

# PROCEDURE FOR CALIBRATING, STANDARDIZING OR CHECKING EQUIPMENT

Revised 12/01, 3/11, 1/13

PROCEDURE #49

## Equipment Checked:

GYRATORY MOLDS, RAM HEADS & BASE PLATES

T 312, SD 318

## Purpose:

To provide instructions for checking the inside diameter of mold, the height of mold at room temperature, ram and base plate face diameters, flatness of the ram and base plates.

## Inspection Equipment Required:

1. Caliper readable to 0.01 mm and capable of measuring an inside diameter of 150.00 mm.
2. Caliper or ruler readable to 1 mm capable of measuring a height of 250 mm.

## Tolerance:

Tolerances can be found in the appropriate test method listed above.

## Procedure:

1. Measure and record the inside diameter of the mold three times at three different locations (Approximately 50 mm from the top of the mold, 100 mm from the top or bottom and 50 mm from the bottom). Average the three measurements and record the average inside diameter of the mold. The average must meet the specification tolerance. All measurements are recorded to the nearest 0.001 mm.
2. Measure and record the height of the mold in three equally spaced places. Average the three measurements and record the average height. The average must meet the specification tolerance. All measurements are recorded to the nearest 1 mm.
3. Measure and record the ram and base plate face diameters in three equally spaced areas. Average the three measurements and record the average ram and base plate face diameters. The average must meet specification tolerance. All measurements are recorded to the nearest 0.001 mm.
4. Observe ram heads and platen side of the mold to verify compliance with specifications.
5. Record the data and the date.