

Gauge Block Sets



Gauge Block Specifications:
 Metric: BS EN ISO 3650: 1999
 Inch: BS 4311: Part 1: 2007
 Each set is supplied with a UKAS 5 point Calibration Certificate
 Blocks are manufactured from specially selected high quality age hardened alloy steel
 Blocks are heat treated to HRC65/HV820
 High resistance to wear
 Supplied in a fitted wooden case

Metric Sets

Packed Weight and Dimensions

Code	Set Size	Type	Description	BS Grade	Din Grade	US Grade	Width mm	Height mm	Length mm	Weight Kilos
53-670-047	47 Piece	Metric	Workshop	2	2	3	167	65	313	2.6
53-670-087	87 Piece	Metric	Workshop	2	2	3	220	65	313	2.9
53-671-047	47 Piece	Metric	Inspection	1	1	2	167	65	313	2.6
53-671-087	87 Piece	Metric	Inspection	1	1	2	220	65	313	2.9

Inch Sets

Packed Weight and Dimensions

Code	Set Size	Type	Description	BS Grade	Din Grade	US Grade	Width mm	Height mm	Length mm	Weight Kilos
53-670-036	36 Piece	Inch	Workshop	2	2	3	172	65	211	1.65
53-670-081	81 Piece	Inch	Workshop	2	2	3	217	65	313	2.87
53-671-036	36 Piece	Inch	Inspection	1	1	2	172	65	211	1.65
53-671-081	81 Piece	Inch	Inspection	1	1	2	217	65	313	2.87

Set Type	Set Size	Pieces in Set	Range mm	Steps mm
Metric	47 Piece	1	1.005	
		20	1.01 – 1.20	0.01
		7	1.30 – 1.90	0.10
		9	1.0 – 9.0	1.0
		10	10.0 – 100.0	10.0
Metric	87 Piece	9	1.001 – 1.009	0.001
		49	1.01 – 1.49	0.01
		19	1.50 – 9.50	0.05
		10	10.0 – 100.0	10.0
Set Type	Set Size	Pieces in Set	Range inches	Steps inches
Inch	36 Piece	1	0.050	
		9	0.1001 – 0.1009	0.0001
		9	0.101 – 0.109	0.001
		9	0.110 – 0.190	0.010
		5	0.100 – 0.500	0.10
		3	1, 2, & 4	1.00
		Inch	81 Piece	9
49	0.101 – 0.149			0.001
19	0.050 – 0.950			0.05
4	1, 2, 3, & 4			1.00

Gauge Block Sets

UKAS Calibration Certificates

These sets are supplied complete with a UKAS Calibration Certificate issued by an approved Laboratory
The Calibration Certificate issued by the Laboratory indicates the date the set was originally calibrated
The calibrated set is deemed to be in isolation until it is sold to the eventual user as there will be no wear or change due to use

The eventual user should record the date of purchase and invoice number to establish when the instrument was first put into use

This date becomes the reference point and is used together with the frequency of the sets use to determine future recalibration dates

Care and Use

Always clean gauge blocks following their use

Wipe with a soft cloth or chamois avoiding direct finger contact with the gauge block

Replace the blocks in the case whilst still holding them with the cleaning cloth

When not in use the blocks should be coated with a rust preventative applied with a soft cloth

Return the coated blocks to their case whilst holding them with the cloth

Before use the blocks can be cleaned with a mineral spirit which will leave slight oily film on their surface and help prevent short term corrosion

The film left by the mineral spirit will not affect the use of the blocks

Blocks can be cleaned with alcohol however this will leave the blocks so clean they will be more susceptible to corrosion

When using alcohol take the necessary precaution as this can cause a fire hazard

Check blocks for burrs and nicks prior to wringing together

Do not leave blocks wrung together over night as this can cause damage to their surfaces when eventually parted

Be careful when handling blocks, do not drop or assemble above the open case as this will cause damage

Check that the instrument or equipment to be checked or set with the blocks for any burrs or nicks which may damage the blocks and cause incorrect readings during the procedure

Gauge Block Tolerance Specification Metric Sets BS EN ISO 3650: 1998 (E)

Size Range Stated in mm	Grade 2 Limit deviation of length at any point from nominal length Stated in microns	Grade 2 Tolerance for the variation in length Stated in microns	Grade 1 Limit deviation of length at any point from nominal length Stated in microns	Grade 1 Tolerance for the variation in length Stated in microns
0 - 10	0.45	0.3	0.2	0.16
10 - 25	0.6	0.3	0.3	0.16
25 - 50	0.8	0.3	0.4	0.18
50 - 75	1.0	0.35	0.5	0.18
75 - 100	1.2	0.35	0.6	2.0

Gauge Block Tolerance Specification Inch Sets BS 4311: part 1: 2007

Size Range Stated in inches	Grade 2 Limit deviation of length at any point from nominal length Stated in micro inches	Grade 2 Tolerance for the variation in length Stated in micro inches	Grade 1 Limit deviation of length at any point from nominal length Stated in micro inches	Grade 1 Tolerance for the variation in length Stated in micro inches
0 - 0.4	18	12	8	6
0.4 - 1.0	24	12	12	6
1.0 - 2.0	32	12	16	7
2.0 - 3.0	40	14	20	7
3.0 - 4.0	48	14	24	8