### **Micrometer and Gage Certification Instruction**

**1.0 Purpose and Scope**

External and Internal certification for micrometers and gages for in- house use.

**2.0 Tools and Equipment**

Micrometers

 Thread Plug Gages

 Ring Gages

 Pin Gages

 Gage Blocks

**3.0 Instruction**

Quality Assurance is the owner and author of the Micrometer and Gage Certification Instruction, and is primarily responsible for coordinating calibration.

* 1. **Certification Interval and method**

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| --- | --- | --- |
| Type of measuring tool | **Interval** | **Method / Source** |
| Micrometer | 1 year | Outside Source |
| Thread Plug Gage | 1 year | Outside Source |
| Ring Gage | 1 year | Outside Source |
| Pin Gages | 1 year  | In House |
| Gage Blocks | 2 year | Outside Source |
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* 1. **Pin Gage Measurement instruction**

Pin Gage Measurement Spreadsheet D0002.2063 is used to track pin gages. Pin gages listed will be measured annually using a micrometer.

If a pin gage measurement is out by more than ± 0.0003”, it will need replacement.

Gages will be measured at room temperature (20° C ± 10° C), and no other environmental considerations are needed.

4**.0 Records**

The completed Certification Certificate is retained by the QA department for at least 3 years after the date of certification.

**5.0 Distribution**

This instruction is available in the on line Document Control area.

**6.0 REVISION HISTORY**

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| --- | --- | --- | --- | --- |
| **DCO #** | **REV** | DATE | **INITIALS** | **CHANGES MADE** |
| 1754 | A | 10/10/2017 | AC | Creation of Micrometer and Gage Certification Instruction |
| 1776 | B | 12/21/2017 | LB | Update document number. |
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