

ISO 3650:1998-12 (E)

Geometrical Product Specifications (GPS) - Length standards - Gauge blocks

| Contents | | Page |
|-----------------|---------------------------------------------------------------|-------------|
| 1 | Scope..... | 1 |
| 2 | Normative references..... | 1 |
| 3 | Definitions | 1 |
| 4 | Nomenclature of faces | 3 |
| 5 | Basis of measurement, traceability, reference condition | 4 |
| 5.1 | Unit of length: metre | 4 |
| 5.2 | Traceability of the length of a gauge block | 4 |
| 5.3 | Reference temperature and standard pressure | 4 |
| 5.4 | Reference orientation of gauge blocks | 5 |
| 6 | General dimensions, material properties, marking | 5 |
| 6.1 | General dimensions | 5 |
| 6.2 | Material properties | 5 |
| 6.2.1 | Material | 5 |
| 6.2.2 | Coefficient of thermal expansion..... | 6 |
| 6.2.3 | Hardness | 6 |
| 6.2.4 | Dimensional stability..... | 6 |
| 6.3 | Marking..... | 6 |
| 7 | Metrological requirements | 6 |
| 7.1 | General | 6 |
| 7.2 | Flatness tolerance, t_f | 7 |
| 7.2.1 | Gauge blocks with nominal lengths exceeding 2,5 mm..... | 7 |
| 7.2.2 | Gauge blocks with nominal lengths up to 2,5 mm..... | 7 |
| 7.3 | Measuring faces | 7 |
| 7.4 | Side faces..... | 7 |
| 7.4.1 | Flatness | 7 |
| 7.4.2 | Parallelism..... | 8 |
| 7.4.3 | Perpendicularity | 8 |
| 7.4.4 | Edges..... | 9 |
| 8 | Calibration of gauge blocks | 9 |
| 8.1 | General | 9 |
| 8.2 | Wringing test..... | 10 |
| 8.3 | Measurement by interferometry..... | 10 |
| 8.3.1 | Measured length | 10 |
| 8.3.2 | Auxiliary plate | 10 |
| 8.3.3 | Corrections to measurements by interferometry..... | 10 |
| 8.3.4 | Calibration certificate..... | 10 |
| 8.4 | Measurement by comparison..... | 11 |
| 8.4.1 | Principle of measurement | 11 |
| 8.4.2 | Central length | 11 |
| 8.4.3 | Method of determining length by comparison | 11 |
| 8.4.4 | Variation in length | 11 |
| 8.4.5 | Corrections | 12 |
| 8.4.6 | Calibration certificate..... | 12 |

| | |
|-------------------------------------------------------------------------------------------|-----------|
| Annex A (informative) Example of a device for the comparison of gauge blocks | 13 |
| Annex B (informative) Relation to the GPS matrix model | 14 |
| Annex C (informative) Bibliography | 15 |