

Grooving Tool & Gauge Calibration Worksheet

Equipment ID: _____	Date: _____
Manufacturer: _____	Performed By: _____
Model #: _____	Last Calibration: _____
Serial #: _____	Next Calibration Due: _____
Storage Location: _____	

Calibration Item: Verify critical dimensions of a grooving tool and gauge
 Calibration Procedure: In-House Procedure for Verifying Grooving Tools and Gauges
 Calibration Equipment: Caliper readable to 0.001 in. (0.1 mm) or better

Caliper ID: _____

<input type="checkbox"/> Curved Grooving Tool	Measurement	Tolerance	Pass / Fail
Thickness of curved end		10.0 ± 0.1 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Width of curved end		13.5 ± 0.1 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Width of cutting edge		2.0 ± 0.1 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Gauge Width/Thickness		10.0 ± 0.2 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Gauge Length		approx. 15.9 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail

<input type="checkbox"/> Flat Grooving Tool	Measurement	Tolerance	Pass / Fail
Width of tip		2.0 ± 0.1 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Top width of V section		11.0 ± 0.2 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Width of cutting end		40.0 ± 0.5 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Thickness of tool		2.0 ± 0.1 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Radius		50.0 ± 0.5 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Gauge Width		at least 10 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Gauge Length		13 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Gauge Thickness		10 ± 0.05 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail

<input type="checkbox"/> Separate Gauge	Measurement	Tolerance	Pass / Fail
Gauge Width		approx. 25 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Gauge Length		approx. 50 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Gauge Thickness		10 ± 0.2 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail

Pass / Fail _____

Initial By _____