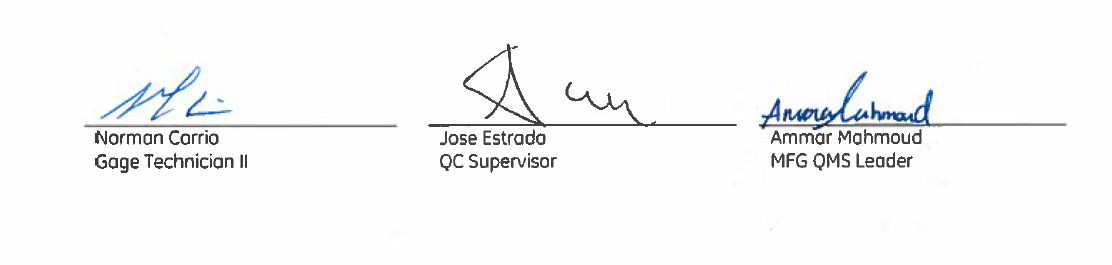
## 

## Approved By:



## Document Revision Chart

The following chart lists the revisions made to this document tracked by version. Use this to describe the changes and additions each time this document is re-published. The description should include as many details of the changes as possible.

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| --- | --- | --- | --- |
| **#.#** | **Section Modified and Revision Description** | **Date** | **Author** |
| 1.0 | All Initial Release | 12/19/2002 | Norman Carrio |
| 2.0 | Revised work instruction’s format. | 1/5/2015 | Ammar Mahmoud |
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Table of Contents

[1.0 Purpose 3](#_Toc405354862)

[2.0 Scope / Application 3](#_Toc405354863)

[3.0 Procedure 3](#_Toc405354864)

[4.0 Responsibilities 4](#_Toc405354865)

[5.0 Quality Records 4](#_Toc405354866)

[6.0 Terms, Definitions and Acronyms 4](#_Toc405354867)

[7.0 References 4](#_Toc405354868)

[8.0 Compliance Requirements 5](#_Toc405354871)

[9.0 Appendix / Attachments 5](#_Toc405354872)

# Purpose

* 1. To describe the requirements and the calibration process of the Dial Bore Gages

# Scope / Application

* 1. Dial bore gages are indicating type gages designed specifically to measure size, straightness, and roundness of internal diameters. Dial bore gages are manufactured in a variety designs, commonly using two or three point contact methods. Most two point contact dial bore gages utilize additional spring loaded expanding contacts which act as centralizers. Dial bore gages require presetting with ring gages or may be set using gage blocks with internal jaws.

# Procedure

* 1. Dial bore gages will to be checked for repeatability, smoothness of operation, and wear on the gaging contacts as outlined below.
     1. Set the dial bore gage using a precision setting ring or gage block gage with internal jaws. Zero the dial bore to zero and remove from the ring. Reinsert the dial bore into the ring and observe whether it still reads zero.
     2. Check for smoothness of operation by slowly depressing the gaging contact by hand to its maximum limits and release while observing the indicator. The motion of the indicator pointer should be smooth and uniform, returning to its original position without any evidence of sticking or binding at any point in either direction of travel.
     3. Check the gaging contacts for excessive wear or flat spots.
  2. Acceptance Limits:
     1. The dial bore gage must repeat to the set point within one unit of graduation. Sticking of the gage contacts or indicator will be cause for repair or replacement. There shall be no flat spots worn on the gaging contacts.
  3. Calibration Frequency:
     1. Six (6) months.

# Responsibilities

* 1. It’s the responsibility of the Gage lab technicians to ensure compliance to the requirements of section 3.0

# Quality Records

The following records produced by this procedure are considered Quality Records and shall be maintained and controlled according to the requirements in OGQ-0102 - Record Control:

Not applicable

# Terms, Definitions and Acronyms

Italicized terms have been defined in GE O&G Lexicon – Terms, Definitions and Acronyms. Their definitions have been repeated here for convenience purposes. In case of conflict GE O&G Lexicon will take precedence.

Not applicable

# References

* 1. QW-HTC-MFG-7.7.1-01 Gauge and Measuring device control maintenance and calibration
  2. MIL-STD-120
  3. Hydril CP02 & CP21

# Compliance Requirements

* Full compliance required by 01/30/2015

|  | GE Oil & Gas |
| --- | --- |
| Title: | Dial Bore Gages |
| Reference: | CP 16 |
| Revision: | 2.0 |
| Application Date: | 1-7-2015 |
| Expiration Date: | 1-7-2018 |
| Author: | Ammar Mahmoud |
| External References: |  |

# Appendix / Attachments

Not applicable