

Tool Setting Gauge Calibration Procedure

Memorial University Technical Services

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Revision: 1

1.0 Standards and Equipment

The following equipment is required:

Granite Plate
Master Gauge Block Set

NOTE: Standards and equipment used must have a valid calibration certificate

2.0 Calibration Procedure

"TS-0097 Tool Setting Gauge Calibration Record Sheet" must be used

Clean the Tool Setting Gauge's measuring surfaces, the granite surface, and the gauge blocks to be used

NOTE: Use a conversion factor of 25.40 mm/in to convert gauge block lengths to Metric from Imperial

Step 1:

Measure the ambient temperature and record it. If the temperature is $<18^{\circ}\text{C}$ or $>24^{\circ}\text{C}$, See the Division Manager for further instructions.

Step 2:

Test Characteristic: Visual inspection of the gauge

Test Method: Slide back and forth the ruler, inspect for damage and wear along the ruler. Inspect the display, legs, and feet for damage and wear.

Acceptable Limit: Should have smooth movement along its whole length and the body of the gauge should be in good shape.

Step 3:

Test Characteristic: Scale measurement

Test Method: Zero the device if necessary. Put the gauge blocks vertically on a granite surface. Put the tool setting gauge over the stack and measure the height with the feet firmly against the granite surface, measure and record 5 different lengths. Join multiple gauge blocks for longer measurements.

Acceptable Limit: +/- 0.05"