

Procedure Calibration P7.6 Rev. G

Approved By: Mike Orsini, Quality Manager

Purpose: To document process for calibrations.

Scope: All MITE (Measuring Inspection and Test Equipment) used to inspect product.

Authority: The Quality Manager has the authority to change or modify this procedure.

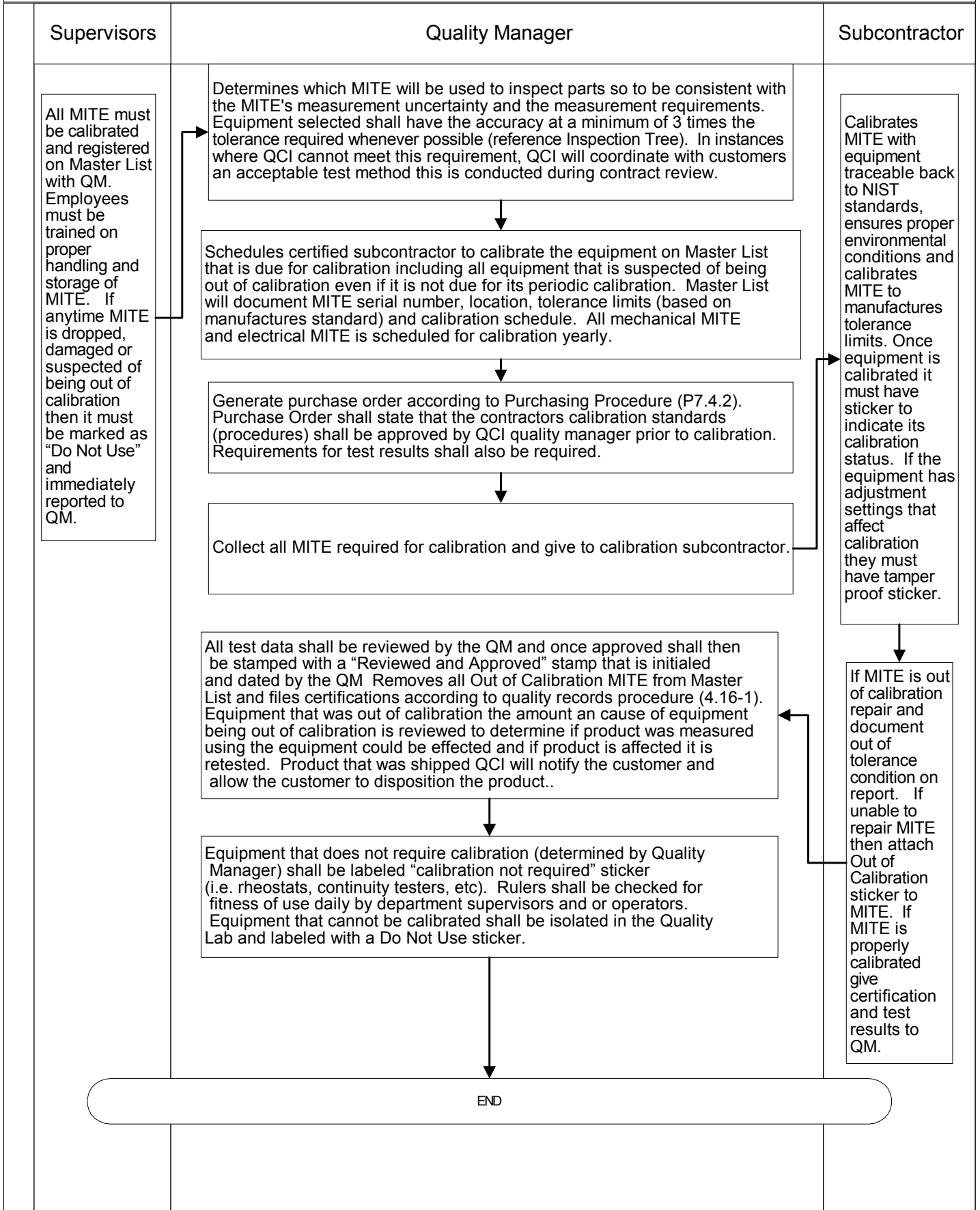
Reference Documents and Records

- Policy Element 7.6 Control of monitoring and measuring devices
- Master List of Gages
- Purchasing Procedure P7.4.2
- Calibration Records
- Quality Records Procedure P4.2.4

Change History

Date	Change	Rev	By
06/13/96	Revised paragraph 2 – changed Project Planning to FIP Department.	B	MO
12/10/96	Rewrote procedure due to pre-assessment audit. Added PO information required use of various stickers and statement on rulers.	C	MO
01/02/97	Added rulers to step 9	D	MO
03/19/97	Added use of “Reviewed & Approved” stamp. Changed precision of master gage block to 50 MILL	E	MO
5/16/01	Revised ruler info to fitness for use, changed pin gage tolerance to -.0005.	F	MO
10/29/2002	Updated to the ISO 9001:2000 requirements and flow charted.	G	MO

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Inspection Tree

Equipment	Tolerances
Micrometer	+/- .0001 inches
vernier calipers	+/- .001 inches
turns counter	+/- 2 turns
test meters	to manufactures tolerances
Bridge	to manufactures tolerances
dial indicator	+/- .0001 inches
depth micrometer	+/- .0001 inches
Ovens	+/- 50 degrees F
all other electrical equipment	to manufactures tolerances
master gage blocks	+/- .00005 inches
pin gages	+ .0000 - .0005 inches
Rulers	fit for use