IN-HOUSE PROCEDURE # _____

PROCEDURE FOR VERIFYING GROOVING TOOLS and GAUGES

Item:
Grooving Tool and Gauge

Purpose:
This method provides instructions for checking the critical dimensions of a grooving tool and height calibration gauge.

Inspection Equipment Required:
1. Caliper readable to 0.001 in. (0.1 mm) or better.

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

Procedure:
CURVED GROOVING TOOL
1. Measure the thickness (depth) of the curved end of the grooving tool.
2. Measure the width of the curved end of the grooving tool.
3. Measure the width of the cutting edge (tip) of the grooving tool.

FLAT GROOVING TOOL
1. Measure the width of the flat tip.
2. Measure the top width of the V section of the grooving tool.
3. Measure the width of the cutting end of the grooving tool.
4. Measure the thickness of the grooving tool.
5. Measure the radius of the cutting end of the tool from 60 mm from the opposite end to the curved section of the cutting end.

GAUGE
1. Measure the width of the gauge.
2. Measure the thickness (height) of the gauge.
3. Measure the length of the gauge.