

Title: Calibration of Rail Depth Gauge Calibration Block

1 Scope

Work Instruction for the calibration of a rail depth gauge calibration block. 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 the identification number is clearly visible.

3.2 Check for visible signs of damage or corrosion.

3.3 Check that the rail section markings and dimensions are clearly visible.

3.4 Position Vernier calliper on each step of the calibration block in turn and record the measurement.

3.5 The maximum deviation from the indicated measurement shall be $\pm 0.10\text{mm}$.

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

4 References

Appendix A. Rail Depth Gauge Calibration Block Calibration Record.

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Appendix A. Rail Depth Gauge Calibration Block Calibration Record.

Gauge Number:		Date last checked:		Frequency:	
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 corrosion.	Pass	Fail	
Check that the rail section markings are clearly visible.	Pass	Fail	

Dimensional Checks (Identify Pass or Fail as appropriate)			Readings / Comments				
Check block measurements <i>Max deviation = $\pm 0.10\text{mm}$</i>			Rail Section	Nominal Height (mm)	Measured Height (mm)	Max Height (mm)	Min Height (mm)
	Pass	Fail	CEN 60	172.00		172.10	171.90
	Pass	Fail	CEN 56E1 (113A) / 110A / 109	158.75		158.85	158.65
	Pass	Fail	95RBH	145.26		145.36	145.16
	Pass	Fail	98	142.80		142.90	142.70
	Pass	Fail	80A	133.35		133.45	133.25

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