

Gyratory Mold Calibration Worksheet

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

Calibration Item: Check general condition and verify critical dimensions
 Calibration Procedure: In-House Procedure for Verifying Gyratory Molds & End Plates
 Calibration Equipment: 3-Point Bore Gauge, readable to 0.001 in. (0.0025 mm) or better

3-Point Bore Gauge ID: _____

6 in. (150 mm) Calibrated Master Ring

Master Ring ID: _____

(2) 2 in. (50 mm) Gauge Blocks

Gauge Block ID: _____

Caliper readable to 0.001 in. (0.025 mm) or better

Caliper ID: _____

MOLD	<input type="checkbox"/> New <input type="checkbox"/> Used	Measurement	Specification	Pass / Fail
Does the mold have deep inside surface gouges?		<input type="checkbox"/> Yes <input type="checkbox"/> No		<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Inside mold length			At least 250 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Wall thickness			At least 7.5 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Mold Diameter Elevation 1	1A		New: 149.9 – 150.0 mm Used: not greater than 150.2 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
	1B			<input type="checkbox"/> Pass <input type="checkbox"/> Fail
	1C			<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Mold Diameter Elevation 2	2A			<input type="checkbox"/> Pass <input type="checkbox"/> Fail
	2B			<input type="checkbox"/> Pass <input type="checkbox"/> Fail
	2C			<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Mold Diameter Elevation 3	3A			<input type="checkbox"/> Pass <input type="checkbox"/> Fail
	3B			<input type="checkbox"/> Pass <input type="checkbox"/> Fail
	3C			<input type="checkbox"/> Pass <input type="checkbox"/> Fail

Pass / Fail _____

Initial By _____

Gyratory End Plate Calibration Worksheet

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

Calibration Item: Check general condition and verify critical dimensions
 Calibration Procedure: In-House Procedure for Verifying Gyratory Molds & End Plates
 Calibration Equipment: Caliper with a range of at least 12 in. (305 mm) and readable to
 0.001 in. (0.025 mm) or better

Caliper ID: _____

END PLATE	Measurement	Specification	Pass / Fail
Does the end plate have deep surface gouges on the side presented to the asphalt?		<input type="checkbox"/> Yes <input type="checkbox"/> No	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Maximum Diameter A		149.50 – 149.75 mm	<input type="checkbox"/> Pass <input type="checkbox"/> Fail
Diameter B			<input type="checkbox"/> Pass <input type="checkbox"/> Fail

Pass / Fail _____
 Initial By _____