


# Schedule of Accreditation

issued by

## United Kingdom Accreditation Service

21 - 47 High Street, Feltham, Middlesex, TW13 4UN, UK

 <p><b>UKAS</b> CALIBRATION <b>0583</b></p> <p>Accredited to <b>ISO/IEC 17025:2005</b></p>	<h3>Western Pegasus Ltd</h3> <p><b>Issue No: 007</b>      <b>Issue date: 31 January 2012</b></p>	
	<p><b>Unit 5</b> 747/751 Warwick Road Tyseley Birmingham B11 2HA</p>	<p><b>Contact: Mr R McKie</b> Tel: +44 (0)121-706 1231 Fax: +44 (0)121-706 8425 E-Mail: roger.mckie@westpeg.com Website: www.westpeg.com</p>
<p><b>Calibration performed at the above address only</b></p>		

### DETAIL OF ACCREDITATION

Measured Quantity Instrument or Gauge	Range	Calibration and Measurement Capability (CMC) Expressed as an Expanded Uncertainty ( $k=2$ )	Remarks
<p>RANGE IN MILLIMETERS AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED</p>			
<p>MASTER GEAR</p>			
<p><b>Spur</b></p>			
Bore Diameter	11 to 50 50 to 100	1.0 2.5	
End Face Squareness	25 to 100	1.0	
Tip Diameter	25 to 100 100 to 200	1.0 3.5	
Tip Radial Runout	25 to 200	1.0	
Dimension over Pins	25 to 100 100 to 200	5.0 7.5	
Tooth Profile	Overworking length of tooth (minimum base circle diameter. 20)	1.0 to 2.5 depending upon size	
Tooth Alignment	0 to 50 face width 50 to 100 face width	1.0 2.5	
Radial Runout of Reference Circle	50 to 100	1.0	
Adjacent Pitch	25 to 200 reference circle diameter	1.0	
Two Consecutive Pitches	25 to 200	1.0	
Cumulative Pitch	25 to 200 reference circle diameter	3.5	



0583  
Accredited to  
ISO/IEC 17025:2005

**Schedule of Accreditation**  
issued by  
**United Kingdom Accreditation Service**  
21 - 47 High Street, Feltham, Middlesex, TW13 4UN, UK

**Western Pegasus Ltd**  
**Issue No: 007 Issue date: 31 January 2012**

Calibration performed at main address only

Measured Quantity Instrument or Gauge	Range	Calibration and Measurement Capability (CMC) Expressed as an Expanded Uncertainty (k=2)	Remarks
RANGE IN MILLIMETERS AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED			
MASTER GEAR (cont'd)			
<b>Helical (Maximum 45)</b>			
Bore Diameter	12 to 50	1.0	
End Face Squareness	25 to 200	1.0	
Tip Diameter	5 to 100 100 to 200	1.0 3.5	
Tip Radial Runout	25 to 200	1.0	
Dimension over Balls	25 to 100 100 to 200	5.0 7.5	
Tooth Profile	Over working length of tooth (minimum base circle diameter 20)	1.0 to 2.5 depending upon size	
Tooth Lead	0 to 50 face width 50 to 100 face width (minimum base circle dia. 20)	1.0 2.5	
Radial Runout of Reference Circle	25 to 200	1.0	
Adjacent Pitch	25 to 200 reference circle diameter	1.0	
Two Consecutive Pitches	25 to 200 reference circle diameter	1.0	
Cumulative Pitch	25 to 200 reference circle diameter	3.5	
SPLINE GAUGES, INVOLUTE			
<b>Spur External including Taper Masters</b>			
Major Diameter	5 to 100 100 to 200	1.0 3.5	
Runout of Major Diameter with respect to Reference Circle Dia.	5 to 200	1.0	
Dimensions over Pins	From 5 up to 100 Above 100 up to 200	2.5 3.5	



0583  
Accredited to  
ISO/IEC 17025:2005

**Schedule of Accreditation**  
issued by  
**United Kingdom Accreditation Service**  
21 - 47 High Street, Feltham, Middlesex, TW13 4UN, UK

**Western Pegasus Ltd**  
**Issue No: 007 Issue date: 31 January 2012**

Calibration performed at main address only

Measured Quantity Instrument or Gauge	Range	Calibration and Measurement Capability (CMC) Expressed as an Expanded Uncertainty (k=2)	Remarks
RANGE IN MILLIMETERS AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED			
SPLINE GAUGES, INVOLUTE (cont'd)			
<b>Spur External including Taper Masters</b>			
Tooth Profile	Over working Length of Tooth (Minimum base circle dia. 20)	1 to 2.5 depending upon size	
Tooth Alignment	50 face width 50 up to 100 face width	1.0 2.5	
Adjacent Pitch	5 to 200 diameter	1.0	
Two Consecutive Pitches	5 to 200 diameter	1.0	
Cumulative Pitch	5 to 200 diameter	3.5	
<b>Helical External</b>			
Major Diameter	5 to 100 100 to 200	1.0 3.5	
Runout of Major Diameter with respect to Reference Circle Dia.	5 to 200 diameter	1.0	
Dimensions over Balls	5 to 100 100 to 200	5.0 6.0	
Tooth Profile	Over working length of tooth (Minimum base circle dia. 20)	1.0 to 2.5 depending upon size	
Tooth Lead	0 to 50 face width 50 up to 100 face width (minimum base circle diameter 20)	1.0 2.5	
Adjacent Pitch	5 to 200 diameter	1.0	
Two Consecutive Pitches	5 to 200 diameter	1.0	
Cumulative Pitch	5 to 200 diameter	3.5	



0583  
Accredited to  
ISO/IEC 17025:2005

**Schedule of Accreditation**  
issued by  
**United Kingdom Accreditation Service**  
21 - 47 High Street, Feltham, Middlesex, TW13 4UN, UK

**Western Pegasus Ltd**  
**Issue No: 007 Issue date: 31 January 2012**

Calibration performed at main address only

Measured Quantity Instrument or Gauge	Range	Calibration and Measurement Capability (CMC) Expressed as an Expanded Uncertainty (k=2)	Remarks
RANGE IN MILLIMETERS AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED			
SPLINE GAUGES, INVOLUTE (cont'd)			
<b>Spur Internal</b>			
Minor diameter	12 to 100	Even teeth 2.5    Odd teeth 3.5	
	100 to 200	3.5                    5.0	
Runout of minor diameter with respect to Reference Circle Dia.	12 to 200 diameter	1.0 to 2.5 depending upon size	
Dimension between Pins	12 to 100	2.5	
	100 to 200	5.0	
Tooth Profile	Over working length of tooth (minimum base circle dia. 20)	1.0 to 2.5 depending upon size	
Tooth Alignment	0 to 50 face width	1.0 to 2.5 depending upon size	
Adjacent Pitch	12 to 200 diameter	1.0	
Two Consecutive Pitches	12 to 200 diameter	1.0	
Cumulative Pitch	12 to 200 diameter	3.5	
<b>Helical Internal</b>			
Minor diameter	12 to 100	Even Teeth 2.5    Odd Teeth 3.5	
	100 to 200	3.5                    5	
Runout of minor diameter with respect to Reference Circle Dia.	12 to 200 diameter	2.5 to 3.5 depending upon size	
Dimension between Balls	12 to 100 diameter	5.0	
	100 to 200 diameter	7.5	
Tooth Profile	Over working length of tooth (minimum base circle dia. 20)	2.5	
Tooth Lead	0 to 100 Face width	2.5	
Adjacent Pitch	30 to 200 Diameter	1.0	
Two Consecutive Pitches	30 to 200 diameter	1.0	
Cumulative Pitch	30 to 200 diameter	3.5	



0583  
Accredited to  
ISO/IEC 17025:2005

**Schedule of Accreditation**  
issued by  
**United Kingdom Accreditation Service**  
21 - 47 High Street, Feltham, Middlesex, TW13 4UN, UK

**Western Pegasus Ltd**  
**Issue No: 007 Issue date: 31 January 2012**

Calibration performed at main address only

Measured Quantity Instrument or Gauge	Range	Calibration and Measurement Capability (CMC) Expressed as an Expanded Uncertainty (k=2)	Remarks
RANGE IN MILLIMETERS AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED			
<b>SPLINE GAUGES STRAIGHT SIDED</b>			
<b>Plug</b>			
Major diameter	10 to 100 diameter 100 to 200 diameter	1.0 3.5	
Minor diameter	10 to 100 diameter 100 to 200 diameter	1.0 3.5	
Runout of Major Diameter with respect to Minor Diameter		1.0	
Spline Width		1.0	
Tooth Alignment	0 to 50 face width 50 up to 100 face width	1.0 2.5	
Adjacent Pitch	30 to 200	1.0	
Two Consecutive Pitches	30 to 200	1.0	
Cumulative Pitch	30 to 200	3.5	
<b>Ring</b>			
Major Diameter	12 to 50 diameter 50 to 100 diameter 100 to 200 diameter	Even Teeth 2.5 3.5 5.0	Odd Teeth 3.5 5.0 7.5
Minor Diameter	12 to 50 diameter 50 to 100 diameter 100 to 200 diameter	2.5 3.5 5.0	3.5 5.0 7.5
Runout of Major Diameter with respect to Minor Diameter	12 to 200 diameter	2.5	
Spline Width		1.0 to 2.5 depending upon size	
Tooth Alignment	0 to 50 face width	1.0	
Adjacent Pitch	30 to 200 diameter	1.0	
Two consecutive Pitches	30 to 200 diameter	1.0	
Cumulative Pitch	30 to 200 diameter	3.5	



0583  
Accredited to  
ISO/IEC 17025:2005

**Schedule of Accreditation**  
issued by  
**United Kingdom Accreditation Service**  
21 - 47 High Street, Feltham, Middlesex, TW13 4UN, UK

**Western Pegasus Ltd**  
**Issue No: 007 Issue date: 31 January 2012**

Calibration performed at main address only

Measured Quantity Instrument or Gauge	Range	Calibration and Measurement Capability (CMC) Expressed as an Expanded Uncertainty (k=2)	Remarks
RANGE IN MILLIMETERS AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED			
<b>SERRATION GAUGES STRAIGHT SIDED</b>			
<b>Plug</b>			
Major Diameter	6 to 100 diameter 100 to 150 diameter	1.0 3.5	
Runout of Major Diameter with respect of Serration's		1.0	
Dimension over Pins	6 to 75 diameter 75 to 150 diameter	1.0 3.5	
Dimension across Flats (90 Serration's only)	3 to 100 diameter 100 to 150 diameter	1.0 2.0	
Angular measurement of Serration's	As BS 2059		
Fine Serration's	13 to 25 diameter	20 minutes of arc	
Serration's	25 to 75 diameter 75 to 150 diameter	15 minutes of arc 10 minutes of arc	
Tooth Pitch	0 to 50 face width 50 to 100 face width	1.0 2.5	
Adjacent Pitch	6 to 150 diameter	1.0	
Two Consecutive Pitches	6 to 150 diameter	1.0	
Cumulative Pitch	6 to 150 diameter	3.5	
<b>Ring</b>			
Minor Diameter	6 to 100 diameter 100 to 150 diameter	Even Teeth 2.5 Odd Teeth 3.5 3.5 5.0	
Dimension under Pins	6 to 100 diameter 100 to 150 diameter	2.5 5.0	
Dimension across Flats (90 Serration's only & even Teeth only)	6 to 100 diameter 100 to 150 diameter	2.5 3.5	
Angular Measurement of Serration's	As BS 2059		
Fine Serration's	6 to 25 diameter	20 minutes of arc	



0583  
Accredited to  
ISO/IEC 17025:2005

**Schedule of Accreditation**  
issued by  
**United Kingdom Accreditation Service**  
21 - 47 High Street, Feltham, Middlesex, TW13 4UN, UK

**Western Pegasus Ltd**  
**Issue No: 007 Issue date: 31 January 2012**

Calibration performed at main address only

Measured Quantity Instrument or Gauge	Range	Calibration and Measurement Capability (CMC) Expressed as an Expanded Uncertainty (k=2)	Remarks
RANGE IN MILLIMETERS AND UNCERTAINTY IN MICROMETRES UNLESS OTHERWISE STATED			
SERRATION GAUGES STRAIGHT SIDED (cont'd)			
<b>Ring</b> (cont'd)			
Serration's	25 to 75 diameter 75 to 150 diameter	15 minutes of arc 10 minutes of arc	
Runout of Minor Diameter with respect of Reference Band	6 to 150 diameter	2.5	
Tooth Alignment	0 to 50 face width	2.5	
Adjacent Pitch	30 to 150 diameter	1.0	
Two Consecutive Pitches	30 to 150 diameter	1.0	
Cumulative Pitch	30 to 150 diameter	3.5	
END			