

DAKOTA ULTRASONICS

MAX

ULTRASONIC BOLT METER

OPERATION AND REFERENCE MANUAL
VER. 1.4

This manual applies to MAX units with “Rel. 1.0” Firmware or later
To update the MAX with the latest firmware see Appendix E

DAKOTA ULTRASONICS Inc.

Table of contents

Company contact information	1
Warranty & Safety Information	1
Diagram of the MAX	2
Dakota Ultrasonics MAX Specifications	3
The Dakota Ultrasonics MAX system	4
How the Dakota Ultrasonics MAX Bolt Meter Works	
Features of the Dakota Ultrasonics MAX	5
Ultrasonic measurement of bolts	5
Low frequency versus high frequency	6
Effect of transducer diameter	6
Bolt end conditions effecting measurement	7
Tone burst pulser system	7
Analog output	7
Use of ultrasonic couplant	7
System zeroing	8
Preparing for measurement	
Selecting the appropriate transducer	9
Requirements for connecting bolt ends	10
Requirements for reflecting bolt ends	11
Preparing the MAX for operation	12
SETUP MAX functions	
Selecting SETUP MAX from Main menu	13
Entering temperature of calibration bars	15
Entering known length of calibration bars	17
Entering ultrasonic velocity of calibration bars	18
Measuring ultrasonic length of calibration bars	19
Manually entering system zero	21
Calculating system zero	21
Selecting units of measure	22
Setting ultrasonics	23
Selecting transducer frequency	24
Setting analog output	25
Setting automatic triggering	27
Establishing a password	28
BOLT DATA GROUP functions	
Selecting from the Main menu	30
Deleting a bolt group	30
Deleting all bolt groups	32
Creating and changing bolt groups	32
Entering or changing the sonic stress factor	34
Entering or changing the approximate length	35
Entering or changing the velocity	36

Entering or changing the temperature factor	37
Changing the load factor	38
Changing the load offset	39
Calculating the bolt load factor	40
MEASURE functions	
Selecting from the Main menu	42
Entering bolt temperature	42
Selecting the Bolt Group to measure	43
Deleting bolt data from the active Bolt Group	44
Measuring a bolt in the active Bolt Group	46
Measuring elongation and load	47
Entering a known load for calibration	49
Viewing and changing bolt data	50
Changing or viewing length	51
Changing or viewing elongation	52
Changing or viewing load	53
Reporting and transmitting data	
Sending reports to a PC or printer	55
Reporting all groups	56
Reporting a single group	56
Transferring data between MAX units	57
Transferring from the MAX to a PC	59
Transferring data from a PC to the MAX	60
Canceling data transmission	61
Signal Analysis	
When measuring unloaded length	62
When measuring elongation or load	63
Rectified signal display	65
Appendix	
A: Bolt calibration factors	66
B: Determining sonic stress factor by measuring length	67
Estimating sonic stress factor by measuring load	69
C: Determining the temperature factor	71
D: Messages, Hidden Key functions	73
Troubleshooting	74
E: Reprogramming the MAX	75
F: Units of measure	79
G: Sample report	80
H: Standard Dakota Ultrasonics ultrasonic transducers	81
Index	84

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Warranty & Safety Information

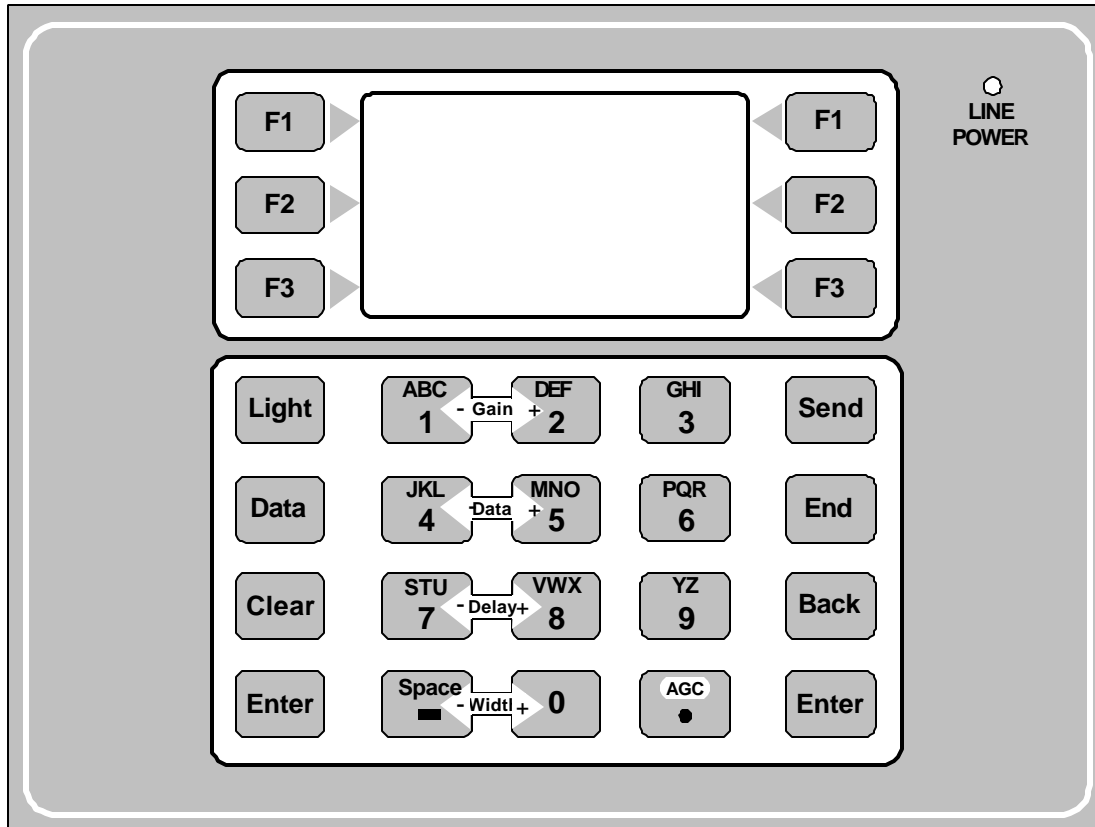
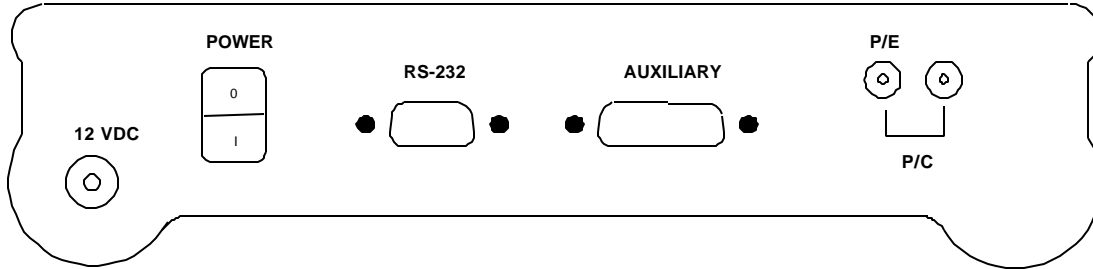
Limited Warranty

The Dakota Ultrasonics MAX carries a two year limited warranty. The warranty only applies to MAX units being operated as described in this manual. Software and hardware failures of the unit will be repaired or replaced at Dakota Ultrasonics discretion. Dakota Ultrasonics will not be held liable for any damage caused, interruption of business, loss of profits, etc., resulting from such failures. Dakota Ultrasonics will not be liable to repair or replace a unit, which has been damaged, used inappropriately, or subject to unauthorized repair by the purchaser.

Safety Information

- Using the MAX while standing in water or in a wet environment can result in serious electric shock, injury, and even death.
- Operating the MAX with damaged or inadequate cables and power source can result in serious electric shock, injury, and even death.
- Failure to read this manual and understand the proper operation of the MAX can result in inaccurate measurements, and lead to decisions which cause property damage, personal injury, or even death.
- Use of the MAX for any other purpose, or in any other manner than described in this manual invalidates the warranty and can result in serious electric shock, injury, and even death.

Diagram of the MAX



Dakota Ultrasonics MAX Specifications

PHYSICAL DESCRIPTION	ULTRASONIC SPECIFICATIONS
Size: 8.5 " W X 6.4" H X 2" D	Resolution: 0.0001 inch (0.002mm)
Weight: 3.8 lbs.	General: Pitch catch, pulse echo measurement modes.
Keypad: Membrane switch with tactile keys.	Automatic peak signal and phase selection.
Display: 128 x 64 pixels with EL Back-light	Pulser: 160 volt push / pull tone burst Selectable burst width.
Case: Sealed Aluminum.	Selectable frequencies 1.0, 2.25, and 5.0 MHz.
Line power: 90 - 250 VAC 47 to 63 Hz Battery Power 4 "C" Cells	Receiver: Low noise preamplifier. Automatic gain control. Automatic waveform and signal diagnostic display
Operating Temperature: 0 to 40°C / 32°F to 104°F	Timing: 160 MHz 10 ppm TCXO controlled digitizer.
Automatic Compensation for Temperature Of Fastener	Memory: 2 megabit non-volatile. 1000 bolts, 5000 measurements.
Calibration: Automatic verification of system calibration Field verification of bolt material calibration constants	
Data Output: RS232 I/O. 0 to 10 V Analog Output	2 YEAR LIMITED WARRANTY

The Dakota Ultrasonics MAX system

The MAX Bolt Meter system includes:

- Unit and carrying case
- Either a 10 " or 20 " transducer cable, with Lemo to MicroDot connectors
- Power cord
- RS232 Data Transfer Cable DB9 M/F
- 4 oz. Bottle of ultrasonic couplant
- Operation & Reference Manual
- Price list for transducers and accessories

How the Dakota Ultrasonics MAX Bolt Meter works

Features of the Dakota Ultrasonics MAX

Note: The terms *bolt*, *fastener*, and *threaded fastener* are used interchangeably.

The Dakota Ultrasonics MAX, Ultrasonic Bolt Meter, defines the State of the Art in the measurement of the actual clamp load produced by tightening a fastener. The MAX can measure clamp load or the resulting elongation extremely accurately in bolts of virtually any material from 1 inch to 50 feet in length.

Through the use of digital signal processing and automated signal diagnostics the MAX minimizes operator training and preparation. The Dakota Ultrasonics MAX provides state of the art hardware and software to achieve measurements with maximum automation, minimizing operator interpretation. Offering digital recordation and transmission of data, as well as calibrated analog signal output, the MAX offers a complete system for measurement, recordation, and control of bolt tension in the most demanding applications.

Ultrasonic measurement of bolts

Ultrasonic measurement has proven to be the most reliable and cost effective solution when:

- Variations in friction or joint geometry prevent applied torque from controlling the actual clamping force produced by the fastener with the required accuracy.
- The clamping force must be monitored over the service life of the bolt.

Ultrasonic measurement of clamping load is obtained through a predictable decrease in the sound velocity within the body of the bolt as the tensile load is increased. By introducing a sonic pulse at one end of the bolt and accurately measuring the time required for the echo to return from the opposite end, the ultrasonic length is determined. As the fastener is tightened, the change in this ultrasonic length is used to calculate and display the actual clamping force produced.

The physics governing this process are clearly understood, and have been employed for many years in the fields of active sonar, or radar. Send a pulse of energy toward an object (in this case the opposite or reflecting end of the fastener), and then measure the time between the initial pulse and the returning echo.

While the concept is comparatively simple and ultrasonic measurement can produce astoundingly accurate results, the selection of the optimum bolt and transducer, and their

coupling can be difficult. The MAX minimizes these difficulties to the greatest extent possible:

- The selectable tone burst pulser system can send the maximum amount of energy to the ultrasonic transducer, allowing the broadest possible range of transducers for a given application.
- The low noise and automatic Gain features of the receiver system allow signal detection and measurement in the most difficult applications.
- Automatic digital signal analysis optimizes the measurement process and warns of potential problems.

Low frequency versus high frequency

Ultrasonic measurement requires the transmission of a suitable quantity of ultrasonic energy through the length of the bolt. The relationship of the energy pulse frequency to its penetration is important in energy transmission. Lower frequencies produce longer wavelengths that will travel further through a given substance: while higher frequencies produce shorter wavelengths. To use a familiar example: AM radio signals are broadcast at relatively low frequencies and can be received hundreds of miles away, over the horizon. Higher quality FM radio and television signals are broadcast at much higher frequencies, and can only be received within a comparatively short line-of-sight distance.

The same phenomenon exists with ultrasound. A low frequency 1 MHz pulse travels much farther through metal than a 5 MHz pulse. Therefore, a lower frequency transducer is able to achieve an echo in a longer bolt, or in a bolt made of metal with higher resistance to sound transmission (attenuation). While the lower frequency has more penetration power, it also produces more unwanted noise. Low frequency energy tends to spread, much like an unfocussed beam of light. When low frequency energy is introduced at the end of a bolt, a significant portion is bounced from side to side within the cylindrical shape, producing a noisy and distorted echo. Higher frequency pulses tend to travel more directly down and back the centerline of a bolt, with less noise and distortion.

Effect of transducer diameter

The best balance between maximum frequency and noise suppression requires selecting the best transducer for bolt measurement. The diameter of the transducer (which is generally specified by the diameter of the actual piezoelectric crystal) directly effects energy transmission: Larger diameter crystals have greater ability to send and receive energy, and less of the energy tends to spread laterally. The MAX Bolt Meter strives to achieve this ideal balance: direct transmission of the strongest possible pulse, with the least amount of noise and distortion, down and back the center of the bolt to obtain the most accurate measurement.

Bolt end conditions effecting measurement

Dirty, rusty, heavily painted, or uneven bolt ends create uneven echoes and interfere with precise ultrasonic measurement. The echo ricocheting back through the bolt travels further than the echo returning directly along the bolt axis, reaching the transducer at a slightly different time. The overlapping echoes are interpreted by the MAX as a single distorted signal, which does not match the frequency of the transmitted pulse. A reduction in the bar indicator of frequency match, described in Signal Analysis, will alert the operator of this discrepancy.

Bending of the bolt under load and nonperpendicular bolt ends create similar problems. Bending of the bolt is a fairly common occurrence, normally due to nonparallel faces of materials being clamped, or by bending these faces to nonparallel during tightening. Pipe flanges or joints with partial gaskets are prone to this problem. When the bolt is bent, both ends of the bolt are forced out of perpendicular to the path of the ultrasonic pulse.

Tone burst pulser system

Adjustment of the tone burst pulser system optimizes the amplitude of the ultrasonic signal. This is accomplished by adjusting the number of synchronized impulses sent to the transducer. This is similar to delivering multiple pushes to a schoolyard swing causing the swing to go higher. Increased ultrasonic signal amplitude is useful for long fasteners or materials of high acoustic attenuation.

Analog output

The MAX offers a linear 0-10 VDC high-speed analog signal output via the BNC connector located on the rear panel. This signal can be calibrated to be directly proportional to either Elongation or Load. It is used to interface the MAX to analog recording devices, visual and audio alarms, and various control devices used to stop power tightening tools at a selected Load or Elongation.

Use of ultrasonic couplant

Sonic energy of the frequency used by the MAX travels well through solid materials and most liquids. It does not travel well through air. This variable resistance to the passage of sonic energy is called *sonic impedance*. It is the sudden change in impedance which occurs when the sound pulse attempts to cross the metal / air boundary at the end of the bolt, which causes most of the energy to be returned as an echo. To make a familiar comparison: light crossing the transparent glass boundary of a mirror and reflecting back an image from the nontransparent silvered back is much like an echo.

Any air gap between the face of the transducer and the end of the bolt will prevent the sonic energy from crossing. The gap must be filled with a suitable coupling fluid. Normally, a liquid ultrasonic couplant is applied between the transducer and the bolt. Since liquid has sonic impedance closer to the transducer and bolt material than air, it forms a continuous path for the outgoing pulse and the returning echo.

Many liquids can serve as an adequate couplant, however, liquids with lower sonic attenuation will produce better results. Liquids containing glycerin offer such low impedance, and couplant manufactured for ultrasonic testing, such as the one shipped with the MAX, produce the best results. Water or even saliva can be used in a pinch, but the results will not be as good, and may be dangerous in certain environments.

The single purpose of the couplant is to fill the air gap between the transducer and the bolt end. This is accomplished more easily with a liquid that is viscous enough to stay in place. Very viscous substances can create such a thick layer between the transducer and bolt that measurement errors occur. Also, viscous substances can trap air bubbles, which prevent adequate energy transmission. Again, the ultrasonic couplant provided with the MAX works best. Apply only the smallest quantity of couplant required to fill the air gap, and carefully seat the transducer so that any trapped air or excess couplant is squeezed out of the interface.

System zeroing

System zeroing is the method of calculating the time required for each MAX and transducer combination to detect the echo. When an echo travels back through the bolt to the transducer face, there is an electronic delay before the MAX detects the echo. Because of differences in the electronic parts, or the transducer and cable, the delay is slightly different for each combination of MAX and transducer. The time delay is called the *delay factor* or *zero time offset*.

The MAX is designed for use with two calibration bars having a known ultrasonic velocity and known length. Comparing their known physical length and measured ultrasonic length determines the system delay factor, or zero time offset. The system delay factor makes the Dakota Ultrasonics MAX interchangeable with all other calibrated MAX systems.

Once the delay factor is determined, the MAX software automatically subtracts it from the apparent measurement of the time required for the sonic signal to travel through the bolt. Thus, the actual time of signal travel is determined, and compensation is made for the slight difference in each system. Since every *zeroed* MAX makes the same time measurement, the systems give the same result and are interchangeable.

System Zeroing is only required if changing between MAX units, or changing between transducers, while measuring a set of bolts. If the same MAX and transducer are used, the amount of the delay is constant. If unloaded length measurements were made with one MAX, and the load measurements were made with another, the difference in the delay factor could cause an error, though in most cases the error would be very small. Since it is uncertain that the same unit and transducer will always be used, it is strongly recommended that System Zeroing be checked whenever the MAX used.

Preparing for measurement

The goal is to transmit as much sonic energy as possible from the transducer into the bolt, and to send that energy, to the greatest extent possible, down and back the center of the bolt, as shown in Figure 1.

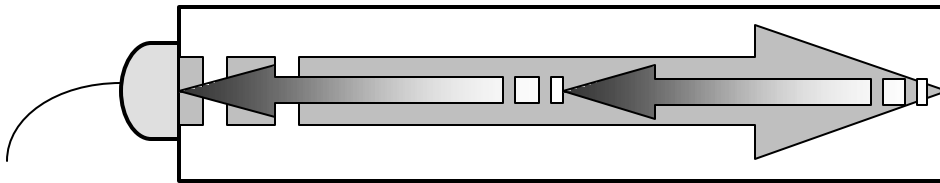


Figure 1

Selecting the appropriate transducer

- Select the largest diameter transducer that will seat completely on the end of the bolt.
- Select the highest frequency transducer of that diameter.
- Using the “SET ULTRASONICS” function in the SETUP MENU match the frequency of the MAX pulser to the frequency of the transducer, and set the pulse width to 1 pulse.
- If the signal magnitude is too small, select a lower frequency transducer of the same diameter, and reset the frequency of the MAX pulser.
- If the lower frequency transducer does not produce an acceptable echo, send a greater pulse width (2 or 4 pulses) by adjusting the tone burst pulser in the MAX Setup Menu. This sends more energy to the transducer, producing a larger signal.

Requirements for connecting bolt ends

Smooth, even surfaced bolt ends that seat the entire active surface of the transducer with minimum gap are required for accurate signal transmission. Bolt ends may need to be cleaned, ground, etc. to achieve the required surface.

Avoid:

- Rough or irregular surfaces that prevent adequate contact with the transducer. Energy will ricochet off the side walls. Irregular or rough surfaces can be filled with couplant, but energy transmission will still be reduced and dispersed, as shown in Figure 2.
- Bolt ends not perpendicular to the axis of the bolt, as shown in Figure 3. Energy will be transmitted toward the side wall and ricochet along the bolt, yielding poor signal quality and possible measurement errors. Avoid alignment errors exceeding 2 degrees.

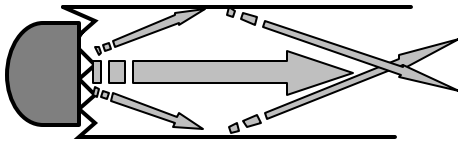


Figure 2

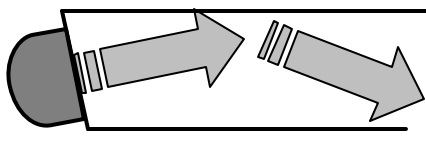


Figure 3

- Rusted, dirty, or thick paint-covered bolt ends. These coatings prevent sonic energy from traveling between the transducer and the bolt. Very thin well-adhered coating or plating is acceptable.
- Bolt ends with recessed grademarks, as shown in Figure 4. Couplant can be used to fill recessed grademarks. Small indentations cause some loss of signal strength, but normal measurement is still possible. Large or numerous indentations cause the signal to be too weak for reliable measurement.
- Bolt ends with raised grade marks, or indentations with a raised edge, which cause the transducer to sit at an angle to the axis of the bolt, preventing adequate contact, as shown in Figure 5.

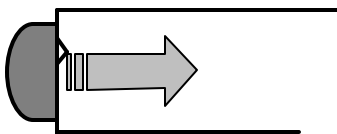


Figure 4

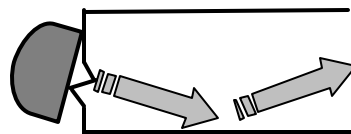


Figure 5

Requirements for reflecting bolt ends

Smooth, flat reflecting bolt ends that are perpendicular to the axis of the bolt are required for accurate echo reception. Bolt ends may need to be cleaned, ground, etc. to achieve the required surface.

Note: Misalignment exceeding 2 degrees can cause significant errors.

Avoid:

- Rough reflecting bolt ends. As shown in Figure 6, if the reflecting end of the bolt is rough or curved, most of the reflected energy will be dispersed and a weak or distorted echo will be received.
- Reflecting bolt ends not perpendicular to the axis of the bolt. Sonic energy will be reflected toward the side wall of the bolt, as shown in Figure 7.
- Nonperpendicular reflecting bolt ends due to bending of the bolt as shown in Figure 8.

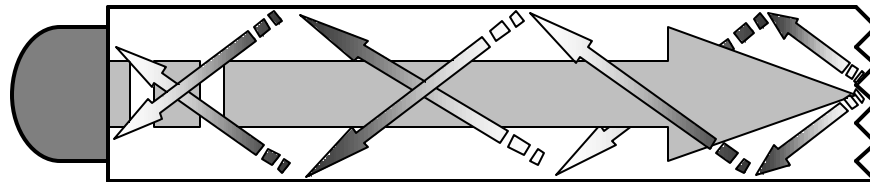


Figure 6

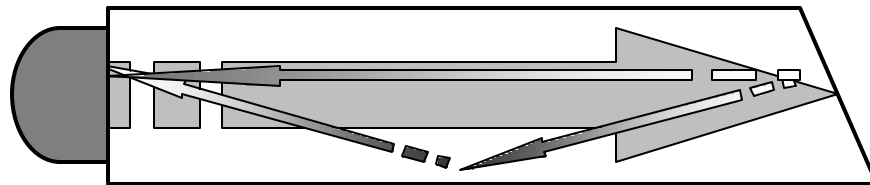


Figure 7

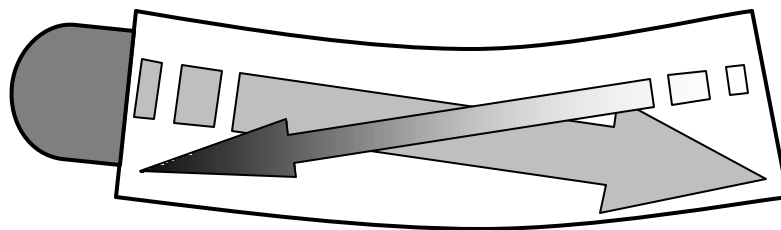


Figure 8

Preparing the MAX for operation

1. Insert 4 “C” batteries as shown on the back label (The MAX is designed to operate with Alkaline batteries. Rechargeable batteries may be substituted at the users option. However, this will result in reduced operating time between battery charges.

Or

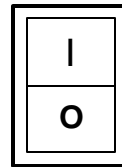
Connect the MAX power adapter to the 12 VDC power input connector on the unit and to a grounded A/C power supply of 90 to 240 VAC.

2. Connect the appropriate transducer(s) and cable(s) to the transducer port(s) on the back of the unit.

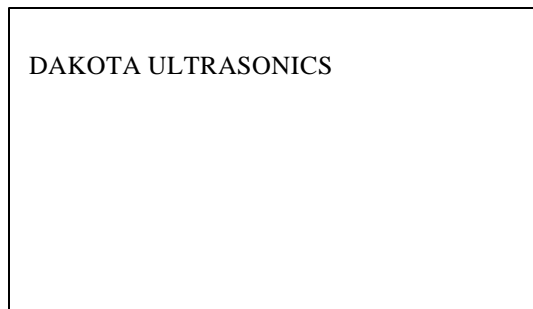
NOTE: USE THE P/E PORT WHEN USING A SINGLE TRANSDUCER.



3. Turn on the MAX with the power switch.



The Dakota Ultrasonics Logo is displayed:



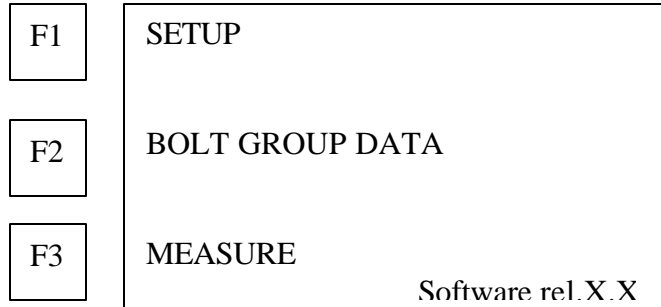
4. Enter password.

The MAX is delivered with the password set at zero (0.0) allowing free access to all functions. If a password other than zero has been established, it must be entered while the Dakota Ultrasonics logo is displayed by using the numeric keypad. Page 28 describes how to establish a numeric password. The password controls access to all functions of the unit (unit settings, unit calibration, and bolt group data) other than those used in the actual bolt measurement, and data recordation process. An operator without the password can only measure bolts and record data as preprogrammed by the person with password control.

Note: There is no password prompt, or any visual acknowledgement of password entry.

5. Press the ENTER key.

The Main menu appears showing the software version in lower right corner:



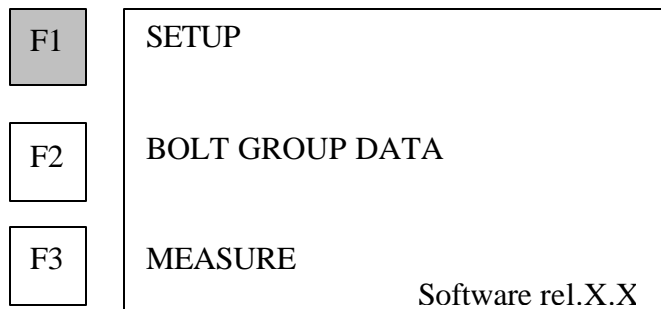
- **F1** (SETUP MAX) allows the operator to set the variables which control the overall operation of the MAX.
- **F2** (BOLT GROUP DATA) allows programming of the variables associated with the bolts to be measured and the management of the data collected.
- **F3** (MEASURE) moves the MAX to the actual measurement function.

Note: Without entry of an established password, the MAX will skip the SETUP MAX functions and go directly to MEASURE menu.

SETUP MAX functions

Note: Press the **END** key at any point in the SETUP program to return to Main menu.

Select SETUP MAX to review or change the operational settings of the MAX.



1. Press F1 (SETUP MAX) on the Main menu to display operational settings.

F1	DISPLAY CONTRAST 1 TO 15
F2	CHECK BATTERY XXX
F3	NEXT PAGE

2. Press F1 (DISPLAY CONTRAST) to change screen contrast.

Then press F1 or F2 to increase /decrease contrast by increments of one.

F1	INCREASE 1 TO 15
F2	DECREASE
F3	EXIT

3. Press F3 (EXIT) when contrast is satisfactory.

Display returns to contrast / backlight menu:

F1	DISPLAY CONTRAST 1 TO 15
F2	CHECK BATTERY XXX
F3	NEXT PAGE

4. Press F2 (CHECK BATTERY) to display a bar graph depicting the amount of charge in the batteries. The number appearing below the CHECK BATTERY (0 TO 256) also indicates the charge remaining in the batteries.

5. Press F3 (NEXT PAGE) when contrast setting and battery check are satisfactory.

F1	MEASURE SYSTEM ZERO
F2	SELECT UNIT SYSTEM POUNDS / INCHES
F3	NEXT PAGE

6. Press F1 (MEASURE SYSTEM ZERO) to begin zeroing the MAX and transducer combination.

Note: Dakota Ultrasonics offers calibration bars approximately 1.5 inch (38mm) diameter x 3 inches (76mm) in length and 1.5 inch (38mm) diameter x 6 inches (152mm) constructed of vacuum melt steel with the sound velocity of approximately 232,000 inches per second (5892800 mm/sec).

Entering temperature of calibration bars

Use this menu to verify or input the temperature of the calibration bars. The MAX requests the temperature and the sonic temperature factor for the material of the calibration bars. Temperature and temperature factor shown are from the previous calibration.

Note: Prior to delivery the MAX is programmed with the temperature factor imprinted on the side of the Dakota Ultrasonics calibration bars. If other calibration bars are used, care must be taken to accurately determine its sonic velocity and sonic temperature factor. APPENDIX A presents approximate values for a number of materials.

1. Determine the temperature of the calibration bars.

F1	TEMPERATURE 68.1
F2	TEMPERATURE FACTOR 58.0
F3	CONTINUE

2. Press F1 (TEMPERATURE) if the temperature of the calibration bars at the time of use is different from the temperature shown.

F1	TEMPERATURE CAL. BAR
F2	XXX.XX
F3	PRESS ENTER KEY

3. Use the number keys to enter correct temperature.
4. Press ENTER key after data is entered.

MAX returns to the Temperature menu:

F1	TEMPERATURE 68.1
F2	TEMPERATURE FACTOR 58.0
F3	CONTINUE

1. Press F2 (TEMPERATURE FACTOR) if the temperature factor of the calibration bars is different from the temperature factor shown.

F1	TEMPERATURE FACTOR
F2	XXX.XX
F3	PRESS ENTER KEY

2. Use the number keys to enter correct temperature factor.
3. Press ENTER key after data is entered.

F1	TEMPERATURE 68.1
F2	TEMPERATURE FACTOR 58.0
F3	CONTINUE

4. Press F3 (CONTINUE) when temperature and temperature factor are set.

Entering known length of calibration bars

MAX displays data from memory of the previous calibration:

F1	CAL. BAR 1 X.XXXX X.XXXX
F2	CAL. BAR 2 X.XXXX X.XXXX
F3	VELOCITY SYS ZERO XXXX XX X.XXX

1. Press F1 (CAL BAR 1) to set data on calibration bar #1.

F1	CAL. BAR 1
F2	KNOWN LENGTH X.XXX
F3	ULTRASONIC LENGTH X.XXX

2. If it is different than previous data, press F2 (KNOWN LENGTH) to enter the physical length of calibration bar #1 measured at 68° F (20° C).

F1	ENTER KNOWN LENGTH CAL. BAR 1
F2	X.XXXXX
F3	PRESS ENTER KEY

3. Use the number keys to enter data.

4. Press ENTER key after data is entered.

MAX returns to the calibration menu:

F1	CAL. BAR 1 X.XXXX X.XXXX
F2	CAL. BAR 2 X.XXXX X.XXXX
F3	VELOCITY SYS ZERO XXXX XX X.XXX

- 5. Press F2 to select calibration bar #2.
- 6. Repeat steps 2 through 4 to enter known length of calibration bar #2.

Entering ultrasonic velocity of calibration bars

F1	CAL. BAR 1 X.XXXX X.XXXX
F2	CAL. BAR 2 X.XXXX X.XXXX
F3	VELOCITY SYS ZERO XXXX X.XXX

1. Press F3 (VELOCITY SYS ZERO).

F1	VELOCITY XXXXXX
F2	SYSTEM ZERO XXXXX
F3	OPTIMIZE SYSTEM ZERO

2. Press F1 (VELOCITY) to input material velocity other than that shown.

F1	VELOCITY
F2	XXXXXXXX
F3	PRESS ENTER KEY

3. Enter data with number keys.

4. Press the ENTER key.

F1	VELOCITY 232000
F2	SYSTEM ZERO XXXXX
F3	OPTIMIZE SYSTEM ZERO

5. Press Back to return to calibration data menu

F1	CAL. BAR 1 X.XXXX X.XXXX
F2	CAL. BAR 2 X.XXXX X.XXXX
F3	VELOCITY SYS ZERO XXXX X.XXX

6. Press F2 (CAL. BAR 2) to select calibration bar #2.

7. Repeat steps 1 through 4 for calibration bar #2

Measuring ultrasonic length of calibration bars

1. Apply couplant.

- Apply a small quantity of liquid ultrasonic couplant between the transducer and the end of the calibration bar.
- Use the ultrasonic liquid couplant shipped with the MAX for best results.
- Order additional couplant from Dakota Ultrasonics.

2. Attach transducer to end of calibration bar.

- Seat the transducer directly and completely on the end of the calibration bar.
- Squeeze out any trapped air and excess couplant.

F1	CAL. BAR 1
F2	KNOWN LENGTH 4.100
F3	ULTRASONIC LENGTH X.XXX

3. Press F3 (ULTRASONIC LENGTH).

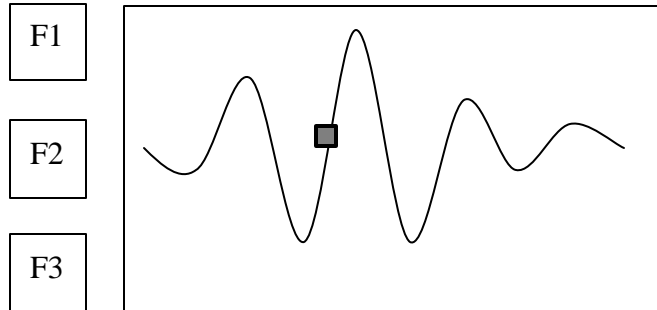
Note: If the MAX automatic trigger mode is OFF, the MAX displays a graphic image of the echo received from the opposite end of the calibration bar. The Gain required to achieve it is shown at bottom of screen.

F1	PRESS ENTER KEY
F2	
F3	XXXX GNXXX XXXX

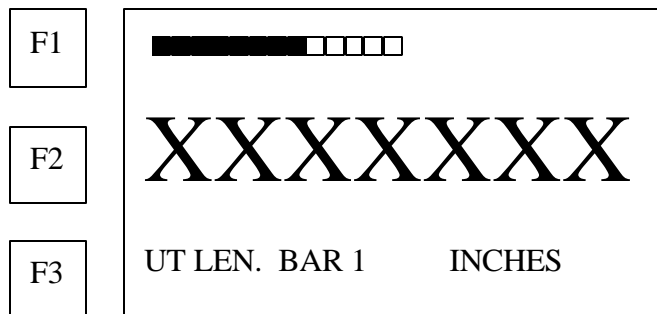
4. Adjust the position of the transducer on the bar end to minimize the gain value displayed, and obtain, as closely as possible, a single spike of maximum height.

5. Press ENTER key when lowest gain is obtained.

The MAX selects the best measurement point and displays the time of flight (echo):



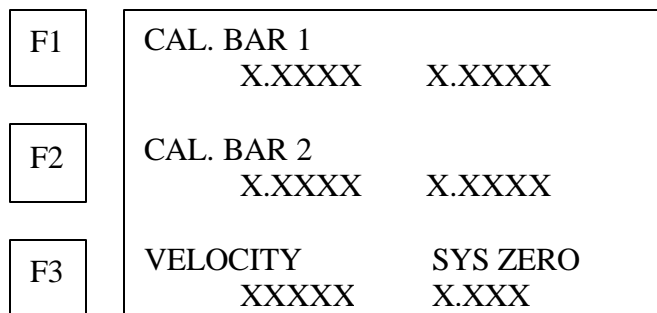
The ultrasonic length value is displayed:



Note: If the automatic trigger is ON, the MAX goes directly to the above display.

6. Press ENTER key for calibration status display.

MAX displays the calibration data:



7. Press F2 to select calibration bar #2.

8. Repeat steps 3 through 7 to obtain ultrasonic length for calibration bar #2.

Press F3 (VELOCITY SYS ZERO) to displays calibration options.

Manually entering system zero

If the system zero, or delay factor for the MAX is known from previous calibration, may be entered manually as follows:

F1	VELOCITY XXXXXX
F2	SYSTEM ZERO XXXXX
F3	OPTIMIZE SYSTEM ZERO

1. Press F2 (SYSTEM ZERO) to manually input a delay value for the system.

F1	SYSTEM ZERO
F2	XXXXXXXX
F3	PRESS ENTER KEY

8. Use the number keys to enter the data.

9. Press the ENTER key.

MAX returns to the calibration options:

F1	VELOCITY XXXXXX
F2	SYSTEM ZERO XXXXX
F3	OPTIMIZE SYSTEM ZERO

Calculating system zero

1. Press F3 (OPTIMIZE SYSTEM ZERO) to calculate the internal delay based on the known lengths and measured ultrasonic lengths recorded for the cal bars.

MAX displays calculated delay values and places them in memory for use in all subsequent measurements.

F1	CAL. BAR 1 X.XXXX X.XXXX
F2	CAL. BAR 2 X.XXXX X.XXXX
F3	VELOCITY SYS ZERO 233000 X.XXX

To verify that the system zero factor has been properly determined, check to see that the known length and ultrasonic length displayed, match to within ± 0.0002 inch or ± 0.002 mm. Repeat the ultrasonic measurements to verify.

2. Press the END key to exit calibration and return to the Main menu.

Selecting units of measure

F1	SETUP USM
F2	BOLT GROUP DATA
F3	MEASURE
	Software rel.X.X

1. Press F1 (SETUP MAX).

F1	MEASURE SYSTEM ZERO
F2	SELECT UNIT SYSTEM POUNDS / INCHES
F3	NEXT PAGE

2. Press F2 (SELECT UNIT SYSTEM) to select the unit system in which the MAX is to operate.

MAX displays measurement unit options:

F1	POUNDS / INCHES
F2	KILONEWTONS / MM
F3	KILOGRAMS / MM

3. Press F1, F2, or F3 to select units of measurement.

MAX returns to the SETUP MAX menu.

Setting ultrasonics

F1	SETUP USM
F2	SELECT UNIT SYSTEM POUNDS / INCHES
F3	NEXT PAGE

1. Press F3 (NEXT PAGE) to display the Ultrasonics menu.

F1	SET ULTRASONICS
F2	SET ANALOG OUTPUT
F3	NEXT PAGE

2. Press F1 (SET ULTRASONICS) to adjust the ultrasonic pulse and receive system.

F1	RECEIVER MODE PULSE/ ECHO
F2	TRANSDUCER FREQUENCY 5 MHZ
F3	PULSE WIDTH 1 PULSE

3. Press F1 (RECEIVER MODE) to select the ultrasonic measurement mode.

F1	PULSE / ECHO
F2	PITCH / CATCH
F3	

- Press F1 (PULSE / ECHO) if using a single transducer.
NOTE: (PULSE/ECHO) uses transducer connector #2.
- Or press F2 (PITCH / CATCH) if using two transducers placed at opposite ends of the fastener to transmit and receive. Two transducers can transmit ultrasonic signals over greater lengths and through material of high acoustic attenuation.

Selecting transducer frequency

After selection of receiver mode, MAX returns to the Set Ultrasonics menu:

F1	RECEIVER MODE PULSE/ ECHO
F2	TRANSDUCER FREQUENCY 5 MHZ
F3	PULSE WIDTH 1 PULSE

1. Press F2 (TRANSDUCER FREQUENCY) to match the MAX pulser to the ultrasonic transducer being used.

This function optimizes generation and reception of ultrasonic energy for proper evaluation of the signal.

F1	1 MHZ
F2	2.25 MHZ
F3	5 MHZ

2. Press F1, F2, or F3 to select the frequency that matches the transducer.

F1	RECEIVER MODE PULSE/ ECHO
F2	TRANSDUCER FREQUENCY 5 MHZ
F3	PULSE WIDTH 1 PULSE

3. Press F3 (PULSE WIDTH) to adjust the tone burst pulser.

Note: Increasing signal energy also increases acoustic noise or interference. Select the minimum pulse width that yields a measurable signal.

F1	1 PULSE
F2	2 PULSES
F3	4 PULSES

4. Press F1, F2, or F3 to set the number of pulses to be sent to the transducer.
Ultrasonics are now set.

Setting analog output

1. Press BACK key to return to page 2 of the setup menu.

F1	SET ULTRASONICS
F2	SET ANALOG OUTPUT
F3	NEXT PAGE

2. Press F2 (SET ANALOG OUT) to program the analog signal output.

F1	SCALE ELONGATION
F2	SCALE LOAD
F3	CAL VOLTS OUT

3. Press F1 (SCALE ELONGATION) to calibrate the analog signal output to correspond to elongation.

F1	ENTER FULL SCALE ELONG
F2	0.XXXXX
F3	PRESS ENTER KEY

4. Using the number keys, enter the fastener elongation value which corresponds to a maximum analog output voltage of 10 VDC.

5. Press the ENTER key.

MAX returns to the Set Analog Output menu:

F1	SCALE ELONGATION
F2	SCALE LOAD
F3	CAL VOLTS OUT

6. Press F2 (SCALE LOAD) to calibrate the analog signal output to correspond to load.

F1	ENTER FULL SCALE LOAD
F2	XXXXXXXXXX
F3	PRESS ENTER KEY

7. Use the number keys to enter the fastener load value which corresponds to a maximum analog signal output voltage of 10 VDC.

8. Press the ENTER key.

9. Connect the peripheral device to the AUXILARY (15 pin “D” connector) port on the back of the MAX.

F1	SCALE ELONGATION
F2	SCALE LOAD
F3	CAL VOLTS OUT

10. Press F3 (CAL VOLTS OUT) to output test output.

F1	OUTPUT 0.00 VOLTS
F2	OUTPUT 10.00 VOLTS
F3	EXIT

- Press F1 (OUTPUT 0.00 VOLTS) to output 0.000 VDC.
Adjust zero setting on the periferal device
- Press F2 (OUTPUT 10.00 VOLTS) to output 10.000 VDC (nominal)
Adjust full scale setting on the peripheral device

11. Press F3 (EXIT) to exit Set Analog Out and return to the setup MAX menu.

Setting automatic triggering

F1	SET ULTRASONICS
F2	SET ANALOG OUTPUT
F3	NEXT PAGE


1. Press F3 (NEXT PAGE).

F1	AUTO TRIGGER OFF
F2	PASSWORD 0
F3	EXIT

2. Press F1 (AUTO TRIGGER) to toggle the automatic triggering on and off.

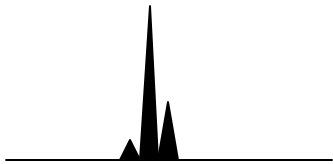
- AUTO TRIGGER ON**

Use this mode for bolts that can be measured without difficulty. The MAX bypasses the rectified signal display, and signal acquisition, to go directly to digital measurement.

F1	
F2	XXXXXXXXXX
F3	UT LEN. BAR 1 INCHES

- AUTO TRIGGER OFF**

Use this mode for preliminary measurements, or for difficult to measure bolts. The MAX displays the received signal as a rectified waveform.

F1	PRESS ENTER KEY
F2	
F3	XXXX GN: XXX XXXX

Establishing a password

Note: Password restricts access to all but the measurement function of the MAX. Set up a password before programming a bolt group data.

F1	AUTO TRIGGER OFF
F2	PASSWORD 0
F3	EXIT

1. Press F2 (PASSWORD) to establish a password.

F1	PASSWORD
F2	XXXXXXXXXX
F3	PRESS ENTER KEY

2. Use the number keys to enter a number up to seven digits, but not beginning with 0.
3. Press the ENTER key to place the password in memory.

	AUTO TRIGGER OFF
	PASSWORD 0
F3	EXIT

4. Press F3 (EXIT) or the END key to return to the main menu.

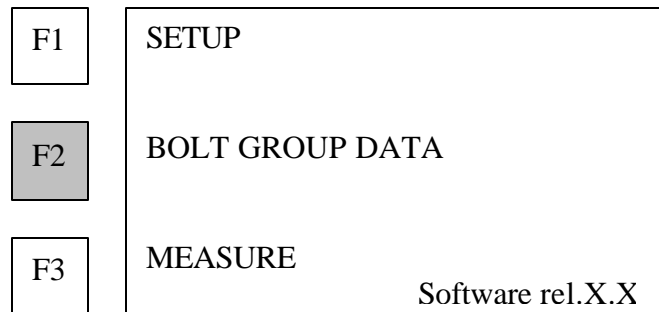
Note: If a password has been programmed at this point, it must be entered whenever the MAX is restarted. Be sure to write down your password and keep it in a safe place, as you will not be able to program the MAX without it.

BOLT GROUP DATA functions

The BOLT GROUP DATA allows input of calibration factors for the bolts to be measured, and management of data already stored in the memory of the MAX.

Use BOLT GROUP DATA to:

- create a new bolt group
- change bolt group factors
- delete a bolt group
- experimentally determine load factors

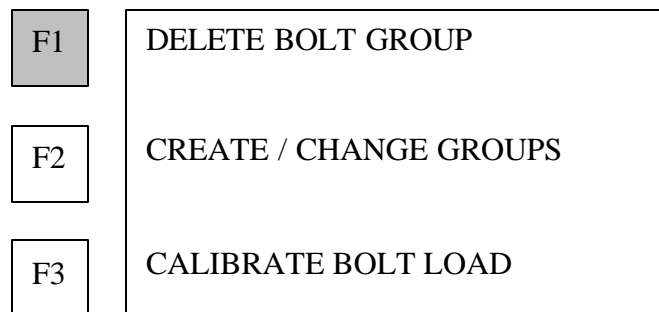


Press F2 (BOLT GROUP DATA) on the main menu to access BOLT GROUP DATA.

Deleting a bolt group

Note:

- When a group is deleted the data will be marked deleted, and that space will remain used until there is not sufficient memory to accommodate a new bolt group. At that point the MAX will verify if there is sufficient space available to accommodate the new group. If there is enough memory space, the MAX will automatically repack the memory, and a screen will warn that data will be lost if power is interrupted. See Troubleshooting in Appendix B.
- If there is any question regarding the reliability of this process, press the BACK key to abort the function.



1. Press F1 (DELETE BOLT GROUP) to delete one or more bolt groups from memory.

F1	DELETE ONE GROUP
F2	DELETE ALL GROUPS
F3	

2. Press F1 (DELETE ONE GROUP) to remove a single bolt group from memory.

F1	ENTER NAME OF GROUP TO BE DELETED
F2	XXXXXXXXXX
F3	PRESS TO SCROLL LIST

- **Use the alphanumeric keys to enter the name of the group to be deleted.**
The alphanumeric keys are used by repeatedly pressing the appropriate key until the desired letter or number is displayed. For example the first key is A,B,C, 1 and the second key is E,F,G,2.
- **Or press F3 (PRESS TO SCROLL LIST) to display the list of the bolt groups in memory.**

3. Press the ENTER key when the desired bolt group name is displayed.

MAX requests confirmation:

F1	DELETE ONE GROUP XX
F2	NO
F3	YES

- **Or press F2 (NO) to cancel.**
- **Press F3 (YES) to delete the selected bolt group.**

MAX returns to deletion option menu.

Deleting all bolt groups

F1	DELETE ONE GROUP
F2	DELETE ALL GROUPS
F3	

1. Press F2 (DELETE ALL GROUPS) to delete all bolt groups from MAX memory.

F1	DELETE ALL GROUPS
F2	NO
F3	YES

- Or press F2 (NO) to cancel deletion and return to DELETE BOLT GROUP menu.
- Press F3 (YES) to confirm deletion of all bolt groups.

The MAX will display PLEASE WAIT while each page of memory is erased.

The MAX will return to the bolt group data menu when deletion is completed

Creating and changing bolt groups

F1	DELETE BOLT GROUP
F2	CREATE / CHANGE GROUPS
F3	CALIBRATE BOLT LOAD

1. Press F2 (CREATE / CHANGE GROUPS) to add a new bolt group to memory or change the data for a bolt group previously entered in memory.

F1	ENTER NAME OF BOLT GROUP
F2	XXXXXXXXXX
F3	PRESS TO SCROLL LIST

- **Enter the name of the bolt group using the alphanumeric keys.**
The alphanumeric keys are used by repeatedly pressing the appropriate key until the desired letter or number is displayed. For example the first key is A,B,C, 1 and the second E,F,G,2.
- **Or F3 (PRESS TO SCROLL LIST) to scroll through bolt groups in memory.**

2. Press the ENTER key when the desired bolt group is displayed.

If the group is not listed in memory, the MAX inquires if a new group is being created:

F1	CREATE NEW GROUP
F2	NO
F3	YES

- **Press F2 (NO) to cancel creation of a new bolt group and return to previous screen.**
- **Or press F3 (YES) to create a new group.**

F1	ENTER MAXIMUM NUMBER OF BOLTS IN GROUP
F2	XXX
F3	PRESS ENTER KEY

- 3. Use the number keys to enter the maximum number of bolts (1 to 999) in the new group.**
NOTE: The number of bolts can not be revised after the bolt group has been created. Therefore make certain to allow enough space for all possible bolts in the group.
- 4. Press the ENTER key after data has been entered.**

The MAX displays the following menu.

For a new bolt group, the Sonic Stress Factor will default to 0.275 and the Approximate Length will be zero:

F1	SONIC STRESS FACTOR 0.275
F2	APPROX LENGTH XXX.XX
F3	CONTINUE

Entering or changing the sonic stress factor

The sonic stress factor is an empirically determined value for the bolt material or type of bolt being measured. It expresses the ratio of the actual elongation, or stretch, of the bolt, to the apparent ultrasonic change in length.

Note:

- **Appendix A presents approximate Sonic Stress Factor values for many fastener materials and types.**
- **Appendix B discusses how to determine the Sonic Stress Factor experimentally.**

The MAX defaults to Sonic Stress Factor = 0.275, the average value for common steel bolts.

F1	SONIC STRESS FACTOR 0.275
F2	APPROX LENGTH XXX.XX
F3	CONTINUE

- 1. Press F1 (SONIC STRESS FACTOR) to change the sonic stress factor for the bolt type being measured.**

F1	ENTER SONIC STRESS FACTOR
F2	X.XXX
F3	PRESS ENTER KEY

2. Use the number keys to enter or change the sonic stress factor.

3. Press the ENTER key.

Entering or changing the approximate length

The MAX requires the approximate length of the bolts in the group to eliminate interference by background noise or secondary echoes, and locate the correct echo from the reflecting end of the bolt.

Note: Approximate length entered must be within plus or minus 5% of the actual bolt length.

F1	SONIC STRESS FACTOR 0.275
F2	APPROX LENGTH XXX.XX
F3	CONTINUE

1. Press F2 (APPROXIMATE LENGTH) to change the approximate length value or enter a new value.

- MAX displays from memory the previously recorded length of an existing Bolt Group.
- For a new bolt group, the value will be 0.0.

F1	ENTER APPROXIMATE LENGTH OF BOLT
F2	XXX.X
F3	PRESS ENTER KEY

2. Use the number keys to enter or change the value.

3. Press the ENTER key.

The MAX displays the Velocity and Temperature Factor menu:

F1	VELOCITY XXXXXX
F2	TEMPERATURE FACTOR XX.X
F3	CONTINUE

4. Press F3 (CONTINUE).

Entering or changing the velocity

The velocity is the velocity of sound in the bolt material.

Note: The value of the sound velocity for a range of fastener materials and types is presented in Appendix A.

F1	VELOCITY XXXXXX
F2	TEMPERATURE FACTOR XX.X
F3	CONTINUE

Note: The MAX defaults to the average velocity for steel: V= 232000 inches/sec (5892800 mm/sec).

1. Press F1 (VELOCITY) to change the velocity value.

F1	ENTER VELOCITY
F2	XXXXXXXXXX
F3	PRESS ENTER KEY

2. Use the number keys to enter the velocity.
3. Press the ENTER key.

Entering or changing the temperature factor

The temperature factor is an empirically determined value for the bolt material or type of bolt being measured. More specifically, it is the change in the velocity of sound within the bolt material, per degree of change in the bolt temperature.

Note:

- Appendix A presents the average value of the Temperature Factor for a range of fastener materials and types.
- Appendix C discusses how to determine the temperature factor experimentally.

F1	VELOCITY XXXXXX
F2	TEMPERATURE FACTOR XX.X
F3	CONTINUE

1. Press F2 (TEMPERATURE FACTOR) to change the value of the temperature factor.

The MAX defaults to the average Temperature Factor for common steel bolts. TF = 58 /°F (104.4 /°C).

F1	ENTER TEMPERATURE FACTOR
F2	XX.X
F3	PRESS ENTER KEY

2. Use the number keys to enter or change the value.

3. Press the ENTER key.

F1	VELOCITY XXXXXX
F2	TEMPERATURE FACTOR XX.X
F3	CONTINUE

4. Press F3 (CONTINUE).

Changing the load factor

Use this menu to enter load factor and load offset prior to storing the sonic stress factor, approximate length, velocity, and temperature factor in the Bolt Group Data memory.

Note: Load factor and offset are not necessary for measuring elongation. If calculation of load is not required, both the load factor and load offset may be left at the default value of zero.

The load factor is an empirically determined value for the geometry of the bolt. It is the amount of load required to elongate the bolt 0.001 inch in English Units or 0.001mm in Metric Units. The accurate load factor for the bolts being measured is determined by the Calibrate Bolt function.

An approximate value of this geometry dependent factor can be calculated as follows:

$$\text{LoadFactor} = \frac{A_s E}{(L_g + D)} \times 10^{-3}$$

Where: A_s = Cross Sectional Area of the Bolt
 E = Modulus of Elasticity of Bolt Material
 L_g = Grip Length of the Bolt
 D = Diameter of the Bolt

If no load factor has been entered, the MAX defaults to a value of zero.

F1	LOAD FACTOR XXXX
F2	LOAD OFFSET XX.XX
F3	STORE GROUP

1. Press F1 (LOAD FACTOR) to enter a load factor calculated by the equation above or previously determined by the Bolt Calibration function.

F1	ENTER LOAD FACTOR XXXXX
F2	
F3	PRESS ENTER KEY

2. Use the number keys to enter the load factor.
3. Press the ENTER key.

Changing the load offset

The load offset is an empirically determined value for the geometry of the bolt and compensates for the erroneous load reading which may occur at zero elongation measurement. The theoretical value is zero. Compression of the bolted connection or uneven loading of the bolt cross-section can cause some errors. The load offset is determined by the Calibrate Bolt function for the bolts being measured.

If no load offset has been entered, the MAX defaults to a value of zero.

F1	LOAD FACTOR XXXX
F2	LOAD OFFSET XX.XX
F3	STORE GROUP

1. Press F2 (LOAD OFFSET) to enter the value of a previously determined load offset.

F1	ENTER LOAD OFFSET
F2	XXXX
F3	PRESS ENTER KEY

- Use the number keys to enter the load offset.
- Press the ENTER key.

F1	LOAD FACTOR XXXX
F2	LOAD OFFSET XX.XX
F3	STORE GROUP

- Press F3 (STORE GROUP) to complete the creation of the Bolt Group and to store the data in the MAX memory.

DO NOT PRESS THE END KEY BEFORE PRESSING F3 (STORE GROUP), OR THE MAX WILL NOT CREATE THE BOLT GROUP AND ALL INPUT DATA WILL BE LOST.

Calculating the bolt load factor

This function allows the operator to calculate the load factor for any bolt group in memory if known loads have been entered for at least two measurements of elongation on a bolt within the selected bolt group. See page 47, Measuring elongation and load, for more detailed discussion.

F1	SETUP
F2	BOLT GROUP DATA
F3	MEASURE
	Software rel.X.X

- Press F2 (BOLT GROUP DATA) to go to bolt group options menu.

F1	DELETE BOLT GROUP
F2	CREATE / CHANGE GROUPS
F3	CALIBRATE BOLT LOAD

2. Press F3 (CALIBRATE BOLT LOAD).

F1	ENTER NUMERIC NAME OF BOLT GROUP
F2	XXXXXXXXXX
F3	PRESS TO SCROLL LIST

- Use the number keys to enter the name.
- Or press F3 (PRESS TO SCROLL LIST) to scroll through the bolt groups in memory.

3. Press the ENTER key when the desired bolt group is displayed.

The MAX will calculate and display the correct load factor and load offset for the selected Bolt Group based on the known loads entered to correspond to elongation measurements.

F1	LOAD FACTOR XXXX
F2	LOAD OFFSET XXXX
F3	STORE GROUP

4. Press F3 (STORE GROUP) to store calculated values of load factor and load offset for the selected Bolt Group and return to the main menu.

MEASURE function

Use the MEASURE functions to perform the actual measurement of bolts.

F1	SETUP
F2	BOLT GROUP DATA
F3	MEASURE
	Software rel.X.X

Press F3 (MEASURE) on the Main menu to enter the MEASURE menu.

Entering bolt temperature

The MAX displays the last temperature entered.

F1	TEMPERATURE XX.X
F2	BOLT GROUP XXXXXXXX
F3	CONTINUE

1. Press F1 (TEMPERATURE) to enter the bolt temperature

Note: The temperature entered here combined with the temperature factor entered in Bolt Group Data are used to normalize the calculation of length and elongation values to 68°F (20°C).

F1	TEMPERATURE
F2	XXX.XX
F3	PRESS ENTER KEY

2. Use the number keys to enter the value.

3. Press the ENTER key to store the data.

Selecting the Bolt Group to measure

F1	TEMPERATURE XX.X
F2	BOLT GROUP XXXXXXXX
F3	CONTINUE

1. Press F2 (BOLT GROUP) to access a different bolt group.

NOTE: The Bolt Group must have been previously placed in memory using the Create Bolt Group function. See page 32.

F1	ENTER NAME OF BOLT GROUP
F2	XXXXXXXX
F3	PRESS TO SCROLL LIST

- Use the alphanumeric keys to enter the bolt group name.
- Or press F3 (PRESS TO SCROLL LIST) to scroll the list of bolt groups in memory.

2. Press the ENTER key when the desired Bolt Group is displayed.

F1	TEMPERATURE XX.X
F2	BOLT GROUP XXXXXXXX
F3	CONTINUE

3. Press F3 (CONTINUE).

Deleting bolt data from the active Bolt Group

F1	DELETE BOLT DATA
F2	VIEW / CHANGE DATA
F3	MEASURE BOLT

1. Press F1 (DELETE BOLT DATA) to delete data for bolts in the active Bolt Group.
The Bolt Group will remain in memory.

F1	CLEAR BOLTS IN GROUP XXX
F2	CLEAR ONE BOLT
F3	

2. Press F1 (CLEAR BOLTS IN GROUP) to clear the data for all the bolts in the active Bolt Group.

F1	CLEAR BOLTS IN GROUP XXX
F2	NO
F3	YES

3. Press F2 (NO) or F3 (YES) to cancel or confirm deletion of bolt data in the Bolt Group shown.

F1	CLEAR BOLTS IN GROUP XXX
F2	CLEAR ONE BOLT
F3	

4. Press F2 (CLEAR ONE BOLT) to delete data for a single bolt in the active Bolt Group.

F1	ENTER BOLT NUMBER TO CLEAR
F2	XXX
F3	PRESS TO SCROLL LIST

- Use the number keys to enter the number of the bolt group to be cleared.
 - Or press F3 (PRESS TO SCROLL LIST) to scroll through the list of bolt numbers in the active group.
5. Press the ENTER key when the correct bolt number is displayed.

F1	CLEAR ONE BOLT XX
F2	NO
F3	YES

6. Press F2 (NO) or press F3 (YES) to cancel or confirm deletion of data for the bolt group selected.
7. Press the BACK key to return to the Measure menu.

Measuring a bolt in the active Bolt Group

F1	DELETE BOLT DATA
F2	VIEW / CHANGE DATA
F3	MEASURE BOLT

1. Press F3 (MEASURE BOLT) to begin actual measurement of bolts in the active Bolt Group.

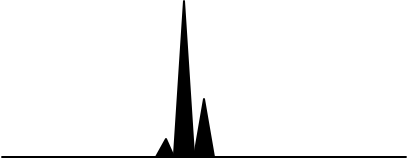
F1	ENTER NUMBER OF BOLT
F2	XXX
F3	PRESS TO SCROLL LIST

- Use the number keys to enter the number of the bolt to be measured.
- Or press F3 (PRESS TO SCROLL LIST) to scroll through bolt numbers in the active group.

2. Press the ENTER key when the correct bolt number is displayed.

3. Couple the transducer to the end of the bolt to be measured.

With automatic trigger OFF, the MAX mode displays a graphic image of the echo received from the end of the bolt:

F1	PRESS ENTER KEY
F2	
F3	XXXXX GN:XXX XXXXX

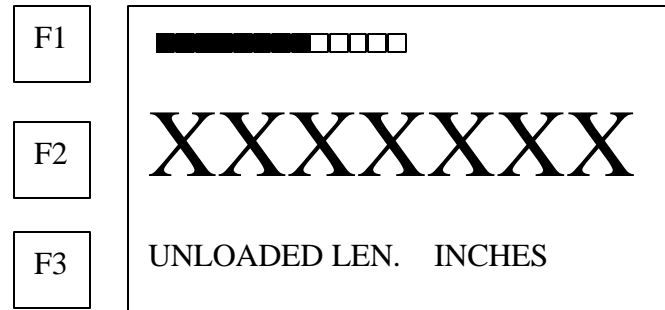
4. Adjust the position of the transducer on the bolt end to minimize the gain value displayed, and obtain, as closely as possible, a single spike of maximum height.

NOTE: If the automatic trigger mode is ON, the MAX will skip the above display and proceed directly to measurement of unloaded length.

5. Press the ENTER key.

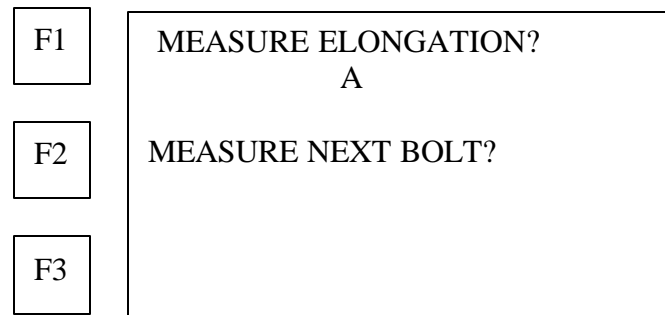
MAX displays the ultrasonic length measurement:

NOTE: The function keys (F1, F2, F3) may be used to activate Signal Analysis. See page 62.



6. Press the ENTER key to place unloaded length measurement in memory.

The MAX allows continuous measurement of a selected bolt, or sequential measurements of all bolts in the active Bolt Group.



- Press F2 (MEASURE NEXT BOLT) for the next bolt in the active Bolt Group, then repeat steps 1 – 6.
- Or press F1 (MEASURE ELONGATION) to measure elongation or load on the currently selected bolt.

Measuring elongation and load


Note:

- If the Load Factor for the active bolt group is 0.0 (no entry), the unit will automatically begin the measurement of Elongation.
- If a Load Factor other than 0.0 has been entered for the active bolt group, the MAX will automatically begin the measurement of Load.
- If the bolt selected has an unloaded length in memory, the MAX will go directly to measurement of Elongation or Load.
- If the bolt number selected does not have an unloaded length in memory, the unit will proceed with measurement of the unloaded length.

1. Tighten bolt to point where elongation or load will be measured.


MAX displays measurement of elongation:

NOTE: The function keys (F1, F2, F3) may be used to activate Signal Analysis. See page 62.

F1	 0.XXXXX ELONGATION INCHES GO TO LOAD
F2	
F3	

2. Press F3 (GO TO LOAD) to toggle to measurement of load.

NOTE: If no Load Factor has been entered for the bolt group dashes will be displayed.

F1	 XXXXXXXXXX LOAD POUNDS GO TO ELONGATION
F2	
F3	

3. Press F3 (GO TO ELONGATION) to toggle back to measurement of elongation.

4. Press the ENTER key for the first elongation / load measurement (point A) on the selected bolt to be placed in memory.

F1	NEXT ELONGATION? B
F2	
F3	

5. Press F1 (NEXT ELONGATION) to measure elongation or load at a second point (B) on the same bolt.

6. Repeat steps 1-5.

Note: The MAX can record up to 5 measurements on an individual bolt, identified as A, B, C, D, and E, in the order of measurement made. If 5 measurements have been recorded for a given bolt, the MAX warns that the memory for this bolt is full.

F1	NEXT ELONGATION? B
F2	MEASURE NEXT BOLT?
F3	ENTER A GIVEN LOAD

7. Press F2 (MEASURE NEXT BOLT?) to measure another bolt.

Note: MAX will automatically display the next higher bolt number. However, any number may be entered using the number keys, or by scrolling the bolts in memory.

8. Repeat all steps for Measuring a bolt in the active Bolt Group, starting on page 46.

Entering a known load for calibration

F1	NEXT ELONGATION? B
F2	MEASURE NEXT BOLT?
F3	ENTER A GIVEN LOAD

1. Press F3 (ENTER A GIVEN LOAD) to enter independently measured load data to calculate the load factor and load offset for the active Bolt Group.

Note: A minimum of two known loads must be entered to calculate the load factor and load offset. Up to 5 loads for all bolts in the selected Bolt Group can be used in the calculation.

F1	GIVEN LOAD
F2	XXX.X
F3	PRESS ENTER KEY

2. Use the number keys to enter the value.

3. Press the END key when all measurements have been entered for the current group.

Viewing and changing bolt data

F1	SETUP
F2	BOLT GROUP DATA
F3	MEASURE
	Software rel. X.X

1. Press F3 (MEASURE) for the active Bolt Group menu.

F1	TEMPERATURE XX.X
F2	BOLT GROUP XXXXXXXX
F3	CONTINUE

2. Press F3 (CONTINUE) for the measurement options menu.

F1	DELETE BOLT DATA
F2	VIEW / CHANGE DATA
F3	MEASURE BOLT

3. Press F2 (VIEW / CHANGE DATA) to review data in memory or make a new measurement of a bolt in the active Bolt Group.

The MAX displays the measurement values in memory for the selected bolt and presents options to change.

Changing or viewing length

F1	CHANGE LENGTH XXX.XXXX
F2	CHANGE ELONGATION A X.XXXX
F3	CHANGE LOAD A XXXX

1. Press F1 (CHANGE LENGTH) to make a change to the measurement of the unloaded length.

F1	TEMPERATURE XX.X
F2	UNLOADED LENGTH XXX.XXXX
F3	

2. Press F1 (TEMPERATURE) to change the measurement, which will change the unloaded length measurement.

F1	TEMPERATURE
F2	XXX.XX
F3	PRESS ENTER KEY

3. Press the ENTER key to place the new value in memory.

F1	TEMPERATURE XX.X
F2	UNLOADED LENGTH XXX.XXXX
F3	

4. Press F2 (UNLOADED LENGTH) to make a new measurement of the unloaded length.


F1	TEMPERATURE
F2	XXX.XX
F3	PRESS ENTER KEY

2. Use the number keys to enter the value.

3. Press the ENTER key to recalculate elongation and place values in memory.

F1	TEMPERATURE XX.X
F2	ELONGATION X.XXXX
F3	SKIP TO POINT AFTER X

4. Press F2 (ELONGATION) to make a new measurement of the elongation

F1	
F2	0.XXXXX
F3	ELONGATION INCHES GO TO LOAD

5. Press the ENTER key to place values in memory.

Changing or viewing load

F1	CHANGE LENGTH XXX.XXXX
F2	CHANGE ELONGATION A X.XXXX
F3	CHANGE LOAD A XXXX

1. Press F3 (CHANGE LOAD) to change or make a new measurement of load on the selected bolt, or to change the value of the known load.


F1	MEASURED LOAD XXXXX
F2	GIVEN LOAD XXXXX
F3	SKIP TO POINT AFTER X

2. Press F3 (SKIP TO POINT AFTER) to scroll through the load measurements in memory for the selected bolt, or to select the measurement point to be changed.

NOTE: The measurement point shown under the SKIP TO POINT AFTER prompt is the current measurement point, and corresponds to the MEASURED LOAD shown. Pressing skip moves to the next point.

F1	MEASURED LOAD XXXXX
F2	GIVEN LOAD XXXXX
F3	SKIP TO POINT AFTER X

3. Press F1 (MEASURED LOAD) to make a new measurement for the selected load. MAX displays the new measurement values:

F1	
F2	XXXXXXXXXX
F3	LOAD POUNDS GO TO ELONGATION

4. Press the ENTER key to place the new load in memory.

F1	MEASURED LOAD XXXXX
F2	GIVEN LOAD XXXXX
F3	SKIP TO POINT AFTER X

5. Press F2 (GIVEN LOAD) to change the known load which corresponds to the elongation measurement at the selected point.

Note: this value is used to calculate load factor and load offset.

F1	GIVEN LOAD
F2	XXX.X
F3	PRESS ENTER KEY

6. Use the number keys to enter the value.
7. Press the ENTER key to place values in memory.

Reporting and transferring data

Sending reports to a PC or printer

Unless changed or deleted, the data entered is preserved in the MAX memory indefinitely. Backup copies should be made frequently by transferring data to a PC, as discussed later in this section.

Note: A report can be sent at any time during operation, except when the MAX is actually measuring of length, elongation, or load.

A MAX report includes calibration data, comments, unloaded reference data, and all elongation and load measurements. A sample report is shown in Appendix G.

1. Connect any compatible PC or printer to the MAX through the RS232 port (9 pin "D" connector), using the interface cable provided with the MAX.
2. Press the SEND key to access the report options menu.

Reporting all groups

F1	REPORT SINGLE GROUP
F2	REPORT ALL GROUPS
F3	TRANSFER DATA

1. Press F2 (Report ALL GROUPS) to transmit a report for All Bolt Groups in the MAX memory.
2. Press the BACK key to abort report output

Note: Reports of all bolt groups in memory are transmitted automatically.
If the memory contains numerous bolts, transmission of the report may require several minutes.

Reporting single group

F1	REPORT SINGLE GROUP
F2	REPORT ALL GROUPS
F3	TRANSFER DATA

1. Or press F1 (REPORT SINGLE GROUP) to transmit a report for any single Bolt Group in the MAX memory.

F1	ENTER NAME OF GROUP TO REPORT
F2	XXX
F3	PRESS TO SCROLL LIST

2. Use the alphanumeric keys to enter the name of the single group.
3. Or press F3 to scroll through bolt groups in memory.
4. Press the ENTER key to transmit the report.

Transferring data between MAX units

The MAX can exchange data for any bolt group in memory between MAX units, using internal software.

1. Connect the two MAX units together through the RS232 ports (9 pin "D" connector).

NOTE: This will require the use of a non-standard null modem cable, which is available from DAKOTA ULTRASONICS.

2. Press the SEND key to access the report options menu.

F1	REPORT SINGLE GROUP
F2	REPORT ALL GROUPS
F3	TRANSFER DATA

3. Press F3 (TRANSFER DATA) to begin the transfer of data for any bolt group in memory to or from the MAX.
4. Press F2 (RESTORE GROUP) on the receiving MAX to enable it to receive the data. Receiving MAX notifies the operator that it is waiting for group data:

F1	WAITING FOR GROUP TO BE SENT
F2	
F3	

F1	BACKUP GROUP
F2	RESTORE GROUP
F3	

5. Press F1 (BACKUP GROUP) on the sending MAX to transmit bolt group data to the receiving MAX.

F1	ENTER NAME OF BOLT GROUP
F2	XXXXXX
F3	PRESS TO SCROLL LIST

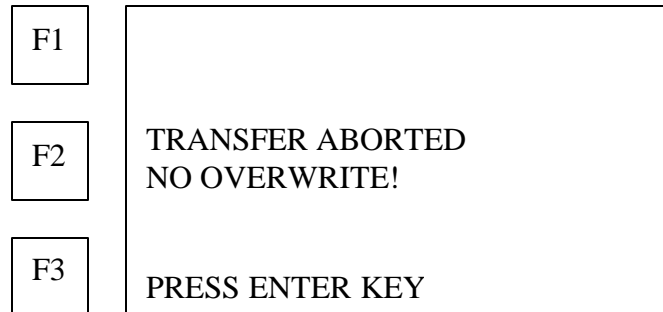
- Use the alphanumeric keys to enter the name of the bolt group to be transmitted.
 - Or press F3 (PRESS TO SCROLL LIST) to scroll the list of bolt groups in memory.
6. Press the ENTER key when the desired bolt group is displayed.
The MAX requests the operator to wait while data for the selected bolt group is transmitted:

F1	
F2	PLEASE WAIT SENDING DATA
F3	

The MAX will display the bolt numbers as the data is transmitted.
When data transfer is complete the MAX returns to the BACKUP / RESTORE menu:

F1	BACKUP GROUP
F2	RESTORE GROUP
F3	

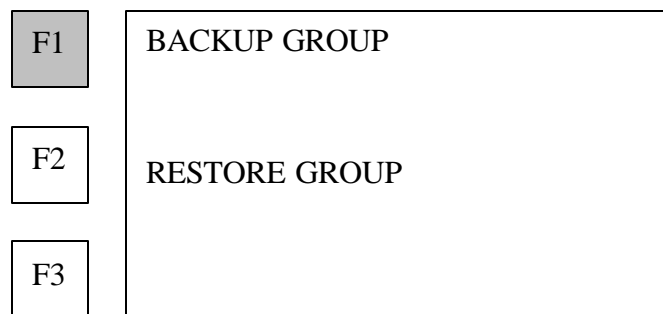
NOTE: Data for a bolt group, which already exists in the memory of the receiving MAX cannot be overwritten. When data transmission begins, the MAX checks to see if the bolt group name being received is already in memory. The MAX will refuse to accept the data and will alert the operator with the following display:



- To replace the existing data with the data being sent under the same bolt group name, the bolt group must be deleted as discussed under Deleting bolt data from the active Bolt Group, page 30, and then repeat the RESTORE GROUP function.
- If sufficient memory space is not available in the MAX to receive the bolt group data being transmitted, the unit displays **INSUFFICIENT MEMORY**. To create the required memory space, it is necessary to repack the MAX memory or clear the memory by using the **DELETE ALL GROUPS** function. Existing data should be sent to backup prior to this procedure.

Transferring data from the MAX to a PC

1. Connect the MAX RS-232 port (9 pin “D” connector) to the serial port on the PC using the standard serial interface cable provided with the MAX
2. Install Dakota Ultrasonics “backres” utility software on the PC by downloading, free of charge, from www.DakotaUltrasonics-usa.com, or requesting a disk from DAKOTA ULTRASONICS-USA
3. Click the BACKUP icon of the running “backres” software on the PC to enable it to receive the data being sent by the MAX.



4. Press F1 (BACKUP GROUP) on the MAX to send bolt group data to the PC..

F1	ENTER NAME OF BOLT GROUP XXXXXX PRESS TO SCROLL LIST
F2	
F3	

- Use the alphanumeric keys to enter the name of the bolt group.
- Or press F3 (PRESS TO SCROLL LIST) to scroll the list of bolt groups in memory.

5. Press the ENTER key when the desired bolt group is displayed.

The MAX requests the operator to wait while data for the selected bolt group is transmitted:

F1	PLEASE WAIT SENDING DATA
F2	
F3	

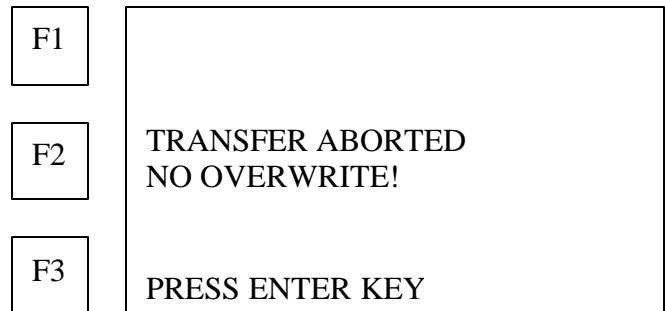
Transferring data from a PC to the MAX

Connect the MAX and the PC with “backres” software as described above.

F1	BACKUP GROUP RESTORE GROUP
F2	
F3	

6. Press F2 (RESTORE GROUP) on the MAX to receive bolt group data from a PC running “backres” software.
7. Click the RESTORE icon on the PC “backres” software to send data from the PC to the MAX.
8. The PC displays the “Group Name to Restore” window with the names of the bolt groups on the PC hard disk.

9. Click on the name of the bolt group that is to be transmitted to the MAX. The bolt group name is highlighted. Next click on the OPEN button. Data transmission will begin. Both the PC and the MAX will display the bolt numbers as the data is transmitted. When data transfer is complete the PC will return to the “backres” control screen, and the MAX will return to the BACKUP / RESTORE menu.
- Data for a bolt group, which already exists in the memory of the receiving MAX cannot be overwritten. When data transmission begins, the MAX checks to see if the bolt group name being received is already in memory. The MAX will refuse to accept the data and will alert the operator with the following display:



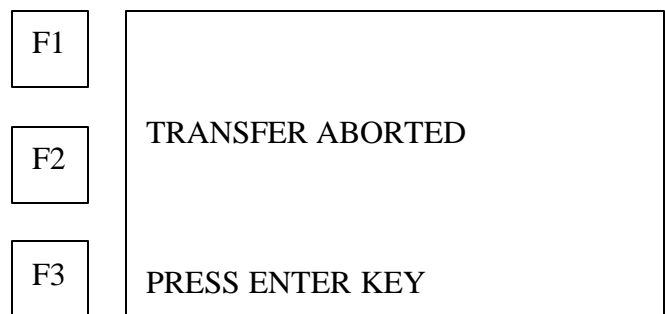
- To replace the existing data with the data being sent under the same bolt group name, the bolt group must be deleted as discussed under Deleting Bolt Data from the active Bolt Group, page 44, and then repeat the RESTORE GROUP function.
- If sufficient memory space is not available in the MAX to receive the bolt group data being transmitted, the unit displays INSUFFICIENT MEMORY. To create the required memory space, it is necessary to repack the MAX memory or clear the memory by using the DELETE ALL GROUPS function. Existing data should be sent to backup prior to this procedure.

10. Press the ENTER key to return to the BACKUP / RESTORE menu.

Canceling data transmission

1. Press the BACK key or the END key to cancel data transmission.

MAX will display that transfer has been aborted:

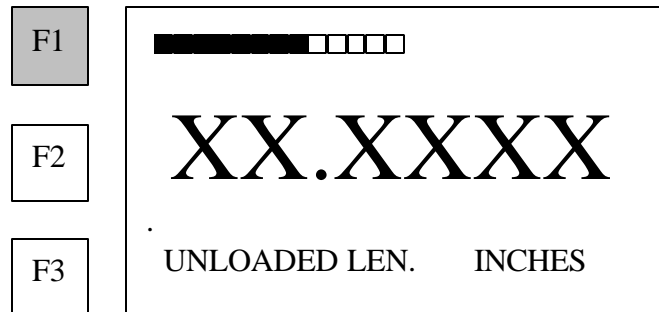


2. Press the ENTER key to return to the BACKUP / RESTORE menu.

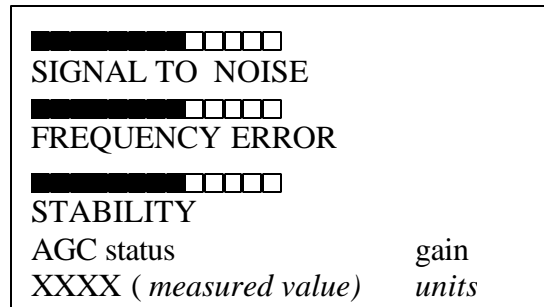
Signal Analysis

The Dakota Ultrasonics MAX offers advanced signal digitization and analysis. In all but the most difficult applications, the MAX is able to select the best signal available and display a graphic representation of the composite signal quality. When the MAX is in measurement mode, (unloaded length, elongation, load), a bar graph appears at the top of the display, which darkens from left to right as signal quality improves. A completely darkened bar indicates the best possible signal quality. To increase operator control, the MAX also provides graphic representations of each signal characteristic used for the composite analysis.

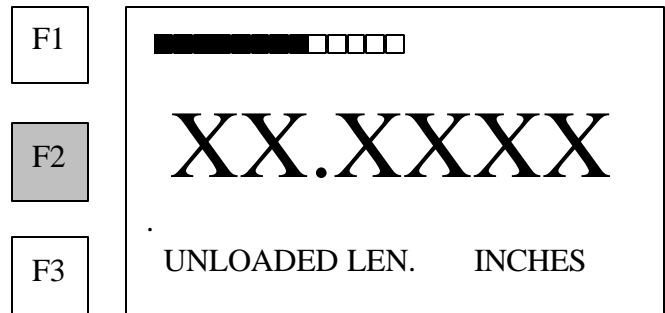
When measuring unloaded length



1. Press F1 for a bar graph presentation of signal components.

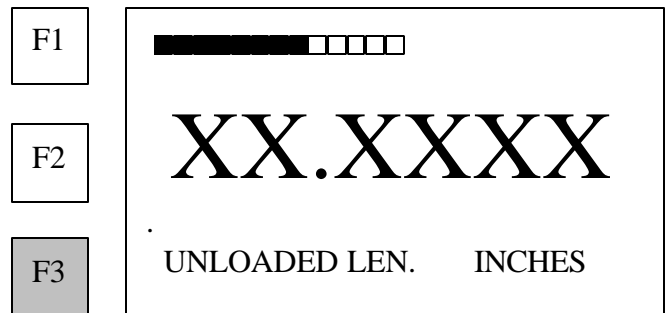
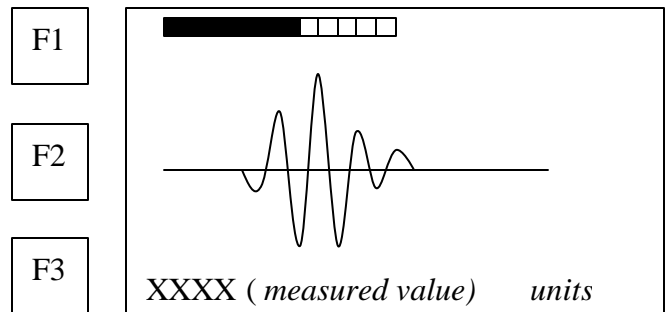


- SIGNAL TO NOISE represents the ratio of signal amplitude to background noise.
- FREQUENCY ERROR represents the ratio of signal frequency to that of the transducer.
- STABILITY represents the stability or consistency of the signal.
- AGC displays whether the automatic gain control is ON or OFF and the present Gain value. AGC is normally ON during measurement of unloaded length.
- The measured value (length, elongation or load) and units appear at the bottom.



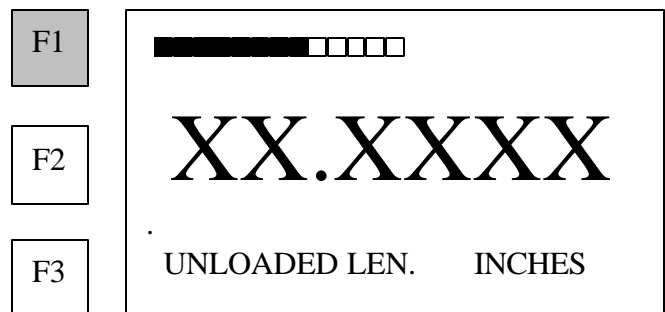
2. Press F2 to view the shape and relative amplitude of the echo, as shown below.

NOTE: Press F2 to cycle the horizontal scale of the waveform display through four values.

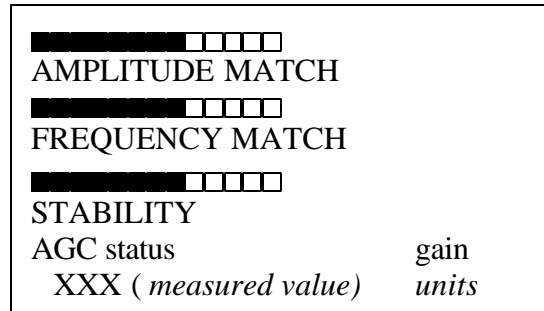


3. Press F3 to return to length measurement.

When measuring elongation and load

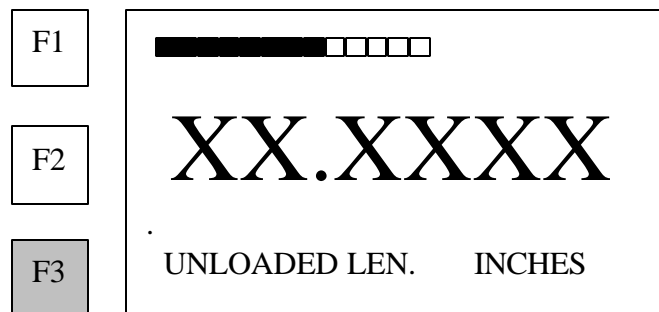
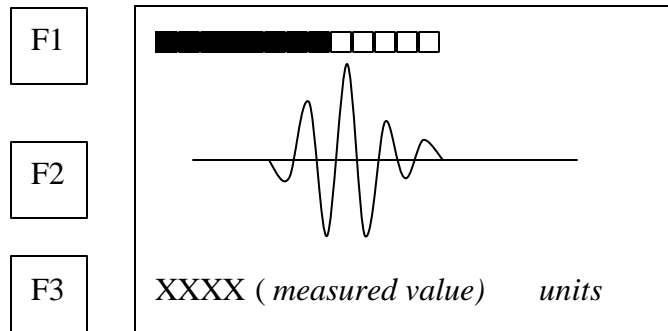


1. Press F1 for a graphic comparison of the present signal to the signal used for unloaded length measurement.



- AMPLITUDE MATCH compares the signal amplitude being used to measure Elongation or Load to the signal amplitude used to measure Unloaded Length.
- FREQUENCY ERROR compares the signal frequency being used to measure Elongation or Load to the signal frequency used to measure Unloaded Length.
- STABILITY represents the stability or consistency of the signal.
- AGC: displays whether the automatic gain control is ON or OFF and the presents Gain value.
AGC is normally OFF during measurement of elongation or load.
- Length (*measured value*) and *units* appear at the bottom.

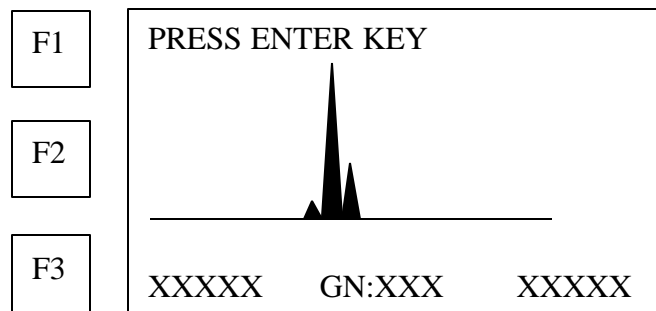
2. Press F2 to view the shape and relative amplitude of the echo.



4. Press F3 to return to elongation or load measurement.

Rectified signal display

The display of the rectified signal which occur when the MAX is placed in an active measurement mode (when automatic triggering is off) Is presented to assist the operator in positioning the transducer on the bolt end.



The operator should adjust the position of the transducer on the bolt end so the gain displayed in the lower portion of the display is the minimum achievable value, and the rectified display of the echo is, as close as possible, a single spike of maximum height.

On the bottom of the display, are shown lengths that corresponding to the left and right edges of the display. These will initially be set to $\pm 5\%$ of the entered approximate length.

In the event that a clean sharp spike is not visible, it may be that the approximate length is not centered properly or there may be a flaw in the bolt causing the echo to return at a shorter length. In order to investigate, the scanning range can be modified.

To move the scanning window along the length of the bolt use the DELAY arrows between the “7” and “8” keys. The (-) arrow moves the scanning window toward the transducer, and the (+) arrow moves the window toward the reflecting end of the bolt. As the window is moved along the bolt the bolt length at which the Max begins scanning appears in the lower left of the display. The bolt length at which scanning is stopped appears in the lower right of the display.

The scanning window may be widened by using the WIDTH arrows between the “Space” and “0” key. These arrows move the point at which scanning is stopped, while holding the beginning point of the scan constant. Thus the scan window is widened or narrowed.

Note The DELAY and WIDTH arrows keys are only active in the rectified signal display mode.

Reviewing Data in Memory

Work in progress

Appendix A

Bolt calibration factors

Note: These are approximate values and should only be used when accuracy of plus minus 10% is acceptable.

MATERIAL OF BOLT	SONIC STRESS FACTOR	TEMPERATURE FACTOR		SOUND VELOCITY		MODULUS OF ELASTICITY	
		F	C	IN / SEC	MM / SEC	PSI X 10 ⁶	Mpa X 10 ³
4140 STEEL	0.274	56	101	232000	5890000	29.9	205
4340 STEEL	0.285	55	99	232000	5890000	30	207
STS STEEL	0.250	80	144	230000	5840000	29	200
INCONEL	0.296	62	111	225000	5710000	31	214
TITANIUM	0.490	64	115	245000	6220000	16.5	114
ASTM SPECIFICATIONS							
A193 B7	0.280	57	103	232000	5890000	30	207
A193 B16	0.280	57	103	232000	5890000	30	207
A325	0.274	56	101	232000	5890000	29.9	205
A490	0.299	60	101	232000	5890000	29.9	205
A540	0.299	60	108	232000	5890000	30	207
SAE SPECIFICATIONS 1038							
Gr.2	0.275	57	103	232000	5890000	29.9	205
Gr.5	0.275	57	103	232000	5890000	29.9	205
Gr.6	0.277	60	108	232000	5890000	29.9	205
Gr.8	0.274	57	103	232000	5890000	29.9	205
Gr.9	0.275	58	104	232000	5890000	29.9	205
ISO SPECIFICATIONS R898							
Gr.9.8	0.276	58	105	232000	5890000	29.9	205
Gr.10.9	0.274	57	103	232000	5890000	29.9	205
Gr.12.9	0.274	57	108	232000	5890000	29.9	205

Appendix B

Determining sonic stress factor by measuring length

Following are steps for determining the Sonic Stress Factor for bolts of a specific bolt material and specific geometry by measurement of the actual change in bolt length.

Required Equipment:

- A laboratory or room in which the temperature can be maintained at between 66° to 70° F.
- A means of applying load to the bolt. Ideally this would be a tensile load machine, capable of measuring the applied load to within 100 lbs. However, since the actual value of the applied load is not used in calculating the stress factor, any means of applying an approximate load to the bolt will suffice. This includes tightening the bolt against a fixture that simulates the actual joint. A mechanical means of traceable measurement of the physical length of the sample fasteners at various tensile loads to an accuracy of plus or minus 0.0001 inch. Examples of such devices include the following
 - Length measurement function of sophisticated tensile test machine
 - Mechanical or electronic height gages
 - Averaged values of length measurement with mechanical and electric micrometers.
- A Dakota Ultrasonics MAX Ultrasonic Stress Meter.
- A minimum of three sample bolts which are representative of the bolt type and geometry for which the Sonic Stress Factor is to be determined.

NOTES:

- The Dakota Ultrasonics MAX must be calibrated, or zeroed, as described in the procedure entitled System Zeroing in the Setup section of the MAX Operation.
- The sample bolts must be left to soak in the controlled temperature environment for a period of not less than 24 hours. Care must be taken through out the measurement process to avoid significant change in the bolt temperature due to handling of the sample bolts, or the process of applying load.
- The mechanical apparatus for measurement of length must be calibrated in accord with governing QA procedures. The device should be configured so that minimum handling of the sample bolts will be required during the measurement process.

Determination of the Sonic Stress Factor is accomplish by solving the equation:

$$SonicStressFactor = \frac{\Delta L_{MECHANICAL}}{\Delta L_{ULTRASONIC}} = \frac{L_M - L_{M0}}{L_{U1} - L_{U0}}$$

Where:

L_M = MechanicalLength@ Load

L_{U0} = UltrasonicLength@ ZeroLoad

L_{M0} = MechanicalLength@ ZeroLoad

L_{U1} = UltrasonicLength@ Load

Acquire data as follows:

1. Using the mechanical measuring device, measure and record the Mechanical Length at Zero Load “ L_{M0} ” for each sample bolt.
2. Using the MAX in the Unloaded length measurement mode, measure and record the Ultrasonic Length at Zero Load “ L_{U0} ” for each sample bolt. NOTE: Ultrasonic measurements will be more easily accomplished, and more accurate, if the transducer remains undisturbed on the bolt through out the loading process.
3. Place the first sample bolt in the loading apparatus.
4. Apply approximately 1/3 of the maximum load, which is to be placed on the bolt under actual working conditions.
5. Using the mechanical measuring device, measure and record the Mechanical Length at Load 1 “ L_{M1} ” for the current sample bolt.
6. Using the MAX in the Unloaded length measurement mode, measure and record the Ultrasonic Length at Load 1 “ L_{U1} ” for the current sample bolt.
7. Increase the applied load to approximately 2/3 of the maximum load, which is to be placed on the bolt under actual working conditions.
8. Using the mechanical measuring device, measure and record the Mechanical Length at Load 2 “ L_{M2} ” for the current sample bolt.
9. Using the MAX in the Unloaded length measurement mode, measure and record the Ultrasonic Length at Load 2 “ L_{U2} ” for the current sample bolt.
10. Increase the applied load to approximately the maximum load, which is to be placed on the bolt under actual working conditions.
11. Using the mechanical measuring device, measure and record the Mechanical Length at Load 3 “ L_{M3} ” for the current sample bolt.
12. Using the MAX in the Unloaded length measurement mode, measure and record the Ultrasonic Length at Load 3 “ L_{U3} ” for the current sample bolt.
13. Repeat steps 4 through 12 for the second and third sample bolt.
14. Calculate the value of the Sonic Stress Factor at each load on each sample bolt.

$$SSF_{B1L1} = \frac{L_{M1} - L_{M0}}{L_{U1} - L_{U0}} \quad SSF_{B1L2} = \frac{L_{M2} - L_{M0}}{L_{U2} - L_{U0}} \quad SSF_{B1L3} = \frac{L_{M3} - L_{M0}}{L_{U3} - L_{U0}}$$

AND SO ON FOR EACH SAMPLE BOLT

15. Determine the average value of the Sonic Stress Factor by dividing the sum of all SSF values calculated by the total number of SSF values

The above data collection and calculations can be performed easily by use of an **MS Excel** spreadsheet. For the convenience of our customers, a preprogrammed spreadsheet is available for download from our web site at www.DakotaUltrasonics-usa.com, or on disk by contacting Dakota Ultrasonics at 2701 Research Park Drive, Soquel, CA 95073, Tel. (831) 464-7155.

Estimating the Sonic Stress Factor by measuring load

The following describes a procedure by which the Sonic Stress Factor can be calculated by measurement of the applied load.

It must be noted that this procedure is inherently less accurate than the measurement of actual change in bolt length, as described in Appendix B Part 1. The inaccuracy result from the calculation of theoretical change in bolt length under applied load. This calculation, which is the expression of Hooke's Law, requires assumptions as to the effective, or working length, and the stressed cross-sectional area of the bolt, as well as the Modulus of Elasticity of the bolt material. Therefore the final calculation of the Stress factor will be only as accurate as those assumptions.

It is therefore recommended be used only where apparatus for measurement of length is not available, and where bolt geometry allows reasonably accurate estimation of effective length and cross-sectional area.

As discussed in Part 1 the equation for the Sonic Stress Factor is:

$$\text{SonicStressFactor} = \frac{\Delta L_{\text{MECHANICAL}}}{\Delta L_{\text{ULTRASONIC}}} = \frac{\Delta L_{\text{MECHANICAL}}}{L_{U1} - L_{U0}}$$

In this procedure we will be measuring the change in Ultrasonic Length in the same manner as in Part 1. However, we will be calculating the change in Mechanical Length (Elongation) by use of Hooke's Law:

$$\Delta L = \frac{PL}{AE}$$

Where:

$$\Delta L = \Delta L_{\text{MECHANICAL}} = \text{Elongation}$$

P = Applied Load

L = Effective Length (Normally the clamping length + one diameter)

A = Cross-sectional Area of the Stressed Portion of the Bolt

E = Modulus of Elasticity of the Bolt Material (Young's Modulus)

Estimate the value of L, A, as accurately as possible given the bolt geometry. The value of E is published for virtually all materials. The values for common bolt materials a presented in Appendix A.

Acquire data as follows:

1. Using the MAX in the Unloaded length measurement mode, measure and record the Ultrasonic Length at Zero Load "L_{U0}" for each sample bolt.
NOTE: Ultrasonic measurements will be more easily accomplished, and more accurate, if the transducer remains undisturbed on the bolt through out the loading process.
2. Place the first sample bolt in the loading apparatus.
3. Apply approximately and record 1/3 of the maximum load, which is to be placed on the bolt under actual working conditions. "P₁"

4. Using the MAX in the Unloaded length measurement mode, measure and record the Ultrasonic Length at Load 1 “L_{U1}” for the current sample bolt.
5. Increase and record the applied load to approximately 2/3 of the maximum load, which is to be placed on the bolt under actual working conditions.”P₂”
6. Using the MAX in the Unloaded length measurement mode, measure and record the Ultrasonic Length at Load 2 “L_{U2}” for the current sample bolt.
7. Increase and record the applied load to approximately the maximum load, which is to be placed on the bolt under actual working conditions. “P₃”
8. Using the MAX in the Unloaded length measurement mode, measure and record the Ultrasonic Length at Load 3 “L_{U3}” for the current sample bolt.
9. Repeat steps 4 through 12 for the second and third sample bolt.
10. Calculate the value of the Sonic Stress Factor at each load on each sample bolt.

$$SSF_{B1L1} = \frac{P_1 L}{(L_{U1} - L_{U0}) AE} \quad SSF_{B1L2} = \frac{P_2 L}{(L_{U2} - L_{U0}) AE} \quad SSF_{B1L3} = \frac{P_3 L}{(L_{U3} - L_{U0}) AE}$$

AND SO ON FOR EACH SAMPLE BOLT

11. Determine the average value of the Sonic Stress Factor by dividing the sum of all SSF values calculated by the total number of SSF values

$$SSF_{AVERAGE} = \frac{SSF_{B1L1} + SSF_{B1L2} + SSF_{B1L3} \Lambda + SSF_{B3L3}}{9}$$

The above data collection and calculations can be performed easily by use of an **MS Excel** spreadsheet. For the convenience of our customers, a preprogrammed spreadsheet is available for download from our web site at www.DakotaUltrasonics-usa.com, or on disk by contacting Dakota Ultrasonics USA.

Estimating the Load Factor

The following section describes the method by which one can estimate or calculate the theoretical Load Factor for a specific fastener configuration.

It should be noted that this estimation is inherently less accurate than calibration of the actual Load Factor by using actual known loads which correspond to measured elongation as described in this manual under “Calculating the Bolt Load Factor”.

However, where independent measurement of known loads can not be made, a close estimate of the load factor can be achieved using the following procedure.

In the USM-1 the Load Factor is defined as the tensile load required which will produce one unit of elongation in the bolt. When operating in English units the factor is defined as the number of pounds

required per 0.001 inch of elongation (lbs/0.001in.). In metric unit systems the factor is defined as Kilonewtons or Kilograms per 0.001mm.

The relationship between load and elongation is a function of the elasticity of the bolt material, and the geometry of the bolt in the application being measured.

The relationship is expressed by Hooke's Law:

$$P = \frac{\Delta l \times AE}{L}$$

Where: $P = \text{Load}$

$\Delta l = \text{Elongation}$

$A = \text{Cross Sectional Area of the Bolt}$

The cross sectional area of the bolt is defined as the area of the bolt material, which experiences the applied tensile stress.

For a cylindrical bolt the area may be approximated as follows:

$$A = \Pi \left(\frac{D}{2} \right)^2 = \frac{3.1416D^2}{4} = 0.7854D^2$$

Where: $D = \text{the root diameter of the bolt thread}$

More precise calculation of the stressed area, which reflects the effect of thread type and pitch, can be found in a number of reference texts and data published by bolt manufacturers. John H. Bickford presents an excellent tabulation of Stress Areas in "An Introduction to the Design and Behavior of Bolted Joints".

For complex bolts, which have sections of different diameters along the loaded length, the accepted method for estimating the stressed area is to calculate a weighted average of the various areas. This is accomplished by multiplying each area by the respective length and dividing the sum by the total stressed length of the bolt. Cross sectional area is determined as discussed above.

$$A_{\text{average}} = \frac{A_1 L_1 + A_2 L_2 + A_3 L_3 + \dots + A_n L_n}{L_1 + L_2 + L_3 + \dots + L_n}$$

$E = \text{Modulus of Elasticity of the Bolt Material}$

The value of the Modulus of Elasticity, or Young's Modulus, for the bolt material should be provided by the manufacturer of the bolts being tested. A tabulation of E for common bolt materials is presented in Appendix A.

$L = \text{Stressed Length of the Bolt}$

The stressed length of the bolt is equal to the actual clamped length of the bolted connection plus that portion of the bolt within the head and nut, which experiences tensile stress. A number of theories have been proposed as to the stressed length within the head of the bolt and the within the nut. However testing by use of the calibration function of the USM 1 reveals that no single theory is valid for all bolt configurations. Thus, for the estimation of the Load Factor discussed here, it is sufficient assume that the approximate stressed length is equal to the clamp length of the joint plus the nominal bolt diameter.

$$L = L_g + D$$

The Load Factor (the load required for 0.001 elongation) is calculated by solving the above equation for Hooke's Law while setting the value of the elongation at 0.001.

$$\text{LoadFactor} = P_{0.001} = \frac{0.001AE}{L} = \frac{AE}{(L_g + D) \times 1000}$$

Appendix C

Determining the Temperature Factor

The following presents the procedure for experimental determination of the Temperature Factor for a bolt made of a specific bolt material and having specific geometry.

Required Equipment.

- A means of varying, and measuring the temperature of the sample bolts between 32° to 212° F (0° to 100° C) to an accuracy of plus or minus 2° F. The device must allow contact of the end of the sample bolt by the ultrasonic transducer of the MAX. Many sophisticated temperature chambers are commercially available, and ideally suited for this function. However, a simple and inexpensive method can be achieved by immersion of the sample bolts in a water bath, which can be heated to boiling or cooled by adding ice. At sea level this will reliably vary the bolt temperature between approximately 212°F and 32° F (100° and 0° C) depending on water purity and atmospheric pressure. By measuring the temperature of the stirred water bath with a precise mercury thermometer, while reading the ultrasonic length of the bolt, accurate calibration points can be obtained.
- A Dakota Ultrasonics MAX Ultrasonic Stress Meter
- A minimum of three sample bolts, which are representative of the bolt type and geometry for which the Temperature Factor is to be determined.

NOTES:

- The Dakota Ultrasonics MAX must be calibrated, or zeroed, as described in the procedure entitled System Zeroing in the Setup section of the MAX Operation.
- The sample bolts should be left to soak at the measured temperature points for a period of not less than 20 minutes, to insure that temperature is uniform through out the sample.
- If a water bath is used, care must be taken to avoid immersion of the ultrasonic transducer.

Determination of the Sonic Stress Factor is accomplish by solving the equation:

$$\text{TemperatureFactor} = \frac{(L_0 - L_T)}{L_T (T_0 - T)} \times 10^6$$

Where:

L_0 = Ultrasonic Length at Beginning Temperature (T_0)

L_T = Ultrasonic Length at Ending Temperature (T)

T_0 = Beginning Temperature

T = Temperature at Present Measurement Point

Acquire data as follows:

1. Stabilize the sample bolt at approximately 32⁰ F (0⁰ C). If the water bath method is used this is accomplished in a stirred bath of ice and water.
2. Measure and record this minimum temperature as T₀.
3. Using the MAX in the “Unloaded Length” measurement mode, measure the ultrasonic length “L₀” of the sample bolt at the above minimum temperature.
4. Increase the temperature of the sample bolt to approximately 68⁰ F (20⁰ C).
5. Measure and record the exact temperature at this measurement point as T₁.
6. Using the MAX in the “Unloaded Length” measurement mode, measure and record the ultrasonic length “L₁” of the sample bolt at temperature T₁.
7. Increase the temperature of the sample bolt to approximately 104⁰ F (40⁰ C).
8. Measure and record the exact temperature at this measurement point as T₂.
9. Using the MAX in the “Unloaded Length” measurement mode, measure and record the ultrasonic length “L₂” of the sample bolt at temperature T₂.
10. Increase the temperature of the sample bolt to approximately 140⁰ F (60⁰ C).
11. Measure and record the exact temperature at this measurement point as T₃.
12. Using the MAX in the “Unloaded Length” measurement mode, measure and record the ultrasonic length “L₃” of the sample bolt at temperature T₃.
13. Increase the temperature of the sample bolt to approximately 176⁰ F (80⁰ C).
14. Measure and record the exact temperature at this measurement point as T₄.
15. Using the MAX in the “Unloaded Length” measurement mode, measure and record the ultrasonic length “L₄” of the sample bolt at temperature T₄.
16. Increase the temperature of the sample bolt to approximately 212⁰ F (100⁰ C).
17. Measure and record the exact temperature at this measurement point as T₅.
18. Using the MAX in the “Unloaded Length” measurement mode, measure and record the ultrasonic length “L₅” of the sample bolt at temperature T₅.
19. Repeat steps 1 through 18 for the second and third sample bolt.
20. By solving the above equation calculate the Temperature Factor for each data point on each sample bolt.

$$TF_{B1T1} = \frac{(L_0 - L_1)}{L_1(T_0 - T_1)} \times 10^6 \quad TF_{B1T2} = \frac{(L_0 - L_2)}{L_2(T_0 - T_2)} \times 10^6$$

AND SO ON FOR EACH SAMPLE BOLT

Determine the average value of the Temperature Factor by dividing the sum of all TF values calculated by the total number of TF values

$$TF_{AVERAGE} = \frac{TF_{B1T1} + TF_{B1T2} + TF_{B1T3} \Lambda + TF_{B3T4}}{12}$$

The above data collection and calculations can be performed easily by use of an **MS Excel** spreadsheet. For the convenience of our customers, a preprogrammed spreadsheet is available for

download from our web site at www.DakotaUltrasonics-usa.com, or on disk by contacting Dakota Ultrasonics USA.

Appendix D

Messages

NO GROUPS PRESS ENTER KEY

Alerts operator that no bolt group data is stored in memory. Refer to **BOLT GROUP DATA functions** beginning on page 30.

CANNOT SCROLL! NO GROUPS PRESS ENTER KEY

Occurs after the last or only bolt group is deleted. No action is required.

CANNOT MEASURE SO CLOSE TO BANG

Appears when the bolt length is set for ½ inch (18mm) or less, or if the group velocity is set to 0.0. Verify correct length and velocity settings. Also may occur when the units have been changed in the **SETUP MAX** function. See page 25.

FLASH MEMORY ERROR UNIT NEEDS SERVICE

Appears when the flash programming cycle of the flash memory chip has been exceeded, or when the chip has been corrupted. **Return the MAX to Dakota Ultrasonics USA for service, or call the Service Department for further instructions.** Other peripheral damage may have occurred

WARNING! MEMORY MUST BE REPACKED TO MAKE ROOM FOR NEW GROUP. DO NOT TURN OFF OR INTERRUPT POWER. THIS WILL RESULT IN LOSS OF DATA. PRESS ENTER TO BEGIN

Appears when the **Delete one group** function has been used repeatedly. Because the data pages are renamed rather than cleared, they still take up memory space, just as a ream of blank paper takes up as much room as a ream of printed material. **PRESS ENTER TO BEGIN** clears the memory space, but makes all stored data vulnerable to loss or corruption from line voltage anomalies. If the MAX is operated on “dirty” power (compressors, tools using universal motors, etc.), or if the reliability of the power is questionable, press the **BACK** key to abort. Back up data files regularly to prevent this situation.

Troubleshooting

Blank screen when power is turned on.

Usually caused by AC supply failure, power supply failure, or software-related problems.

- Check the AC outlet for voltage.
- Make sure the power cord is fully inserted on the rear panel of the MAX.
- Check the fuse in the PEM for continuity. If it is blown, replace with a 2.5A 5X20 mm “F” type fuse. If the replacement fuse blows, call the Dakota Ultrasonics USA Service Department for further instructions.
- If it is not blown, press the **F1** key repeatedly and observe the screen. If the display contrast increases and becomes readable, power the unit off and back on. If the display returns, the problem may have been repeated use of the **F2** key during the **Display contrast** function during last use.
- If screen remains blank, call the Service Department for further instructions.

Blank screen every time power is turned on.

If using the **F1** and **F2** scenario above restores the display, or if any other setup parameter requires repeated reentry, the non-volatile memory IC has probably failed. **This is considered a field-serviceable condition only for qualified personnel. Call the Service Department for further instructions, or return the unit to Dakota Ultrasonics USA.**

Unable to acquire an echo.

Almost always caused by poor bolt/transducer interface.

- Check bolt end. See page 10 for required bolt surface, and replace if necessary.
- Make sure that the transducer cable is connected to the correct transducer port. Use port 2 for a single transducer.
- Try another equivalent transducer and/or cable.
- Verify that the MAXfrequency matches that of the transducer.
- Verify that the transducer and the receiver mode are appropriate for the measurement method being used.
- If all attempts are unsuccessful, call the Service Department for further instructions.

Unable to change unit system for bolt group.

- Once a bolt group has been created, its units cannot be changed using **Select unit system** in the **SETUP MAX** menu.
- A duplicate group can be made and measured using different units by first changing the units, then creating a new group. **All subsequent groups will be made using those units.**

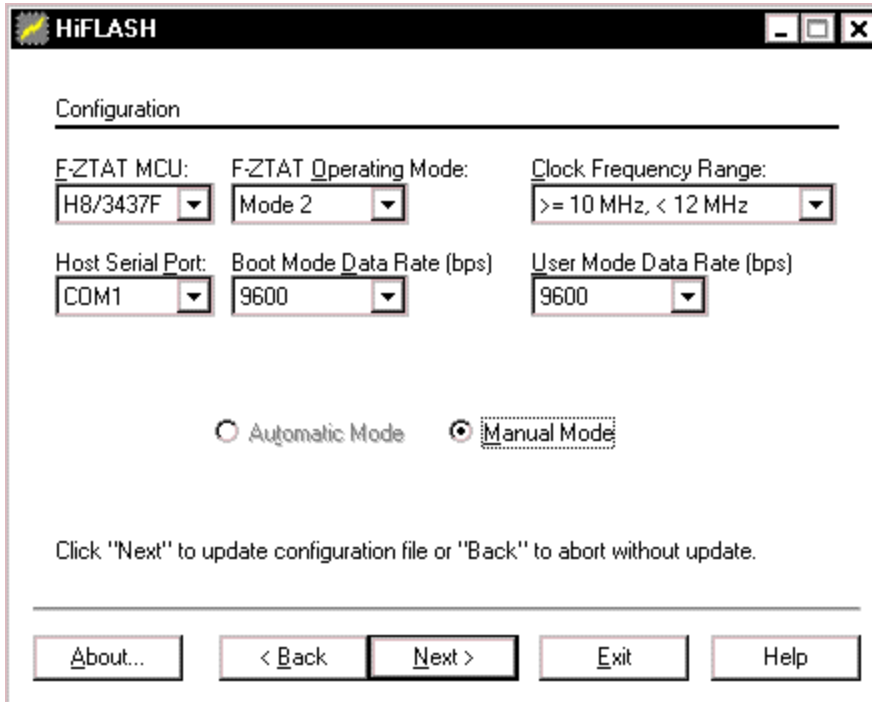
Appendix E

Reprogramming the MAX

1. Download the MAX.mot file from the website ([www.Dakota Ultrasonics-usa.com/firmware](http://www.DakotaUltrasonics-usa.com/firmware)) and save to Desktop.
2. Download the HiFLASH.exe file from the website and save to Desktop. (You may wish to create a special folder on your desktop for these files.)
3. **Verify the power is OFF on the MAX.**
4. Place Firmware Reprogramming Adapter (AVAILABLE FROM DAKOTA ULTRASONICS-USA) on the MAX Auxiliary Connector (15 pin “D” connector).
DO NOT CONNECT OR REMOVE THE REPROGRAMMING ADAPTER WHILE POWER IS ON TO THE MAX.
5. Connect an RS 232 cable from the computer to the MAX RS-232 port (9 pin “D” connector). This is accomplished with the 9-pin male to a 9-pin female, straight through wired cable that is included with the MAX. Your computer may require a 25 pin to 9 pin standard adapter.
6. Double click the HiFlash icon you created on your desktop to start the HiFlash program. The main menu of the HiFlash program should appear.
7. Click the **CONFIGURATION** radio button and then click **NEXT**. The Configuration menu should appear.
8. Set the parameters as follows:
 - F-ZTAT MCU: **H8/3437F**
 - F-ZTAT Operating Mode: **Mode 2**
 - Clock frequency Range: **>=10MHz<12MHz**
 - Boot Mode Data Rate: **9600**
 - User Mode Data Rate: **9600**

Note that the HOST SERIAL PORT may be COM1, COM2, COM3, or COM4, depending on your computer.

The completed configuration screen should look like this:



Configuration

F-ZTAT MCU: F-ZTAT Operating Mode: Clock Frequency Range:
H8/3437F Mode 2 >= 10 MHz, < 12 MHz

Host Serial Port: Boot Mode Data Rate (bps) User Mode Data Rate (bps)
COM1 9600 9600

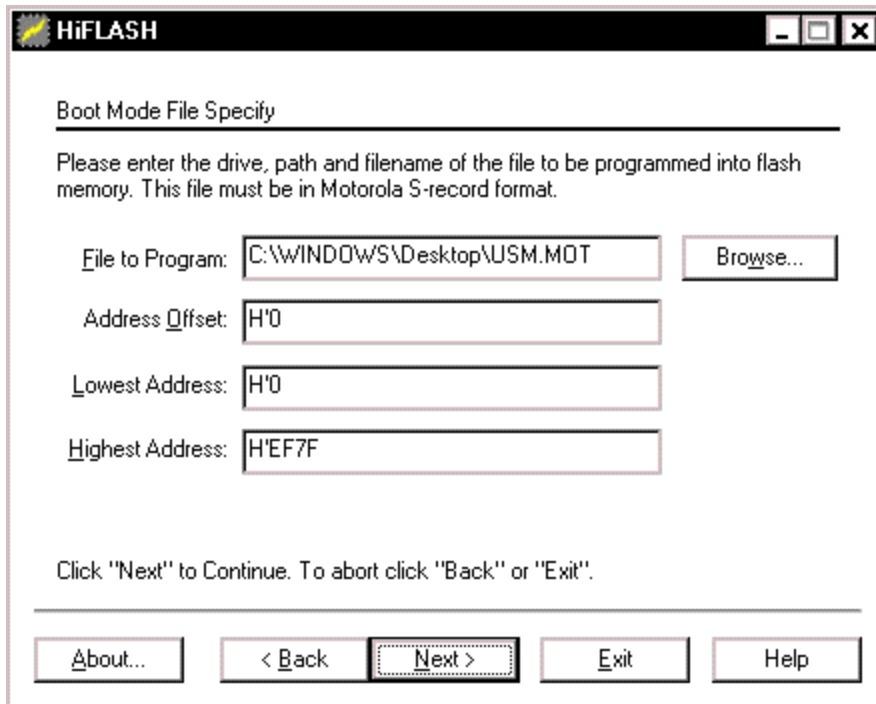
Automatic Mode Manual Mode

Click "Next" to update configuration file or "Back" to abort without update.

About... < Back Next > Exit Help

9. Click **NEXT**.
 10. Click **BOOT PROGRAMMING MODE/QUICK FLASH**
 11. Click **BROWSE**.
 12. Select **DESKTOP**.
 13. Click on **MAX.mot**.
 14. Click **OPEN**
- Do not change any of the other settings.**

The screen should now display the file name and look like this:



15. Click **NEXT**. . A message should appear in the HiFlash display “Warning, do not turn power off”
16. Turn the on to the MAX and wait one second.
17. Click **NEXT**
18. Wait while a string of black or blue squares fills the box above the **Abort** box.
If this fails to occur, check the RS 232 connection, turn the MAX off, cycle the computer to the proper screen by clicking **NEXT** three times, and retry, waiting 1.5 seconds before clicking **NEXT**.
19. Wait as a second box fillings at a much slower rate.
20. **Turn the MAX off immediately after the box is filled with squares and the HiFlash screen indicates completion of programming. Excessive power on time while the reprogramming adapter is connected may damage the MAX**
21. Allow a few seconds for the power supply to drain. then remove the Firmware Reprogramming Adaptor from the MAX Auxiliary port
22. Turn the power on to the MAX.
23. Press the **ENTER** key to go to the MAX main menu. Verify that the new software version (REL X.X) appears in the lower right corner of the display, and reprogramming is complete.

Appendix F

Units of Measure

MEASURED ITEM	ENGLISH	METRIC 1	METRIC 2
DISPLAY CONTRAST	1 TO 15	DIMENSIONLESS	
BACK LIGHT	ON / OFF	DIMENSIONLESS	
MEASUREMENT MODES	PULSE/ECHO, PITCH/CATCH		
TRANSDUCER FREQUENCY	MHz		
TONE BURST LENGTH	PULSES		
ANALOG OUTPUT	VOLTS		
UNIT SYSTEMS	POUNDS / INCHES	KILONEWTONS/MM	KILOGRAMS/MM
LENGTH	INCHES	MILLIMETERS	MILLIMETERS
ELONGATION	INCHES	MILLIMETERS	MILLIMETERS
DIAMETER	INCHES	MILLIMETERS	MILLIMETERS
LOAD	POUNDS	KILONEWTONS	KILOGRAMS
STRESS	PSI	MPA	KG / SQ. MM
STRAIN	DIMENSIONLESS		

Appendix G

Sample report

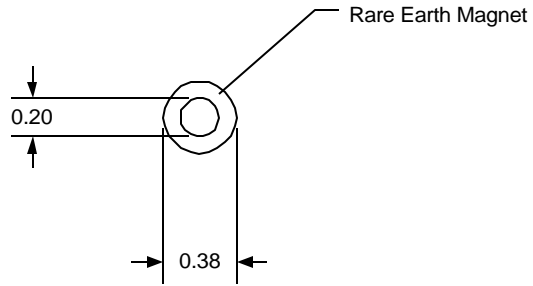
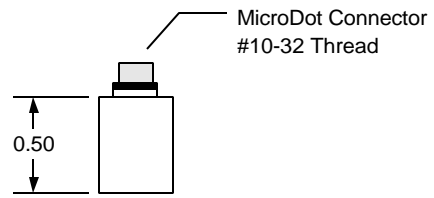
A MAX report includes calibration data, comments, unloaded reference data, and all elongation and load measurements in the following format:

GROUP	XXXXXXXX	ZERO FAC	XX		
COMMENT 1	XXX.....XXX				
COMMENT 2	XXX....XXX				
LAPPROX	STRSFAC	VELO	TEMPFAC	LFACT	LOFFSET
XXX.X	0.XXX	232000	XX.X	XXX.X	XX.X
REFERENCE DATA					
BOLT NUM	REFLEN	PHASE	GAIN	POS.THR	NEG.THR
1	XX.XXXX	2	8	22	10
2	XX.XXXX	1	9	28	12
3	-----	-----	-----	-----	-----
4	-----	-----	-----	-----	-----
5	-----	-----	-----	-----	-----
ELONGATION REPORT					
BOLT NUM	ELONG A	ELONG B	ELONG C	ELONG D	ELONG E
1	0.XXXX	0.XXXX	0.XXXX	0.XXXX	0.XXXX
2	0.XXXX	0.XXXX	0.XXXX	0.XXXX	0.XXXX
3	-----	-----	-----	-----	-----
4	-----	-----	-----	-----	-----
5	-----	-----	-----	-----	-----
LOAD REPORT					
BOLT NUM	LOAD A	LOAD B	LOAD C	LOAD D	LOAD E
1	XXXX	XXXX	XXXX	XXXX	XXXX
2	XXXX	XXXX	XXXX	XXXX	XXXX
3	-----	-----	-----	-----	-----
4	-----	-----	-----	-----	-----
5	-----	-----	-----	-----	-----

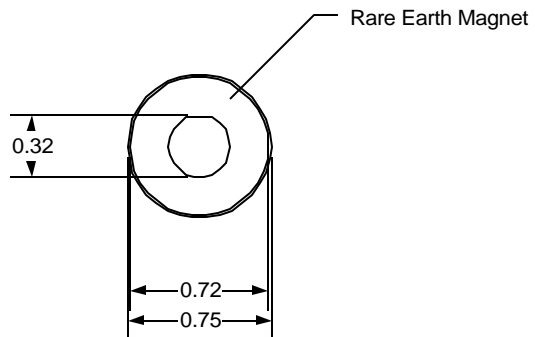
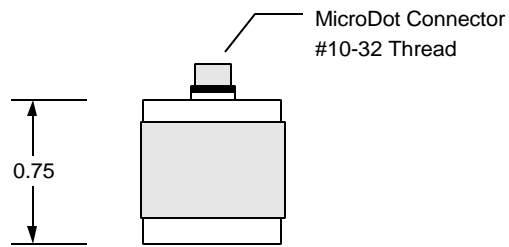
Appendix H

Standard Dakota Ultrasonics Ultrasonic Transducers

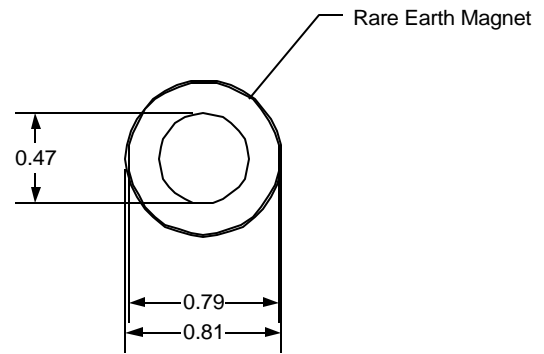
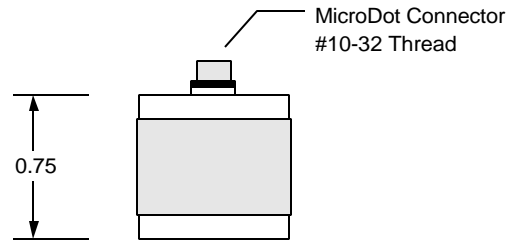
Ordering Information	
19001	1/8 in 10 MHz
19002	1/8 in 5 MHz



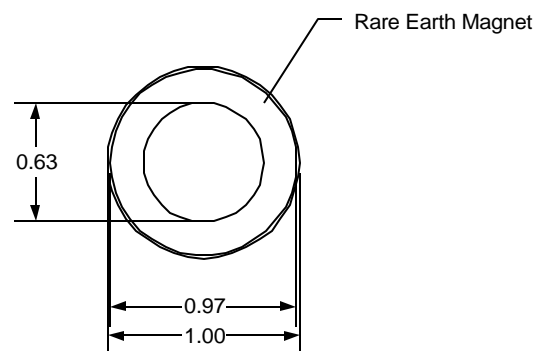
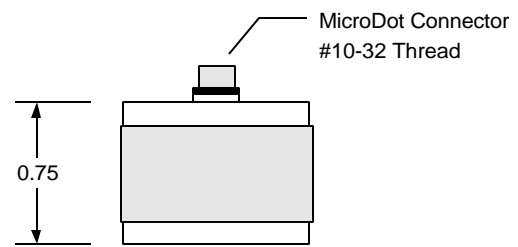
Ordering Information	
19003	1/4 in 10 MHz
19004	1/4 in 5 MHz



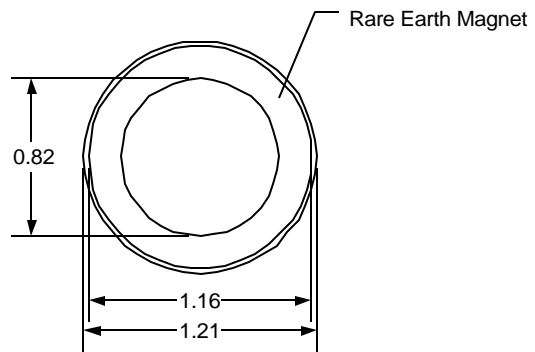
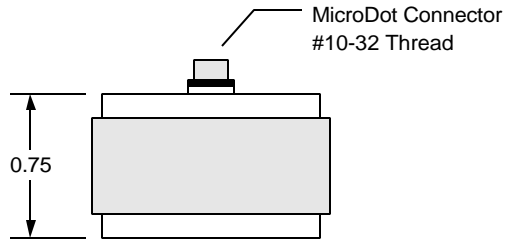
Ordering Information	
19005	3/8 in 5 MHz
19006	3/8 in 2.25 MHz



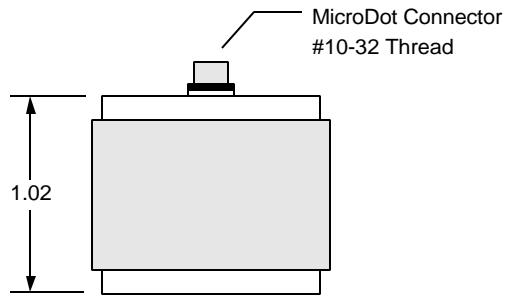
Ordering Information	
19007	1/2 in 5 MHz
19008	1/2 in 2.25 MHz
19009	1/2 in 1.0 MHz



Ordering Information	
19010	3/4 in 5 MHz
19011	3/4 in 2.25 MHz



Ordering Information	
19012	3/4 in 1.0 MHz



Index for MAX-II

- accuracy, 5, 66, 67
- adjusting, 7, 9
- AGC, 62, 64, 74
- air gap, 8
- alignment, 10, 11
- amplitude, 62, 63, 64
- analog, 7, 25, 26, 27
- backlight, 14
- bending, 7, 11
- bnc, 7
- cable, 1, 8, 55, 57, 59, 74
- calibrate, 8, 26, 38, 39, 41
- compensation, 8
- connector, 4, 7, 24
- consistency, 62, 64
- constant, 8
- contrast, 14, 74
- couplant, 19
- crystal, 6
- delay, 8, 21, 73
- diagnostics, 5
- diameter, 6, 9, 15, 38, 69
- display, 20, 74
- echo, 35, 46, 63, 64, 65, 74
- elasticity, 38, 66, 69
- elongation, 39, 40, 41, 47, 48, 52, 62, 63
- energy, 5, 6, 7, 8, 9, 10, 24, 25
- environment, 1, 67
- error, 8, 10, 11, 39, 62, 73
- factor, 8, 15, 16, 21, 22, 30, 34, 37, 38, 40, 47, 66, 67, 69, 71
- features, 5
- firmware, 75
- fluid, 8
- frequency, 6, 7, 9, 24, 64, 74, 76
- friction, 5
- fuse, 74
- gain, 19, 20, 46, 62, 64, 65, 74
- gaskets, 7
- geometry, 5, 38, 39, 67, 69, 71
- glass, 7
- glycerin, 8
- grademark, 10
- hiflash, 75
- Hooke, 69
- immersion, 71
- impedance, 7, 8
- impulses, 7
- inaccuracy, 69
- interface, 7, 8, 55, 59, 74
- interference, 25, 35
- known, 40, 41, 49, 53, 54
- light, 6, 14
- load, 63, 64, 67
- loosening, 75
- marking, 65
- material, 66, 67, 69
- mercury, 71
- microdot, 4
- modulus, 38, 66, 69
- negative, 73
- noise, 6, 35, 62
- nonparallel, 7
- nonperpendicular, 11
- normalize, 42
- offset, 38, 39, 49, 54
- operator, 5, 12, 13
- optimize, 6, 21, 24
- output, 25, 26
- paint, 7, 10
- parameter, 74, 76
- penetration, 6
- piezoelectric, 6
- pipe, 7
- power, 12, 30, 73, 74
- printer, 55
- programming, 13, 28, 73, 75, 78
- proportional, 7
- pulser, 9, 24, 25
- radar, 5
- range, 36, 65, 76
- receiver, 6, 23
- reflecting, 5, 7, 11, 35
- repair, 1
- report, 55, 56, 57, 80
- requirements, 10, 11
- rough, 11
- RS232, 55, 57
- rusted, 10
- scale, 26, 27, 63
- scan, 65
- screws, 75
- send, 55, 57, 58, 59, 60
- setting, 13, 23, 27, 73, 77
- software, 1, 5, 13, 57, 59, 74
- sonar, 5

sound, 6
steel, 15, 34, 36, 37, 66
surface, 10, 74
tensile, 67
tension, 5
thermometer, 71
torque, 5
transmit, 9, 24, 56, 58
troubleshooting, 74
ultrasound, 6
vacuum, 15

variables, 13
velocity, 15, 18, 36, 37, 38, 66, 73
viewing, 50
voltage, 26, 27, 73, 74
warning, 73, 78
warranty, 1
water, 8, 71
waveform, 28, 63, 74
website, 75
zero, 8, 12, 21
zoom, 74

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