

# Selection of Linear & Diameter Measuring Equipment

Tools	Drawing Tolerance +/-					
	.0005 and Less	.00051 - .001	.0011 - .003	.0031 - .005	.0051 - .010	More than .010
Sunnen Bore Gage	•	•	•	•	•	•
Accubore	•	•	•	•	•	•
Fixed OD Micrometer	•	•	•	•	•	•
Precision Bore Gage	•	•	•	•	•	•
Trimos Height Gage	•	•	•	•	•	•
Mitutoyo Height Gage			•	•	•	•
Indical			•	•	•	•
Mueller			•	•	•	•
Thread Micrometer			•	•	•	•
Multi Anvil Std. Mic.			•	•	•	•
Depth Micrometer			•	•	•	•
Caliper – Digital & Dial				•	•	•
Caliper - Vernier				•	•	•
Telescoping Gages					•	•
Ball Gages					•	•
72" Calibrated Scale						•

1. The Optical Comparator shall be used for these drawing criteria.
  - Radius is equal to or less than +/- 1/32
  - Angle (including countersink) is equal to or less than +/- 1 degree
2. The following measuring equipment may be used for sampling purposes within production.
  - Vernier Bevel Protractor
  - Radius Gage
  - Countersink Gage
3. The following measuring equipment maybe used for final inspection.  
 (Any measuring equipment labeled "reference only" shall be calibrated prior to each use with a micrometer)
  - Thread Gage
  - Plug Gage
  - Plain Ring Gage
  - Precision Pins
  - Thread Wires used for 3-wire method
  - Gage Blocks
4. A Dial Indicator is only as accurate as it's setup, therefore if 3 or more pivot points (example: mag base) are used, it shall be considered as "reference only".
5. It is acceptable, when used flat, to use Scales and Tape Measures on "cut" raw material prior to production.