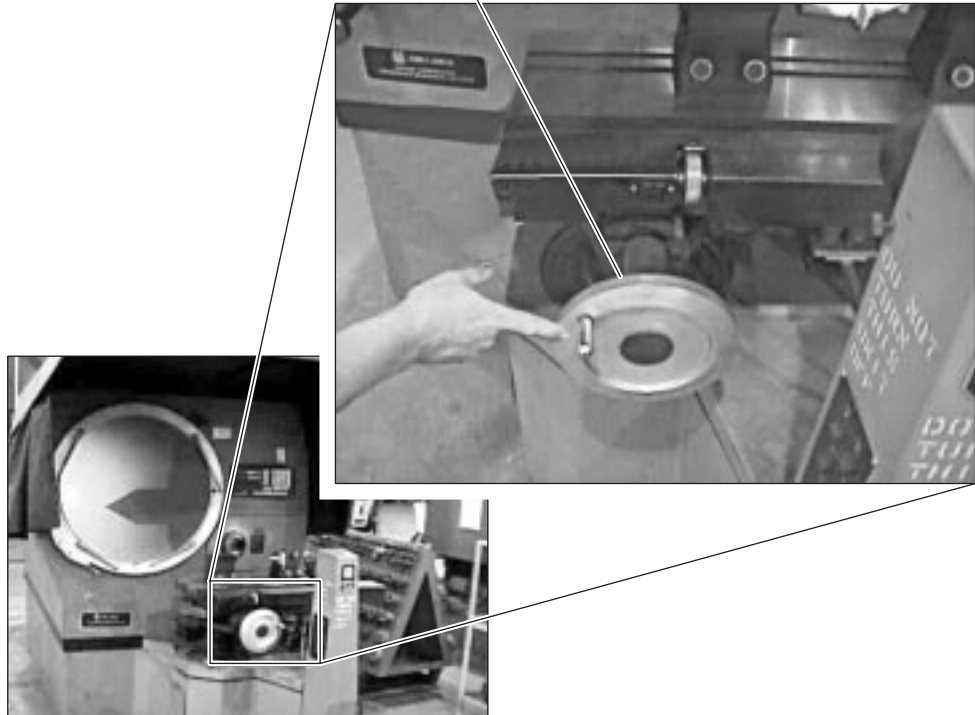
Rapid Feed Button

Fine Feed Wheel



### 3. Focus the shadow with the focus wheel.

Focus Wheel

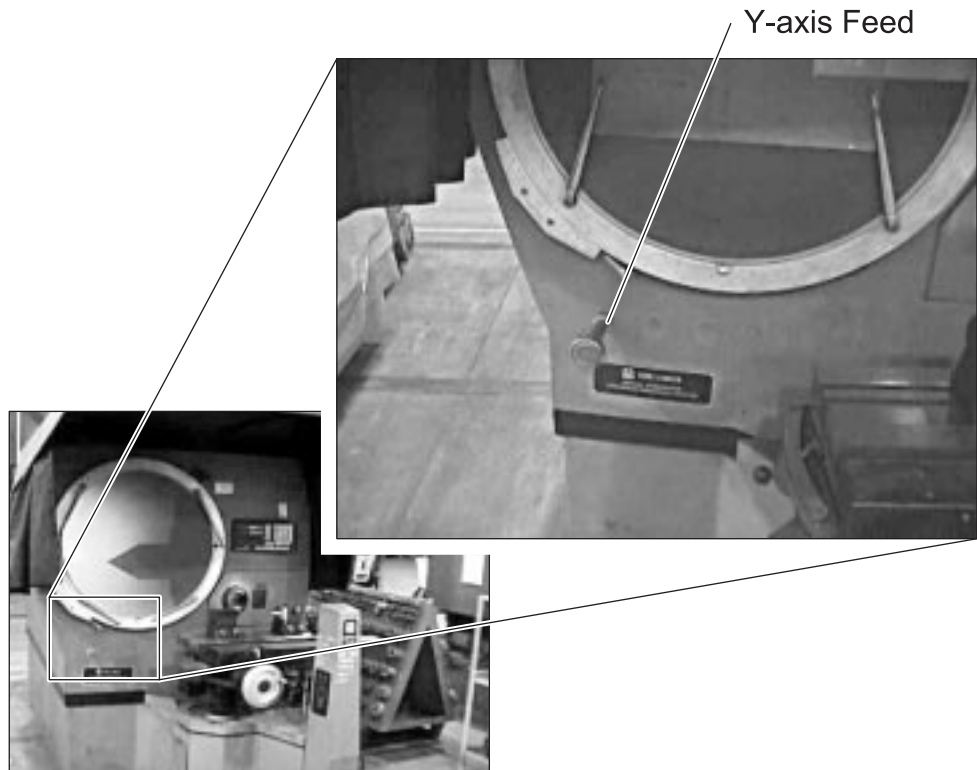


- Turn the wheel until the shadow edges become sharp and readable.

### 4. Set the X and Y axes zeros.

- Move the part with the rapid feed button until the desired end of the measurement comes close to the X axis on the shadow graph screen.
- Adjust the X axis with the fine feed wheel until the piece lines up on the shadow graph screen as closely as possible with the X axis.

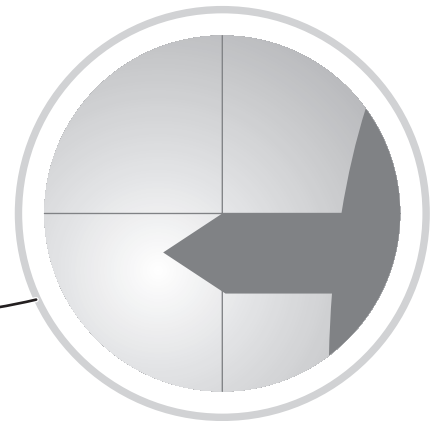
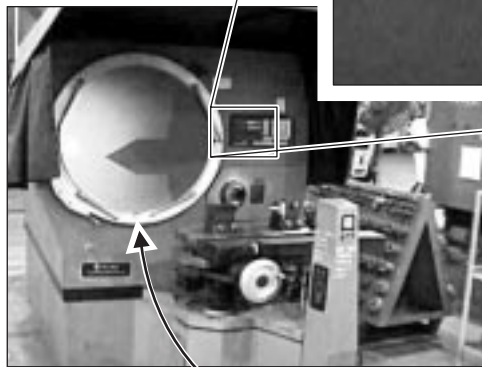
- Move the image on the Y axis with the Y axis adjustment until the end of the measurement is zeroed (X0,Y0).

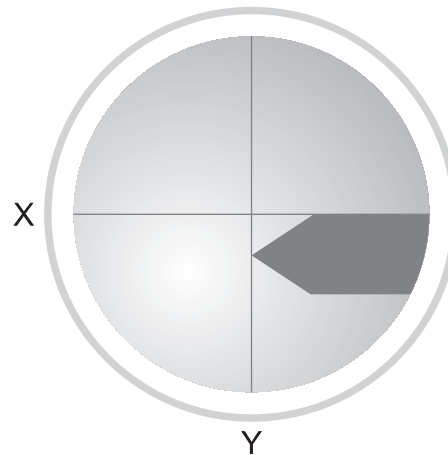


- Press the X keypad and the Y keypad on the control panel to set the values to zero.



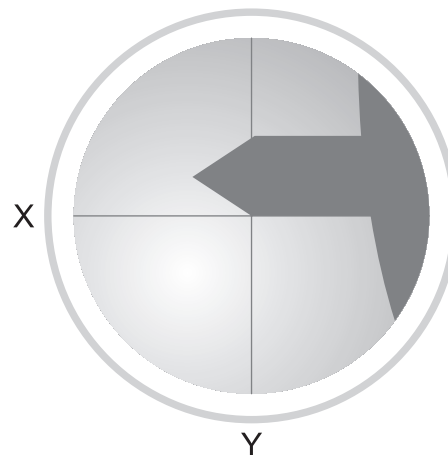
Press Here to Set Values to 0



**5. Measure the X axis.**

- Rapid feed and fine feed the table until the end of the required X axis measurement is reached.
- Record the x value shown on the control panel.

Note: Remember that a negative or positive value is merely the direction you are traveling on the axis. They are absolute values when recorded.

**6. Measure the Y axis.**

- Turn the Y axis adjuster until the top (or bottom) measurement is reached.
- Record the value displayed on the control panel.

**7. Verify the recorded measurements with the print or the expected measurements.**