

# Schedule of Accreditation

issued by

## United Kingdom Accreditation Service

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

 <p><b>0249</b></p> <p>Accredited to <b>ISO/IEC 17025:2017</b></p>	<h3>Threadmaster Gauges Limited</h3> <p><b>Issue No: 022    Issue date: 11 September 2025</b></p>	
	<p><b>Princes Drive</b> <b>Crackley Industrial Estate</b> <b>Kenilworth</b> <b>Warwickshire</b> <b>CV8 2FD</b></p>	<p><b>Contact: Mr R Ancliff</b> <b>Tel: +44 (0)1926-852428</b> <b>Fax: +44 (0)1926-850047</b> <b>E-Mail: sales@threadmastergauges.co.uk</b> <b>Website: www.threadmastergauges.co.uk</b></p>
<p><b>Calibration performed at the above address only</b></p>		

### Calibration and Measurement Capability (CMC)

Measured Quantity Instrument or Gauge	Range	Expanded Measurement Uncertainty ( $k = 2$ )	Remarks
<p>RANGE IN MILLIMETRES AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED</p>			
<b>LENGTH</b>			
Thread measuring cylinders	As BS 5590:1978 and specials 0.1 to 5 diameter	0.87 on diameter	Using a length measuring machine and end standards.
Plain plug gauges (parallel), cylindrical setting standards	1 to 50 diameter 50 to 100 diameter 100 to 150 diameter 150 to 200 diameter 200 to 300 diameter	0.87 1.0 1.5 2.0 3.0 } on diameter	Using a length measuring machine and end standards.
Plain plug gauges (taper)			Using a length measuring machine and end standards.
Taper up to 1 in 8 on diameter	3 to 50 diameter 50 to 100 diameter 100 to 150 diameter	2.0 3.0 4.0 } on diameter	
Taper above 1 in 8 and up to 1 in 3 on diameter	3 to 50 diameter 50 to 100 diameter 100 to 150 diameter	4.0 5.0 6.0 } on diameter	
	Step heights / lengths	3.9	By comparison with end standards.
Plain ring gauges (parallel)	10 to 50 diameter 50 to 100 diameter 100 to 150 diameter	1.7 1.8 2.0 } on diameter	Using a length measuring machine and end standards.
Plain ring gauges (taper)			Using a length measuring machine and end standards.
Taper up to 1 in 8 on diameter	10 to 50 diameter 50 to 100 diameter 100 to 150 diameter	3.0 4.0 5.0 } on diameter	
Taper above 1 in 8 and up to 1 in 3 on diameter	10 to 50 diameter 50 to 100 diameter 100 to 150 diameter	5.0 6.0 7.0 } on diameter	
	Step heights / lengths	3.9	By comparison with end standards.



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Measured Quantity Instrument or Gauge	Range	Expanded Measurement Uncertainty ( $k = 2$ )	Remarks
RANGE IN MILLIMETRES AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED			
LENGTH (cont'd)			
Screw plug gauges (parallel) including check and setting plugs See Note 4	1 to 100 diameter 100 to 300 diameter	3.2 5.0	} on pitch diameter Using a length measuring machine and end standards.
Screw plug gauges (taper) See Note 2	2 to 100 diameter 100 to 300 diameter	. 4.0 8.0	
Screw ring gauges (parallel) See Note 4	1 to 100 diameter 100 to 150 diameter 150 to 300 diameter	5.0 6.0 8.0	} on pitch diameter The 1 mm to 6 mm diameter range relates to functional test of size using check plugs. The rest of the range is determined using a length measuring machine and end standards.
Screw ring gauges (taper) See Note 2	6 to 150 diameter	7.0	
Screw pitch	0.2 to 8	1.5	Using a length measuring machine and end standards.
Screw flank angle	0° to 52°	5.0 minutes of arc	Using a projector
Screw thread adjustable caliper gauges (parallel) See Note 3	1 to 100 diameter	See Note 5	Using setting plugs.

NOTES

1. Calibration results may be given in imperial units of measurement where appropriate.
2. Single start, symmetrical thread forms only.
3. Single start symmetrical and asymmetrical thread forms only.
4. Single and multi-start symmetrical and asymmetrical thread forms
5. Functional test of size using setting plugs.

END



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**Appendix - Calibration and Measurement Capabilities**

**Introduction**

The definitive statement of the accreditation status of a calibration laboratory is the Accreditation Certificate and the associated Schedule of Accreditation. This Schedule of Accreditation is a critical document, as it defines the measurement capabilities, ranges and boundaries of the calibration activities for which the organisation holds accreditation.

**Calibration and Measurement Capabilities (CMCs)**

The capabilities provided by accredited calibration laboratories are described by the Calibration and Measurement Capability (CMC), which expresses the lowest measurement uncertainty that can be achieved during a calibration. If a particular device under calibration itself contributes significantly to the uncertainty (for example, if it has limited resolution or exhibits significant non-repeatability) then the uncertainty quoted on a calibration certificate will be increased to account for such factors.

The CMC is normally used to describe the uncertainty that appears in an accredited calibration laboratory's schedule of accreditation and is the uncertainty for which the laboratory has been accredited using the procedure that was the subject of assessment. The measurement uncertainty is calculated according to the procedures given in the GUM and is normally stated as an expanded uncertainty at a coverage probability of 95 %, which usually requires the use of a coverage factor of  $k = 2$ . An accredited laboratory is not permitted to quote an uncertainty that is smaller than the published measurement uncertainty in certificates issued under its accreditation.

**Expression of CMCs - symbols and units**

It should be noted that the percentage symbol (%) represents the number 0.01. In cases where the measurement uncertainty is stated as a percentage, this is to be interpreted as meaning percentage of the measurand. Thus, for example, a measurement uncertainty of 1.5 % means  $1.5 \times 0.01 \times q$ , where  $q$  is the quantity value.

The notation  $Q[a, b]$  stands for the root-sum-square of the terms between brackets:  $Q[a, b] = [a^2 + b^2]^{1/2}$