

Title: Calibration of Lawton Tools Combination Gauge and Thermit Welding (GB) Ltd Cut-Out / 200mm Edge

1 Scope

Work Instruction for the calibration of a Lawton Tools combination gauge and Thermit Welding (GB) Ltd cut-out / 200mm edges. 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:

- 1200mm Straight Edge
- Metric Feeler Gauges

The 1200mm Straight Edge and Feeler Gauges 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 and that the straight edge is free from damage, burrs, indentations or corrosion.

3.2 Check that the straight edge is not bent or twisted.

3.3 Check for straightness of 200mm edge by positioning on the master straight edge with the 200mm edge in contact. Check for any gap between 200mm edge and master straight edge with 0.1mm feeler gauge. The maximum gap shall be 0.1mm.

3.4 Check for straightness of cut-out edges by positioning on the master straight edge with cut-out edge in contact. Check for any gap between cut-out edge and master straight edge with 0.1mm feeler gauge. The maximum gap shall be 0.1mm.

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

4 References

Appendix A. Lawton Tools Combination Gauge and Thermit Welding (GB) Ltd Cut-Out / 200mm Edge Calibration Record.

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Appendix A. Lawton Tools Combination Gauge and Thermit Welding (GB) Ltd Cut-Out / 200mm Edge Calibration Record.

Gauge Number:		Date last checked:		Next check due:	
Master Equipment Used:					
Straight Edge:		Feeler Gauge:			

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 burrs. <i>Note. Light burrs may be removed by using a smooth cut file</i>	Pass	Fail	
Check for signs of indentation / corrosion <i>Note. light rusting is permissible</i>	Pass	Fail	
Check for signs of distortion in gauge	Pass	Fail	

Dimensional Checks (Identify Pass or Fail as appropriate)			Readings / Comments
Check for straightness of 200mm edge. <i>Max gap = 0.1mm.</i>	Pass	Fail	Maximum gap =
Check for straightness of cut-out edges <i>Max gap = 0.1mm.</i>	Pass	Fail	Maximum gap =

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