

Title: Calibration of Starrett Type Taper Gauge

1 Scope

Work Instruction for the calibration of a Starrett type taper gauge. To be used in the absence of a manufacturers calibration instruction.

2 Preparation

Calibration shall be carried out using Category 'A' master instruments.

Equipment required:

- 200mm Vernier Calliper

The Vernier Calliper shall have the appropriate certificate of calibration traceable through United Kingdom Accreditation Service and shall be rechecked at intervals of no more than 5 years.

3 Method

3.1 Check that the identification number is clearly visible.

3.2 Check that the gauge is free from damage and corrosion.

3.3 Check that all graduations are clearly visible.

3.4 Check the thickness of the taper gauge at the positions indicated in Appendix A with a master Vernier calliper.

3.5 The difference between the indicated thickness and measured thickness shall be 0.05mm maximum.

3.6 Results shall be recorded on the calibration form (see Appendix A) and retained for audit purposes.

NOTE The calibration sticker can be applied to the box or case provided that the gauge and the box or case show the same identification number.

4 References

Appendix A. Starrett Type Taper Gauge Calibration Record.

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Appendix A. Starrett Type Taper Gauge Calibration Record.

Gauge Number:		Date last checked:		Next check due:	
Master Equipment Used:					
Vernier Calliper:					

Visual Checks (Identify Pass or Fail as appropriate)			Comments
Check ID number is clearly visible	Pass	Fail	
Check for visible signs of damage	Pass	Fail	
Check for visible signs of rusting <i>Note. Light rusting can be removed with wire wool.</i>	Pass	Fail	
Check that the graduations are clearly visible	Pass	Fail	

Dimensional Checks (Identify Pass or Fail as appropriate)			Readings / Comments		
Check that the indicated measurements are correct <i>Difference = 0.05mm maximum</i>	Pass	Fail	Indicated Thickness (mm)	Measured Thickness (mm)	Difference (mm)
			1.0		
			1.5		
			2.0		
			3.0		
			4.0		
			5.0		

Examined by:	Signed:	Date:
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NOTE Failed equipment is to be labelled 'Do Not Use' and quarantined until rectified or scrapped.