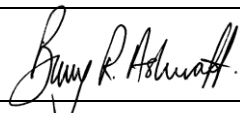


Schedule to CERTIFICATE OF ACCREDITATION																					
Laboratory	Metrology Calibration Services Limited																				
Address	PO Box 10024, Te Rapa, Hamilton, 3241 750 Te Rapa Road, Te Rapa, Hamilton, 3200																				
Telephone	07 849-6296																				
Fax	07 849-2928																				
URL	www.metrologygroup.co.nz																				
Authorised Representative	Mr Lyndon Kapoor Laboratory/Technical Manager																				
Client No.	3916																				
Programme	Metrology & Calibration Laboratory																				
Accreditation Number	618																				
Date of Accreditation	1 August 1996																				
Conformance Standard	NZS ISO/IEC 17025:2005 General requirements for the competence of testing and calibration laboratories																				
Testing Services Summary	<table border="0"> <tr> <td>5.01</td> <td>Engineers' Limit Gauges</td> </tr> <tr> <td>5.02</td> <td>Jigs, Fixtures, Cutting Tools and Components</td> </tr> <tr> <td>5.03</td> <td>Engineers' Measuring Tools and Instruments</td> </tr> <tr> <td>5.04</td> <td>Machine Tools</td> </tr> <tr> <td>5.05</td> <td>Geometric Form</td> </tr> <tr> <td>5.11</td> <td>Working Standards of Length and Angle</td> </tr> <tr> <td>5.12</td> <td>Precision Measuring Instruments</td> </tr> <tr> <td>5.51</td> <td>Force Measuring Devices</td> </tr> <tr> <td>5.53</td> <td>Testing Machines</td> </tr> <tr> <td>5.55</td> <td>Speed Measuring Devices</td> </tr> </table>	5.01	Engineers' Limit Gauges	5.02	Jigs, Fixtures, Cutting Tools and Components	5.03	Engineers' Measuring Tools and Instruments	5.04	Machine Tools	5.05	Geometric Form	5.11	Working Standards of Length and Angle	5.12	Precision Measuring Instruments	5.51	Force Measuring Devices	5.53	Testing Machines	5.55	Speed Measuring Devices
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Signatories	<table border="0"> <tr> <td>Mr Jack Brown</td> <td>5.01, 5.02, 5.03, 5.05, 5.11, 5.12, 5.51, 5.55</td> </tr> <tr> <td>Mr Lyndon Kapoor</td> <td>5.01, 5.02, 5.03, 5.04, 5.05, 5.11, 5.12, 5.51, 5.53, 5.55</td> </tr> <tr> <td>Mr Nigel Kapoor</td> <td>5.01, 5.02 (excluding CMMs), 5.03, 5.05, 5.12(excluding CMMs)</td> </tr> </table>	Mr Jack Brown	5.01, 5.02, 5.03, 5.05, 5.11, 5.12, 5.51, 5.55	Mr Lyndon Kapoor	5.01, 5.02, 5.03, 5.04, 5.05, 5.11, 5.12, 5.51, 5.53, 5.55	Mr Nigel Kapoor	5.01, 5.02 (excluding CMMs), 5.03, 5.05, 5.12(excluding CMMs)														
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Mr Nigel Kapoor	5.01, 5.02 (excluding CMMs), 5.03, 5.05, 5.12(excluding CMMs)																				

Authorised: General Manager		Issue 17	Date: 14/07/10	Page 1 of 16
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Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

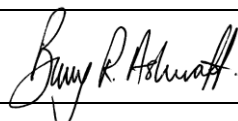
Accreditation No 618

Calibration temperature 20 °C ± 1 °C.
 All measurement uncertainties are based on a level of confidence of at least 95 %.
 Unless stated elsewhere in this schedule, calibrations are performed at the premises of the accredited laboratory.

5.01 Engineers' Limit Gauges

	Range (mm) Unless stated otherwise	Least uncertainty of measurement
Plain plug, ring and gap gauges.		
(a) Plain gap gauges in accordance with BS 969 and CP 139		
Length	10 to 50	± 0.9 µm
	50 to 100	± 1 µm
	100 to 200	± 1.4 µm
Parallelism		± 0.7 µm
Plain parallel plug gauges in accordance with BS 969 and CP137		
Diameter	10 to 25	± 0.6 µm
	25 to 50	± 0.7 µm
	50 to 75	± 0.8 µm
	75 to 100	± 0.9 µm
	100 to 200	± 1.1 µm
	200 to 345	± 1.5 µm
Plain tapered plug gauges in accordance with CP138		
Taper up to 1 in 8 on diameter		
Diameter	3 to 50	± 3 µm
	>50 to 100	± 4 µm
	>100 to 200	± 8 µm
Taper above 1 in 8 up to 1 in 3 on diameter		
Diameter	3 to 50	± 5 µm
	>50 to 100	± 6 µm
	>100 to 200	± 12 µm
Plain taper ring gauges in accordance with CP140		
Taper up to 1 in 8 on diameter		
Diameter	3 to 50	± 6 µm
	>50 to 100	± 8 µm
	>100 to 200	± 12 µm
Taper above 1 in 8 up to 1 in 3 on diameter		

Authorised:
 General Manager



Issue 17

Date: 14/07/10

Page 2 of 16

Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

Diameter	3 to 50	± 8 µm
	>50 to 100	± 10 µm
	>100 to 200	± 14 µm

(b) Parallel screw plug and ring gauges. Adjustable thread calliper gauges for parallel threads.

Parallel screw plug gauges in accordance with BS 3643/2, BS 1580/1 & 2:1962 and BS 919/3:1968, BS 919/1:1960 and CP116

Simple effective diameter	up to 300	± 2.5 µm
Major Diameter	up to 300	± 2.5 µm
Minor Diameter	up to 300	± 2.5 µm
Flank Angles		± 10 minutes of arc
Pitch		± 2.5 µm

Parallel screw ring gauges in accordance with CP119

Simple effective diameter	10 up to 200	± 4.0 µm
Major Diameter	10 up to 200	± 4.0 µm
Minor Diameter	10 up to 200	± 4.0 µm
Flank Angles		± 10 minutes of arc
Pitch		± 2.5 µm

Parallel screw ring gauges in accordance with CP165

Diameter to check plugs	1mm to 10 mm	± 3.0 µm
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(c) Taper screw plug and ring gauges. Adjustable thread calliper gauges (3 roll type) for taper threads.

Tapered screw plug gauges in accordance with BS 21, ANSI/ASME B1.20.1 and B1.20.5 and CP117

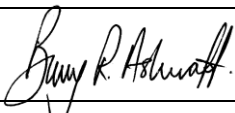
Simple effective diameter	up to 6 inches	± 3.5 µm
Major Diameter	up to 6 inches	± 3.5 µm
Minor Diameter	up to 6 inches	± 3.5 µm
Flank Angles		± 10 minutes of arc
Pitch		± 2.5 µm

Tapered screw ring gauges in accordance with BS 21, ANSI/ASME B1.20.1 and B1.20.5 and CP118

Virtual effective Diameter	NPT/BSPT up to 4 inches	± 7.0 µm
Minor Diameter		
Flank angles		± 10 minutes of arc
Pitch		± 2.5 µm
To check plugs		

Crimp tool plug gauges to manufacturer's specifications and CP179

Insulation, Braid, Barrel, Contact		± 0.6 µm
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Authorised: General Manager		Issue 17	Date: 14/07/10	Page 3 of 16
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Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

5.02 Jigs, Fixtures, Cutting Tools and Components

(calibration may be carried out on site)

Ranges and least uncertainties as specified in class 5.01 and 5.03. Actual uncertainties calculated on a case by case basis.

Thread Cutting Taps including Odd Flute Taps to CP212

	Least uncertainty of measurement
Effective Diameter	$\pm 5 \mu\text{m}$
Major/Minor Diameter	$\pm 5 \mu\text{m}$
Flank angles	± 12 minutes of arc

Measurement using Axiom CMM to CP242

Volume performance	$\pm 0.011 \mu\text{m}$
Bi-directional accuracy	$\pm 0.004 \mu\text{m}$

5.03 Engineers' Measuring Tools and Instruments

(calibration may be carried out on-site)

(a)(b) Equipment as listed below

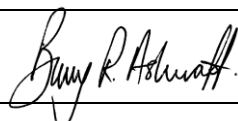
Angle plates incl Box in accordance with BS 5535:1978 and CP131

	Range (mm) Unless otherwise stated	Least uncertainty of measurement
Squareness		$\pm (2+8 L) \mu\text{m}$ where L is length in m
Flatness		$\pm (1.5+0.8 \times \text{diagonal in m}) \mu\text{m}$
Parallelism	<250 mm x 200 mm	$\pm 1.8 \mu\text{m}$
	>250 mm x 200 mm	$\pm 3.0 \mu\text{m}$

Callipers in accordance with ISO 3599:1976, ISO 6906, BS 887, JIS B 7507, DIN 862 and CP101 (may be carried out on-site)

	Range (mm) Unless otherwise stated	Least uncertainty of measurement
Accuracy of indication	up to 150 150 to 500	$\pm 15 \mu\text{m}$ $\pm (15+10L) \mu\text{m}$ where L is

Authorised:
General Manager



Issue 17

Date: 14/07/10

Page 4 of 16

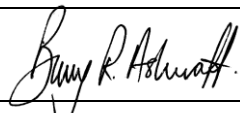
Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

500 to 2000	length in m ± (15+15 L) µm where L is length in m
Accuracy of Internal Jaws up to 300	± 16 µm
Combined Ext/Int. Jaws up to 300	± 8 µm
Combined width of Int. Jaws	± 3 µm
Accuracy of depth probe	± 28 µm
Parallelism of external Jaws (test indicator method)	± 2 µm
(three point measurement)	± 15 µm
Parallelism of external Jaws	± 4 µm
Dial gauges plunger type 0.001 mm in accordance with CP105 (may be carried out on site)	
Accuracy of Indication up to 25 mm	± (0.5 + 0.05 L) µm where L = travel in mm
Repeatability	± 0.4 µm
Discrimination	± 0.4 µm
Dial gauges plunger type 0.01 mm in accordance with BS 907:1965 and CP105 (may be carried out on site)	
Accuracy of indication up to 50 m	± (2 +0.05 L) µm where L = travel in mm
Repeatability	± 0.4 µm
Discrimination	± 0.4 µm
Dial gauges lever type 0.002 mm in accordance with BS 2795, AS 2103:1978 and CP106 (may be carried out on-site)	
Accuracy of indication	± 0.6 µm
Repeatability (drum method)	± 0.6 µm
(roller method)	± 0.8 µm
Discrimination	± 0.6 µm
Dial gauges lever type 0.01 mm to BS 2795, AS 2103:1978 and CP106 (may be carried out on-site)	
Accuracy of indication	± 2.0 µm
Repeatability (drum method)	± 1.0 µm
(roller method)	± 2.0 µm
Discrimination	± 1.0 µm
Digital gauges plunger type 0.001 mm to CP125 (may be carried out on-site)	
Accuracy of indication	± (1.0 + 0.05 L) µm where L = travel in mm
Repeatability	± 1.0 µm
Discrimination	± 1.0 µm

Authorised: General Manager 	Issue 17	Date: 14/07/10	Page 5 of 16
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Schedule to

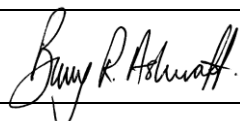
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Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

Digital gauges plunger type 0.0001 mm to CP125 Accuracy of indication	$\pm (0.2 + 0.05 L) \mu\text{m}$ where L = travel in mm
Repeatability	$\pm 0.2 \mu\text{m}$
Discrimination	$\pm 0.2 \mu\text{m}$
Engineer's Levels to BS 3509 & BS 958 and CP114 Mean sensitivity	$\pm 10\%$ of nominal minimum 2 seconds of arc
Base flatness	$\pm 2 \mu\text{m}$
Roll error	$\pm 10\%$ of nominal
Feeler gauges to BS 959:1950 and CP107 Thickness	$\pm 0.7 \mu\text{m}$
Parallelism	$\pm 0.4 \mu\text{m}$
Height gauges – Vernier 0.02 mm/0.001 inch to BS 1643, JIS B 7517 and CP108 (may be carried out on-site) Accuracy of reading up to 2000 mm	$\pm (8 + 5 L) \mu\text{m}$ where L is length in m
Parallelism	$\pm 2.0 \mu\text{m}$
Flatness	$\pm 2.0 \mu\text{m}$
Perpendicularity	$\pm (2 + 8 L) \mu\text{m}$ where L is in metres
Setting blocks supplied with height gauge Length	$\pm 0.5 \mu\text{m}$
Parallelism	$\pm 0.5 \mu\text{m}$
Height Gauges – Digital 0.01 mm/0.0005 inch in accordance with JIS B 7517 and CP127 (may be carried out on-site) Accuracy of reading up to 1000 mm	$\pm (8 + 5 L) \mu\text{m}$ where L is length in m
Parallelism	$\pm 2.0 \mu\text{m}$
Flatness	$\pm 2.0 \mu\text{m}$
Micrometers – External in accordance with BS 870:1950, DIN 863 + JIS B 7502 and CP109 (may be carried out on-site) Range of error to traverse of the Micrometer Screw 0 to 25	$\pm 0.7 \mu\text{m}$

Authorised:
General Manager



Issue 17

Date: 14/07/10

Page 6 of 16

Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

Parallelism	25 to 75	$\pm 2 \mu\text{m}$
	>75	$\pm 0.8 \mu\text{m}$
	0 to 75	$\pm 0.25 \mu\text{m}$
	100 to 150	$\pm 1.5 \mu\text{m}$
Flatness	>150	$\pm 3 \mu\text{m}$
		$\pm 0.15 \mu\text{m}$
Zero setting	0 to 25	$\pm 1 \mu\text{m}$
	25 to 100	$\pm 1.5 \mu\text{m}$
	>100	$\pm (1 + 9 L) \mu\text{m}$ where L is length in m

Micrometers – Internal/Stick in accordance with BS 959:1950, + JIS B 7502, + DIN 863/4 and CP110

Range of error of traverse of the Micrometer screw	$\pm 2 \mu\text{m}$
Zero setting at minimum range (Int. Misc)	$\pm (2 + 5 L) \mu\text{m}$ where L is length in m
Extension tube lengths up to 300	$\pm (0.4 + 3 L) \mu\text{m}$ where L is length in m
	$\pm 3 \mu\text{m}$
up to 600	$\pm 5 \mu\text{m}$
up to 1000	$\pm 0.6 \mu\text{m}$
Spacing collar length	$\pm (0.4 + 3 L) \mu\text{m}$ where L is length in m
Gap setting gauge length	$\pm 0.4 \mu\text{m}$
Gap setting gauge parallelism	$\pm 0.2 \mu\text{m}$
Flatness	

Micrometers – Depth in accordance with BS 6468 and CP104 (may be carried out on-site)

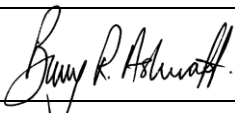
Range of error of traverse of the Micrometer screw	$\pm 2 \mu\text{m}$
Zero setting at minimum range	$\pm (2 + 4 L) \mu\text{m}$ where L is length in m
Flatness (optical flat method) (test indicator method)	$\pm 0.2 \mu\text{m}$
	$\pm 2 \mu\text{m}$

Micrometer heads type 3 in accordance with BS 1734:1951 and CP112

Error of traverse of measuring face (progressive error)	$\pm 0.4 \mu\text{m}$
(periodic error)	$\pm 0.3 \mu\text{m}$
Repeatability	$\pm 0.2 \mu\text{m}$

Protractors – Bevel mechanical and optical in accordance with BS 1685 and CP112

Accuracy of indication	± 1.5 minutes of arc
Straightness	$\pm 2.5 \mu\text{m}$
Parallelism	$\pm 3 \mu\text{m}$
Flatness	$\pm 2 \mu\text{m}$

Authorised: General Manager 	Issue 17	Date: 14/07/10	Page 7 of 16
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Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

Rulers – Steel in accordance with BS 4372:1968 and JIS B 7516 and CP133
 Accuracy of graduation centreline
 relative to datum end up to 2000 $\pm (42 + 0.01 L) \mu\text{m}$ where L is
 measured length in mm

Retractable steel pocket rules and tape measures in accordance with JIS B 7512,
 AS 1290: Part 4 and CP167
 Accuracy of graduation centreline relative to
 blade tip inside face up to 50 m $\pm (50 + 12 L) \mu\text{m}$ where L
 is measured length in m

Straightedges up to 6 m in accordance with BS 5204: Part 2:1977 and CP103
 Straightness $\pm (1.5 + 0.5x \text{ length in m}) \mu\text{m}$
 Parallelism $\pm 3 \mu\text{m}$

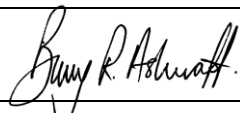
Squares – Engineers incl Cylindrical and Block in accordance with BS 939:1977 and CP102
 Try Squares up to 600 mm $\pm (2 + 8 L) \mu\text{m}$ where L is
 length in m
 Cylindrical/Block squares not exceeding 140 mm dia/width $\pm (1 + 4 L) \mu\text{m}$ where L is
 length in m
 Cylindrical/Block squares exceeding 140 dia/width $\pm (2 + 4 L) \mu\text{m}$ where L is
 length in m

Parallelism
 Try squares blade $\pm 2.3 \mu\text{m}$
 stock $\pm 1.8 \mu\text{m}$
 Block squares $\pm 1.8 \mu\text{m}$

Flatness
 Try/Block squares (by comparison to reference surface) $\pm 1.8 \mu\text{m}$
 Block squares using Talyvel Electronic Level $\pm (1.5 + 0.8 x \text{ diagonal in m}) \mu\text{m}$
 Cylindrical square by comparison to reference surface $\pm 1.8 \mu\text{m}$
 under 95 mm dia by optical interference $\pm 0.2 \mu\text{m}$

Straightness
 Try square $\pm (1 + 4 L) \mu\text{m}$ where L is
 length in m
 Cylindrical squares $\pm 1.8 \mu\text{m}$

Surface plates and tables in accordance BS 817:1988, DIN 876/1
 Federal specification GGG-P-463c, 1973 and CP115
 (may be carried out on-site)

Authorised: General Manager 	Issue 17	Date: 14/07/10	Page 8 of 16
---	----------	----------------	--------------

Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

Flatness $\pm (1.5 + 0.8 \times \text{diagonal in m}) \mu\text{m}$
 Variation (using variation gauge to BS817) $\pm 0.4 \mu\text{m}$

Precision vernier depth gauges 0.02 mm/0.001 inch in accordance BS 6365 and CP142 up to 300 mm

Accuracy of reading $\pm 12 \mu\text{m}$
 Flatness by optical interference $\pm 0.2 \mu\text{m}$
 Flatness by comparison to ref surface $\pm 1.8 \mu\text{m}$
 Parallelism $\pm 1.8 \mu\text{m}$
 Straightness $\pm 1.8 \mu\text{m}$

Bore Gauges – Cylinder type, 2 point contact, to JIS B 7515 and CP123

Sphericity of measuring faces $\pm 4 \mu\text{m}$
 Overall performance 0.001 mm dial $\pm 2 \mu\text{m}$
 0.01 mm dial $\pm 7 \mu\text{m}$
 0.005 inch dial $\pm 0.0003 \text{ inch}$

3 line contact type to DIN 863 part 4 and CP123

Overall performance $\pm 1 \mu\text{m}$

Engineers Parallels to BS 906 parts 1 & 2 and CP132

Thickness/Width $\pm 0.7 \mu\text{m}$
 Straightness $\pm 1.3 \mu\text{m}$
 Parallelism $\pm 0.4 \mu\text{m}$

Ultrasonic Calibration Blocks to BS2704:1978 and CP135

Length $\pm 3 \mu\text{m}$
 Diameter $\pm 5 \mu\text{m}$
 Degrees Scales $\pm 30 \text{ seconds of arc}$

Angle Gauges – Workshop/Inspection to CP213 (Not precision angle gauges)

Plane angle $\pm 4 \text{ seconds of arc}$
 Squareness $\pm (0.7 + 0.007 L) \mu\text{m}$ where L is length in m
 Parallelism $\pm 1 \mu\text{m}$

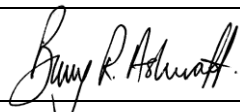
Wet Film Thickness Gauges – wheel type to manufacturer’s specification and CP191

Accuracy of indication $\pm 0.8 \mu\text{m}$

Thread Micrometers to DIN 863 part 3 and CP201

Range of error of traverse of the micrometer screw $\pm 2 \mu\text{m}$
 Zero setting $\pm 1 \mu\text{m}$
 Cone/vee semi angles $\pm 6 \text{ minutes of arc}$

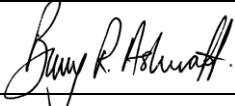
Authorised:
 General Manager



Issue 17

Date: 14/07/10

Page 9 of 16

Schedule to		
CERTIFICATE OF ACCREDITATION		
Metrology Calibration Services Limited Metrology & Calibration Laboratory SCOPE OF ACCREDITATION		Accreditation No 618
Linear Counting Wheels to CP194		$\pm (30 + 0.2 L)$ mm where L is length in m
Inclinometers to manufacturer's specification and CP210		
Digital 0.1° resolution		± 4 minutes of arc
Pendulum type 1 minute of arc resolution		± 30 seconds of arc
Flatness of Base		$\pm 2 \mu\text{m}$
Parallelism		$\pm 1 \mu\text{m}$
5.04 Machine Tools (carried out on-site)		
(a) Geometric testing to CP156 including		Least uncertainty of measurement
Flatness of beds and tables		$\pm (1.5 + 0.8 \times \text{diagonal in m}) \mu\text{m}$
Straightness of guide ways		$\pm (1.5 + 0.5 L) \mu\text{m}$ where L is length in m
Squareness/Parallelism		$\pm (1.5 + 0.01 L) \mu\text{m}$ where L is length in m
(b) Practical tests to CP156 including		
Digital machine scales 0.01 mm		$\pm (10 + 0.01 L) \mu\text{m}$
5.05 Geometric Form (calibration may be carried out on-site)		
Geometric Form to CP214		Least uncertainty of measurement
(a) Surface texture		$\pm 0.05 \mu\text{m} + 2\%$ of nominal
(b) Roundness @ x 10,000		$\pm 0.12 \mu\text{m}$
(c) Straightness		$\pm (1.5 + 0.5 L) \mu\text{m}$ where L is length in m
(d) Flatness		$\pm (1.5 + 0.8 L) \mu\text{m}$ where L is diagonal length in m
(e) Eccentricity		$\pm 0.3 \mu\text{m}$
(f) Squareness		$\pm (0.7 + 0.007 L) \mu\text{m}$ where L is length in m
(g) Angle		± 3 second of arc
Authorised: General Manager		Issue 17 Date: 14/07/10 Page 10 of 16

Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

5.11 Working Standards of Length and Angle

(a) Gauge blocks and accessories

Gauge Block verification, central length and variation in length to BS4311 and ISO 3650 used as a guide

Verification by comparison, using a TESA 0.01 µm dual probe differential probing system
 Measurement uncertainty expanded to reflect in-house method.

Central Length

≤ 10 mm	± 0.12 µm
> 10 mm up to 25 mm	± 0.12 µm
> 25 mm up to 50 mm	± 0.14 µm
> 50 mm up to 75 mm	± 0.18 µm
> 75 mm up to 100 mm	± 0.24 µm

Variation

± 0.07 µm

Gauge Block Accessory Sets to BS 4311 part 2 and CP126

Type A Jaws flatness	± 0.15 µm
length	± 0.3 µm
Type B Jaws flatness	± 0.15 µm
Centre Point flatness	± 0.15 µm
Deviation of centre point from plane of wringing face	± 3 µm
Scriber Point flatness	± 0.15 µm
Base flatness	± 0.15 µm
Platform flatness	± 0.15 µm
parallelism	± 3 µm
height	± 0.4 µm

(b) Length bars and accessories

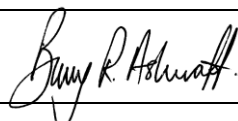
Thread Micrometer Setting Standards to in-house method and CP201

Effective diameter	± 5 µm
Cone/vee flank angles	± 12 minutes of arc

Micrometer settings rods – Spherical Ended to BS870:1950 – Section 3 + JIS B 7502 and CP129

up to 1000 mm	± (0.6 + 3 L) µm where L is length in m
up to 40 inch	±(26 + 2 L) µ inch where L is

Authorised:
 General Manager



Issue 17

Date: 14/07/10

Page 11 of 16

Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

length in inches

Micrometer setting rods (flat parallel ended) in accordance with BS 870:1950, Section 3
 Setting gauges JIS B 7502 and CP129

Length $\pm (0.5 + 3 L) \mu\text{m}$ where L is length in m
 $\pm (20 + 3 L) \mu\text{inch}$ where L is length in inches

Parallelism $\pm (0.4 + 0.5 L) \mu\text{m}$ where L is length in m
 $\pm (15 + 0.5 L) \mu\text{inch}$ where L is length in inches

(c) Cylindrical standards, internal and external

Cylindrical setting standards in accordance with MOY/SCM161M issue 3.2001 and CP136

	Range (mm) Unless otherwise stated	Least uncertainty of measurement
Diameter	up to 25	$\pm 0.6 \mu\text{m}$
	25 to 50	$\pm 0.7 \mu\text{m}$
	50 to 75	$\pm 0.8 \mu\text{m}$
	75 to 100	$\pm 0.9 \mu\text{m}$
	100 to 200	$\pm 1.1 \mu\text{m}$
	200 to 345	$\pm 1.5 \mu\text{m}$
Roundness (MZC)		$\pm 0.12 \mu\text{m}$
Concentricity		$\pm 3 \mu\text{m}$

Plain parallel setting ring gauges in accordance with BS 4064:1966, DIN 2250, CP139

Diameter	10 to 50	$\pm 0.9 \mu\text{m}$
	50 to 100	$\pm 1.0 \mu\text{m}$
	100 to 200	$\pm 1.4 \mu\text{m}$

Parallelism $\pm 0.5 \mu\text{m}$

Roundness to BS 3730 (MZC) $\pm 0.12 \mu\text{m}$

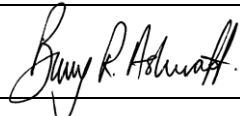
Plain Parallel Setting Ring Gauges to CP211
 from 0.6 up to 11

$\pm 2 \mu\text{m}$

Orifice Plates to BS/EN/ISO 5167-2, ANSI/API MPMS 14.3.2 and CP205

Surface finish (Ra)	$\pm 0.02 \mu\text{m Ra} + 2\% \text{ of reading}$
Flatness	$\pm 6 \mu\text{m}$
Orifice Diameter	$\pm 3 \mu\text{m}$

Authorised:
 General Manager



Issue 17

Date: 14/07/10

Page 12 of 16

Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

Plate thickness (E) ± 5 µm
 Bevel Angle ± 8 minutes of arc

(i) Pi Tapes to manufacturers specification and CP187

On diameter inch ± 0.001 inch
 On diameter millimetre ± 0.03 mm

Dip Tapes to JIS B 7512 and CP199

Graduation centreline position relative to cardinal point ± (50 + 12 L) µm where L is length in m

(m) Reference standards for surface finish

0.3 µm to 12 µ inch Surface Roughness Specimen to BS 1134 part 1 & 2 and CP214(a)
 Surface Finish (Ra) ± 0.025 µm Ra

0.7 µm to 28 µ inch Surface Roughness Specimen to BS 1134 part 1 & 2 and CP214(a)
 Surface Finish (Ra) ± 0.045 µm Ra

6 µm to 240 µ inch Surface Roughness Specimen to BS 1134 part 1 & 2 and CP214(a)
 Surface Finish (Ra) ± 0.25 µm Ra

5.12 Precision Measuring Instruments

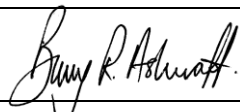
(calibration may be carried out on-site)

(d) Precision projection apparatus to manufacturer's specification and CP144

Least uncertainty of measurement

Linear scales		± 2 µm
Degrees scale		± 1.5 minutes of arc
Squareness		± (1+0.01 L) µm where L is length in m
		± (1+0.01 L) µm where L is length in m
Parallelism		± 0.1 %
Performance	@ 10 x mag'n	± 0.04 %
Measured	@ 20 x mag'n	± 0.01 % value
	@ 50 x mag'n	± 0.005 %
	@ 100 x mag'n	

Authorised:
 General Manager



Issue 17

Date: 14/07/10

Page 13 of 16

Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

(I) Sine bars and sine tables

Sine Bars to BS 3064: 1978 and CP113

Flatness	optical interference	$\pm 0.2 \mu\text{m}$
	test indicator method	$\pm (0.5 + 0.006 L) \mu\text{m}$ where L is length in m
Squareness		$\pm 0.6 \mu\text{m} / 25 \text{ mm}$
Roller Centres		$\pm (0.7 + 0.002 L) \mu\text{m}$ where L is length in m
Equality of Roller Diameters		$\pm 0.6 \mu\text{m}$
Roundness		$\pm 0.12 \mu\text{m}$
Parallelism		$\pm 1 \mu\text{m}$
Performance (Plane angle)		$\pm 4 \text{ seconds of arc}$

Computerised digital height gauges 0.001 mm to 0.000 05 inch to manufacturer's specifications to CP120
 (calibration may be carried out on-site)

Accuracy of reading		$\pm (1 + 3 L) \mu\text{m}$ where L is measured length in m
Squareness	up to 500 mm	$\pm 3 \mu\text{m}$
Straightness		$\pm 2 \mu\text{m}$
Flatness (gauge block method)		$\pm 2 \mu\text{m}$
(test indication method)		$\pm 2 \mu\text{m}$
Parallelism		$\pm 2 \mu\text{m}$
Computed and calculated results		\pm as calculated (see note)

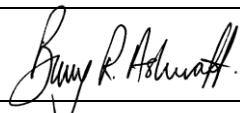
Note: From 10 repeat readings using the height gauge and calibrated ring and plug gauges and 2D artefact.

Mu-Checkers to CP158

Accuracy of Indication	$\pm 1 \%$ of range minimum $0.2 \mu\text{m}$
Repeatability	$\pm 0.1 \mu\text{m}$
Discrimination	$\pm 0.1 \mu\text{m}$

Extensometers to ISO 9513 and CP237

Relative bias error	up to 50 mm/2 inch	$\pm 0.3 \mu\text{m}$ or $12 \mu \text{ inch}$
Gauge length		$\pm 0.025 \text{ mm}$ or 0.001 inch

Authorised: General Manager		Issue 17	Date: 14/07/10	Page 14 of 16
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Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION

Accreditation No 618

Performance verification of Co-ordinate Measuring Machines to ASME B89.4.1 and BS EN/ISO 10360-2

Least uncertainty of measurement (where L is length in metres)

BS/ISO 10360-2:
 Probe repeatability
 Volume accuracy

$\pm 1 \mu\text{m}$
 $\pm (1.2 + 3.5 L) \mu\text{m}$

Uncertainties based on a machine with 1 micron resolution

Repeatability
 Point to point probing
 Bi-directional probing
 Linear displacement accuracy
 Volumetric accuracy

$\pm 0.7 \mu\text{m}$
 $\pm 0.8 \mu\text{m}$
 $\pm 0.9 \mu\text{m}$
 $\pm (0.9 + 3.5 L) \mu\text{m}$ where L is length in meters
 $\pm 1.7 \mu\text{m}$ per 300 mm

5.51 Force Measuring Devices

(a) Spring balances CP 180 and manufacturer's specifications

Range	Least uncertainty of measurement
0 kg to 25 kg x 10 g	$\pm 2 \text{ g}$
0 kg to 25 kg x 50 g	$\pm 14 \text{ g}$
0 kg to 25 kg x 100 g	$\pm 23 \text{ g}$

(b) Digital force gauges to manufacturer's specifications and CP180

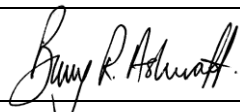
up to 50 kg	$\pm 0.1 \text{ g}$
5 kg x 0.001 kg	$\pm 0.001 \text{ kg}$
10 kg x 0.002 kg	$\pm 0.002 \text{ kg}$
25 kg x 0.005 kg	$\pm (5 + 0.1f)/1000 \text{ kg}$
50 kg x 0.01 kg	$\pm (10 + 0.1f)/1000 \text{ kg}$ where f is measured force in kg

(The constant 0.1 is to account for the combining of several weights)

5.53 Testing Machines

Calibration of Durometer hardness testers of scale types A, B, C, D, DO and O in accordance with

Authorised:
 General Manager



Issue 17

Date: 14/07/10

Page 15 of 16

Schedule to

CERTIFICATE OF ACCREDITATION

Metrology Calibration Services Limited
 Metrology & Calibration Laboratory
SCOPE OF ACCREDITATION Accreditation No 618

ASTM D2240, Section 7.

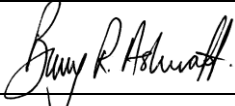
	Least uncertainty of measurement
Indenter spring	± 0.04 N
Indenter shape (Diameter)	± 0.005 mm
Indenter angle	± 12 minutes of arc
Extension	± 0.005 mm
Setting Blocks	± 0.002 mm

5.55 Speed Measuring Devices

(a) Tachometers to manufacturer's specification and CP198

		Least uncertainty of measurement
Non Contact Type		
Digital	30 rpm to 30,000 rpm	± 1 LSD
Contact Type		
Digital	100 rpm to 30,000 rpm	± 1 LSD + 1 rpm to 5,000 rpm
Analogue	100 rpm to 30,000 rpm	± 20 % minimum resolution

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Authorised: General Manager 	Issue 17 Date: 14/07/10	Page 16 of 16
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