

## TI-25M

### Changing Calibration — Two-Point Calibration Procedure

**NOTE:** This procedure requires two samples with "known" thickness values are available during this calibration. The two samples should be at the high and low portions of the expected range thickness that will be encountered.

1. Turn on the gauge
2. Perform a Probe-Zero using the
3. Apply couplant to the sample piece.
4. Press the transducer against the sample piece, at the first/second calibration point, making sure that the transducer sits flat against the surface of the sample. The display should show some (probably incorrect) thickness value, and the Stability Indicator should have nearly all its bars on.
5. Having achieved a stable reading, remove the transducer. If the displayed thickness changes from the value shown while the transducer was coupled, repeat step 4.
6. Press the CAL key. The IN (or MM) symbol should begin flashing.
7. Use the UP and DOWN arrow keys to adjust the displayed thickness up or down, until it matches the thickness of the sample piece.
8. Press the PROBE-ZERO key. The display will flash 1OF2. Repeat steps 3 through 7 on the second calibration point.
9. Press the PROBE-ZERO key again and the display will now show the sound velocity value it has calculated based on the two known thickness values that were entered.
10. The gauge is now ready to perform measurements within this range on that material.