

NATIONAL PHYSICAL LABORATORY

METROLOGY CENTRE

Ref: MOY/SCMI/2A SPECIFICATION OF ACCURACY  
(Issue 2)

for

**A TABLE CENTRING AND WORK LOCATING ATTACHMENT**

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Designed by: Optical Measuring Tools Ltd. for use on the OMT Toolmaker's Microscope.  
(see MOY/SCMI/2).

LIMITING VALUE OR  
MAXIMUM  
PERMISSIBLE ERROR

1. GENERAL

- 1.1 The vee groove of the attachment shall be a good fit in the corresponding vee groove of the work-table as revealed by a blueing test.
- 1.2 When the attachment is assembled on the work-table it shall be free from rock.
- 1.3 The attachment shall have an identification number which shall be the same as the Toolmaker's Microscope with which it is associated.

2. ALIGNMENTS

- 2.1 The datum faces shall be: -
  - (i) Flat 0.0025 mm (0.0001 in)
  - (ii) Mutually square 0.0025 mm per 25 mm  
(0.0001 in per in)
  - (iii) Square to the upper surface of the work-table 0.0025 mm per 25 mm  
(0.0001 in per in)
- 2.2 The datum face adjacent to the locating vee of the attachment shall be parallel to the axis of the vee. 0.0025 mm per 50 mm  
(0.0001 in per 2 in)
- 2.3 The graticule lines shall be parallel to the appropriate datum face. 0.0015 mm (0.000 06 in)  
over the length of the  
graticule lines
- 2.4 The graticule lines shall be symmetrically disposed with respect to the axis of rotation of the work-table of the associated Toolmaker's Microscope. 0.0025 mm (0.0001 in)

LIMITING VALUE OR  
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2.5 The distance from the appropriate datum face to the centre of the graticule lines shall be measured and quoted to the nearest 0.0025 mm (0.0001 in)

(Signed) *F. W. Nichols*

for Director

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*JAP*