

IN-HOUSE PROCEDURE # _____

PROCEDURE FOR VERIFYING CUBE MOLD AND TAMPER

Item:

Cube Mold and Tamper

Purpose:

This method provides instructions for checking the critical dimensions, planeness, and perpendicularity of a cube mold and tamper.

Inspection Equipment Required:

1. Ruler or caliper readable to 0.001 in. (0.01 mm) or better.
2. Straight-edge 2 in. (50 mm) or slightly less
3. Feeler gauges 0.02 in. (0.5 mm), 0.002 in. (0.05 mm)
4. Square 2 in. (50 mm)

Tolerance:

Equipment shall meet the dimensional tolerances specified in the applicable test method.

Procedure:

MOLD

1. Wipe clean all surfaces.
2. Check the planeness of all sides using a straight-edge and 0.002 in. (0.05 mm) feeler gauge.
3. Check the planeness of the bottom and top plates using a straight-edge and 0.002 in. (0.05 mm) feeler gauge.
4. Zero caliper and measure the distance between opposite sides.
5. Measure the height of each compartment.
6. Check the angle between all adjacent faces using a square and a 0.02 in. (0.5 mm) feeler gauge.

TAMPER

1. Measure the width of the tamper.
2. Measure the thickness of the tamper.
3. Measure the length of the tamper.
4. Place the square along the head of the tamper. Try to insert the feeler gauge along the side of the tamper. If this can be accomplished, the head is not square.
5. Check all sides.
6. Check the head for flatness. Place the straight-edge of the square on the head of the tamper. Try to insert the feeler gauge between the square and the head of the tamper. If this can be accomplished the head is not flat. Rounded or peeling tampers shall not be used.