

Schedule of Accreditation

issued by

United Kingdom Accreditation Service

2 Pine Trees, Chertsey Lane, Staines-upon-Thames, TW18 3HR, UK

 UKAS CALIBRATION 0716 Accredited to ISO/IEC 17025:2005	Tru-Cal Metrology Ltd	
	Issue No: 011 Issue date: 16 February 2018	
	Unit 1 Gorton Industrial Estate Froxmer Street Gorton Manchester M18 8EF	Contact: Mr R Desmond Tel: +44 (0)161 223 4028 Fax: +44 (0)161 223 6028 E-Mail: info@tru-cal.co.uk Website: www.tru-cal.co.uk
Calibration performed by the Organisations at the locations specified below		

Locations covered by the organisation and their relevant activities

Laboratory locations:

Location details	Activity	Location code
Address Unit 1 Gorton Industrial Estate Froxmer Street Gorton Manchester M18 8EF	Local contact Mr R Desmond	Calibration A

Site activities performed away from the locations listed above:

Location details	Activity	Location code
At customers premises	Mr R Desmond	Dimensional B



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DETAIL OF ACCREDITATION

Measured Quantity Instrument or Gauge	Range	Calibration and Measurement (CMC) Capability Expressed as an Expanded Uncertainty ($k=2$)	Remarks	Location Code
RANGE IN MILLIMETRES AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED				
LENGTH			NOTES	
Gauge blocks Inch (Steel and Tungsten Carbide)	As BS 4311:2007 0 in to 0.4 in 0.4 in to 1 in 2 in 3 in 4 in	Class (See notes) C 3.0 4.0 5.0 μ in. 6.0 7.0	1. The uncertainty quoted is for the departure from flatness, straightness, parallelism or squareness, ie the distance separating the two parallel planes which just enclose the surface under consideration.	
Millimetre (Steel and Tungsten Carbide)	BS EN ISO 3650:1999 0 to 10 10 in to 25 30, 40, 50 60, 70, 75 80, 90, 100	C 0.080 0.10 0.12 0.15 0.18	2. Calibrations may be given in inch units where applicable. 3. Single start symmetrical thread forms only.	
Comparison Class C uncertainties apply to the measurement of length of gauges by comparison with grade K standards of length of a similar material. Class C uncertainties apply to new and used grade 0, 1 and 2 gauges to BS 4311:2007 and BS EN ISO 3650:1999.				
Plain plug gauge parallel, cylindrical setting standards and rollers	1 to 50 diameter 50 to 100 100 up to 150	0.8 1.0 on diameter 1.5	5. Features and associated parts of these gauges can be measured to the uncertainties given for equivalent items listed in this schedule.	A
Plain plug gauges (taper) parallel to 1 in 8 on diameter	0 to 100 diameter	3.0 on diameter		A
Plain ring gauges (parallel)	2 to 10 diameter 10 to 50 50 to 100 100 to 150	1.5 0.8 on diameter 1.0 1.5		A A
Plain ring gauges (taper) parallel to 1 in 8 on diameter	3 to 25 diameter 25 to 100	4.0 12 on diameter		A A
Length gauges, flat and spherical ended	0 to 575	1.0 + (8.0 x length in m)		A
Plain gap gauges (parallel)	2 to 125 125 to 150	3.0 4.0		A
Screw plug gauges (parallel) including check and setting plugs	0 to 150 diameter	4.0 on pitch diameter See Note 3		A



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RANGE IN MILLIMETRES AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED				
LENGTH (cont'd)				
Screw plug gauges (taper)	0 to 150 diameter	5.0 on pitch diameter (see note 3)		A
Screw ring gauges (parallel)	6 to 150 diameter	5.0		A
Screw ring gauges (taper)	6 to 150 diameter	6.0		A
Screw pitch Screw flank angle	0.2 to 8 0° to 52°	1.5 5.0 minutes of arc		A
Screw thread adjustable caliper gauges (parallel)	1 to 100 diameter	See note 4		A
Parallels	BS 906:Part 1:1972 5 to 50 x 100 x 400	2.5 to 5.0		A
Vee blocks	BS 3731:1987 20 to 150	4.0 to 6.0		A
Receiver, position and profile gauges, jigs and fixtures See note 5	Maximum dimensions 0 to 400 x 700 x 600	Minimum per co-ordinate 3.0 + (20 x length in m)		A
Feeler gauges	BS 957:2008 0.025 to 1	2.0		A
ANGLE				
Squares				
Blade type	BS 939:2007 0 to 600	5.0 On Squareness See Note 1		A
Block	BS 939:2007 0 to 600	7.0		
Spirit levels	BS 958:1968 and BS 3509:1962 5 seconds of arc to 60 minutes of arc nominal sensitivity	Mean sensitivity: 10% of nominal Minimum 0.50 seconds of arc		A
Electronic indicating levels	0 minutes of arc to 20 minutes of arc	1.0 % range Minimum 0.50 seconds of arc		A
Right angle and box angle plates	BS 5535:1978 50 to 600	Squareness 6.0 Parallelism 3.0 See note 1		A



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RANGE IN MILLIMETRES AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED				
FORM				
Surface plates	BS 817:2008 160 x 100 to 1600 x 1000	1.5 + (0.80 x diagonal in m) See Note 1		A, B
Granite and Cast iron				
MEASURING INSTRUMENTS AND MACHINES				
Micrometers				
External	BS 870:2008 0 to 600	Heads: 2.0		
Internal	BS 959:2008 0 to 900	Setting and extension rods		
Depth	BS 6468:2008 0 to 300	1.0 + (8.0 x length in m)		
Height setting micrometer	0 to 300	Heads 1.50 between any two points Stepped column 2.5 Overall Performance 3.0		A
Riser blocks for above	150 300	3.0 5.0		A
Vernier caliper, height and depth gauges	BS 887:2008 0 to 600 BS 1643:2008 0 to 600 BS 6365:2008 0 to 600	Overall performance 10 + (30 x length in m)		A
Bevel protractor	BS 1685:2008 0° to 360°	6 0 minutes of arc		A
Dial gauges and dial test indicators	BS 907:2008 and BS 2795:1981 0 to 50	1.5		A
Comparators (external)	BS 1054:1975 250 to 10 000 magnifications	1% of range Minimum 0.20		A
Profile projectors	10 to 100 magnification Linear 0 to 300 Angular 0° to 360°	125 at the screen 15.0 3.0 minutes of arc		A, B
Electronic microprocessor controlled height gauges	0 to 1000	7.0		A, B
END				