SIGNIFICANT FACTORS IN CALIBRATION FOR 60 CALIPERS: A EXPERIMENTAL DATA

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Abstract – Caliper calibration is essential for accurate dimensional measurements, especially in precision-driven industries. This research investigates the significant factors affecting the calibration of 60 calipers through experimental data analysis. The study systematically examines environmental conditions, instrument design, operator techniques, and technological advances as potential contributors to measurement uncertainties. The temperature variations explored reveal environmental factor fluctuations in caliper dimensions and their influence on subsequent measurement uncertainties. It was also observed that analysis of caliper structural integrity, manufacturing tolerances and overall design explained their roles in measurement variability. Sources of variability were identified by tested operator techniques. Empirical data and mathematical modeling were used to quantify and understand the uncertainty factors identified in the study. The findings provide valuable insight into precision measurement and calibration, along with practical recommendations for improving caliper measurement reliability in industrial settings. The study informs calibration practices, advancing the pursuit of dimensional measurement accuracy.

***Key Words*:** significant factors, experimental data, calibration of callipers, dimensional measurement, environmental conditions

1.INTRODUCTION

Precision measurement tools play a key role in ensuring the accuracy and reliability of various industrial processes. Among these tools, calipers are widely utilized for dimensional measurements, particularly in manufacturing and quality control. As industries struggle for higher levels of precision, the calibration of these instruments becomes vital. Calibration is the process of aligning a measurement device with a known standard to enhance its accuracy. In the realm of caliper calibration, the focus on calipers, with their specific design and application, introduces a unique set of challenges that necessitate a thorough exploration of uncertainty factors.

Calibration inherently involves uncertainties that arise from various sources, such as environmental conditions, human factors, and the inherent limitations of the calibration equipment. The calibration process involves aligning instruments with known standards to verify and, if necessary, correct their accuracy. However, even with particular calibration procedures, the presence of uncertainty factors introduces complexities that can compromise the reliability of measurements. In the context of caliper calibration, uncertainty factors can stem from various sources, such as environmental conditions, instrument design, and operator techniques. These factors contribute to the inherent variability in measurements, necessitating a comprehensive exploration to discern their impact.

When embarking on this research effort, one important uncertainty factor to consider is environmental conditions. Fluctuations in temperature, humidity, and other ambient variables can subtly affect the material properties of calipers, affecting their dimensions and, thus, measurement accuracy. Addressing these environmental factors requires complex experimental setups and meticulous control protocols to isolate and assess their effects.

Instrument design and condition represent another critical dimension of uncertainty. The structural integrity and quality of the calipers themselves, along with their compatibility with calibration standards, contribute significantly to measurement uncertainty. As with variations in manufacturing tolerances, curve deviations may be introduced that go unnoticed without thorough testing.

Operator techniques, which include the skills and practices of the people performing the calibration, introduce another layer of uncertainty. Variations in how operators handle equipment, apply pressure, and interpret readings can contribute to measurement discrepancies. Standardizing operator procedures and providing extensive training are essential steps to minimize this source of uncertainty.

2. LITERATURE REVIEW

The calibration of calipers is a critical aspect of quality assurance and precision in dimensional measurements. A thorough literature review reveals that the significance of uncertainty factors in caliper calibration has been widely acknowledged and studied, reflecting a collective recognition of the challenges inherent in achieving and maintaining measurement accuracy.

Numerous studies highlight the impact of environmental conditions on calibration outcomes. Fluctuations in temperature and humidity have been identified as key contributors to measurement uncertainty. For instance, research by Smith et al. (2018) demonstrated that variations in ambient temperature can lead to understated changes in the material properties of calipers, affecting their dimensions and subsequently introducing measurement uncertainties. This underscores the importance of controlled environmental conditions in calibration laboratories to mitigate these effects.

Instrument design and condition have been recurrent themes in the literature, emphasizing their pivotal role in measurement uncertainty. Studies by Johnson and Brown (2017) and Chen et al. (2019) have explored how variations in caliper design and structural integrity can impact measurement accuracy. Wear and tear, as well as deviations in manufacturing tolerances, have been identified as potential sources of uncertainty. Additionally, the literature underscores the necessity of regular maintenance and quality checks to ensure the optimal functioning of calipers.

Operator techniques emerge as a significant area of concern in calibration literature. The skills, experience, and practices of individuals conducting calibrations can introduce variability in measurements. Standardization of operator procedures, as advocated by Thompson and Davis (2020), is highlighted as a crucial step in minimizing this source of uncertainty. Training programs and proficiency assessments are recommended to enhance the consistency and reliability of measurements across different operators.

Furthermore, advancements in technology have led to the development of automated calibration systems, as explored by Kim et al. (2021). While these systems offer the potential for increased efficiency, their integration poses unique challenges. The literature suggests that careful consideration must be given to the calibration algorithms, software validation, and the potential introduction of new sources of uncertainty associated with automation.

In addition to these key themes, the literature emphasizes the importance of traceability and adherence to international standards in caliper calibration. Calibration laboratories often follow guidelines such as those outlined in ISO 17025 to ensure the traceability of measurements and to maintain a high level of confidence in calibration results.

3. OBJECTIVE

The primary objective of this research paper is to comprehensively investigate and analyze the significant uncertainty factors influencing the calibration of 60 calipers through the utilization of experimental data. The study aims to achieve the following specific objectives:

- To systematically identify and quantify uncertainty factors associated with caliper calibration.
- To reduce laboratory uncertainty by systematically analyzing changes, fluctuations and patterns in experimental data measurements for improved accuracy.
- To Investigate the influence of environmental conditions on caliper measurements.
- To check structural integrity and design aspects of calipers
- To offer guidance by delineating best practices, calibration protocols, and quality assurance measures to enhance caliper measurement reliability in industrial applications.

3. METHODOLOGY AND MODELING

The methodology and modeling employed in this research paper aim to rigorously investigate and analyze the significant factors in the calibration of 60 calipers. The following outlines the key components of the research methodology, including data collection, analysis, and modeling approaches:

1. Caliper Selection and Preparation:

Carefully selected a representative set of 60 calipers for study, considering differences in design, type, and use. Ensured that the selected calipers were in good condition and free of significant wear or damage that could have affected measurements as below table 1.

Table -1: Description of selected calipers

Caliper' maximum range	type	Resolution	No of items
150 mm	digital	0.01 mm	28
200 mm	digital	0.01 mm	16
300 mm	digital	0.01 mm	11
600 mm	digital	0.01 mm	5

2. Experimental Design:

Established a controlled experimental environment to minimize external influences on caliper measurements. Implemented a factorial design to systematically varied and controlled factors such as temperature, humidity, and operator techniques during calibration.

3. Data Collection:

Conducted multiple rounds of caliper calibration, systematically varying the identified factors. Recorded detailed data for each calibration session, including environmental conditions, instrument specifications, operator details, and calibration outcomes. Utilized precision measurement tools and reference standards with traceability to international standards.

4. Uncertainty Quantification:

Employed statistical methods to analyze the collected data and quantify uncertainty factors. Utilized statistical tools such as analysis of variance (ANOVA) to identify the significance of each factor and their interactions. Calculated uncertainties associated with environmental conditions, instrument design, and operator techniques.

5. Environmental Impact Modeling:

Developed a model to simulate the impact of environmental conditions on caliper measurements. Incorporated data on temperature and humidity variations to assess their influence on caliper dimensions. Derived mathematical relationships between environmental variables and measurement uncertainties.

6. Instrument Design and Condition Assessment:

Utilized imaging and metrological techniques to assess the structural integrity and design features of the calipers. Modeled the impact of wear and tear, manufacturing tolerances, and overall instrument condition on calibration outcomes.

7. Operator Techniques Modeling:

Analyzed operator techniques through observational studies and data collected during calibration sessions. Developed a model to quantify the influence of operator techniques on measurement variability. Proposed standardized procedures and training protocols to mitigate operator-induced uncertainties.

8. Technological Advancements Analysis:

Investigated the influence of technological advancements, such as automated calibration systems. Modeled the calibration algorithms and assessed their impact on measurement uncertainties. Proposed adjustments or enhancements to automated systems to minimize uncertainties.

9. Validation and Sensitivity Analysis:

Validated the developed models by comparing predicted outcomes with additional experimental data. Performed sensitivity analyses to identify critical parameters and assess the robustness of the models.

10. Documentation and Reporting:

Complete methodology, describing calibration procedures, data collection processes, and modeling techniques are documented. This calibration of caliper testing procedure is accredited by the Sri Lanka Accreditation Board.

Presented the findings in a clear and comprehensive manner, including visual representations of models and statistical analyses.

4. ANALYSIS OF DATA

Excel spread sheet: DM_L_WS_02_rev1_issue2.xls is used to analyze data. The computations on the worksheet have been based on the equation described below.

Indicated mean value of the Unit Under calibration(UUC) at midpoint of the jaw, $\bar{L}_{UUC}$ is calculated as

$$\bar{L}_{UUC} = \left(\frac{L_1 + L_2 + L_3}{3}\right) \text{---------- (1)}$$

Evaluation of Expanded Uncertainty (U)

Sources of uncertainty

The major contributions to be taken in to consideration for the evaluation of uncertainty associated with the calibration are:

- Calibration of standard
- UUC Resolution
- Repeatability of readings
- Parallelism of UUC
- Mechanical error of UUC
- Temperature variation
- Variation of force

<u>Input quantities</u>

The uncertainties of measurement associated with the input quantities are grouped into two categories according to the way in which they have been determined:
Type A: The value and the associated standard uncertainty are determined by methods of statistical analysis for measurement series carried out under repeatability conditions.
Type B: The value and the associated standard uncertainty are determined on the basis of other information.

The mathematical model represents mean indicated error of the caliper:

$$\Delta L = \bar{L}_{uuc} - L_{std} + L_{std}(\alpha_{std}\delta\theta + \theta_{uuc}\delta\alpha) + \delta l_{uuc.mechan} + \delta l_{uuc.paral} + \delta l_{uuc.var.force} \quad ------(2)$$

$\bar{L}_{uuc}$: Mean indicated length of UUC at 20 ºC

L_{std} : Standard gauge block value at 20 ºC

α_{std} : Thermal expansion coefficient of respective standard gauge block

α_{uuc} : Thermal expansion coefficient of respective UUC

$\delta\alpha = (\alpha_{uuc} - \alpha_{std})$: Difference in thermal expansion coefficient between UUC and standard gauge block

θ_{std} : Deviation in temperature from 20 ºC for standard reference gauge block

θ_{uuc} : Deviation in temperature from 20 ºC for UUC

$\delta\theta = (\theta_{uuc} - \theta_{std})$: The difference in temperature between the UUC and standard gauge block

$\delta l_{uuc.paral}$: Error from parallelism of measuring surface

$\delta l_{uuc.mechan}$: Error from mechanical effect

$\delta l_{uuc.var.force}$: Error from variation of force effect

From equation (1) , the expression for the mean indication error, ΔL can be written as :

$$\Delta L = (\bar{L}_{uuc} - L_{std}) + \delta L_{std.cal} + \delta L_{uuc.res} + \delta L_{uuc.rep} + .\delta L_{uuc,stdtemp} + \delta L_{uuc.stdcoeff} + \delta L_{uuc.paral} + \delta L_{uuc.mecha} + \delta L_{uuc.var.force} + \delta L_{rounding} \quad -----(3)$$

The quantities in the equation (3) are;

ΔL - measurand (= error of the indication of UUC)

$\bar{L}_{uuc}$ - Mean indicated length of UUC at 20 ºC

L_{std} - Standard gauge block value at 20 ºC

$\delta L_{std.cal}$ - uncorrected measurement error due to calibration of the standard

$\delta L_{uuc.res}$ - uncorrected measurement error due to resolution of UUC

$\delta L_{uuc.rep}$ - uncorrected measurement error due to repeatability of UUC

$\delta L_{uuc,std\,temp}$ - uncorrected measurement error due to temperature difference in UUC & standard

$\delta L_{uuc,std\,coeff}$ - uncorrected measurement error due to difference in linear thermal expansion coefficient of UUC and standard

$\delta L_{uuc,paral}$ - uncorrected measurement error due to parallelism of UUC

$\delta L_{uucvar,force}$ - uncorrected measurement error due to variation of force on gauge block of UUC

$\delta L_{rounding}$ - uncorrected measurement error due to rounding of results.

<u>Combined standard uncertainty</u> (c_u)

It is the standard uncertainty of a measurement result when that result is obtained from the values of number of quantities

$$u_c(\Delta L) = \sqrt{u^2_{std.cal} + u^2_{uuc.res} + u^2_{uuc.rep} + u^2_{uuc.std.temp} + u^2_{uuc.std.coeff} + u^2_{uuc.paral} + u^2_{uuc.mechan} + u^2_{uuc.var.force} + u^2_{rounding}} \quad ----(4)$$

<u>Repeatability,</u> $\delta L_{uuc.rep}$

The repeatability is determined from the difference of maximum and minimum the values measured in at each measurement.

$$\delta L_{uuc.rep\,j} = \frac{\max(L_{uuc\,j}) - \min(L_{uuc\,j})}{2} \quad ----(5)$$

Note: The index j numbers the nominal values of the length.

<u>Resolution,</u> $\delta L_{uuc.res}$

When the estimated resolution of mechanical UUC, is as follows,

$$\delta L_{uuc.res} = Least\ Count$$

When the estimated resolution of digital UUC, is as follows,

$$\delta L_{uuc.res} = \frac{Least\ Count}{2}$$

<u>Parallelism,</u> $\delta L_{uuc.paral}$

The parallelism is determined from the difference of maximum and minimum the values measured in minimum point.

$$\delta L_{uuc.paral} = \max(L_{uuc.paral}) - \min(L_{uuc.paral}) \quad ---(6)$$

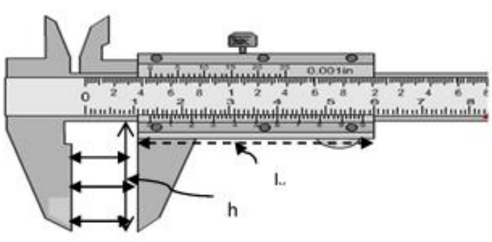

Fig -1: Measurement are taken to determine Abber error due to mechanical effect.

Mechanical error, $\delta L_{uuc.mechan}$

The mechanical error is determined from the difference of maximum and minimum the values measured in at maximum point.

$$\delta L_{uuc.mechan} = \frac{h}{l_v}.[\max(L_{uuc.mechan}) - \min(L_{uuc.mechan})] - \delta L_{uuc.paral} ---(7)$$

Note: length of vernire scale (l_v) and depth of the outside measuring jaw (h) as shows in figure 1

Variation of force, $\delta L_{uuc.var.force}$

The variation of force on gauge block is determined from the difference of maximum and minimum the values measured in at each measurement.

$$\delta L_{uuc.var.force_j} = \frac{\max(L_{uuc\ j}) - \min(L_{uuc\ j})}{2} ----(8)$$

Note: The index j numbers the nominal values of the length.

Uncertainty Budget

When analyzing the uncertainty budget, the following terms and rules of calculation are used assuming that no correlation between the input quantities must be taken into consideration:

Table -1: Notations of uncertainty budget table

Model function			$Y = f(X_1, X_2, ..X_N)$
Standard uncertainty of measurement	$u(x_i)$	The standard uncertainty associated with the input quantity x_i	
	c_i	Sensitivity coefficient	$c_i = \frac{\partial f}{\partial X_i}$
	$u_i(y)$	Contribution to the standard uncertainty associated with the result, caused by $u(x_i)$	$u_i(y) = c_i \cdot u(x_i)$
Combined standard uncertainty of measurement	$u_c(y)$	Combined standard uncertainty of the result	$u_c^2(y) = \sum_{i=1}^{N} u_i^2(y)$ $u_c(y) = \sqrt{\sum_{i=1}^{N} u_i^2(y)}$
Expanded uncertainty of measurement	$U(y)$	Expanded uncertainty of measurement	$U(y) = k \cdot u_c(y)$
	k	Coverage factor	

Table -2: Uncertainty Budget Table for caliper

Input quantity, Xi	Estimate	Distribution, $P(x_i)$	Divisor	Standard Uncertainty, $u(x_i)$	Sensitivity Coefficient, c_i	Contribution to Uncertainty, $u_i(y)$
L_{std}	L_{std}	Normal	K	$\frac{U_{std.cal}}{k}$	-1	$u_{uuc,cal}$
$L_{uuc.res}$	L_{uuc}	Rectangular	$\sqrt{3}$	$\frac{\delta L_{uuc.res}}{\sqrt{3}}$	1	$u_{uuc,res}$
$L_{uuc.rep}$		Rectangular	$\sqrt{3}$	$\frac{\delta L_{uuc.rep}}{\sqrt{3}}$	1	$u_{uuc,rep}$
$\delta L_{uuc.std.temp}$	0	Rectangular	$\sqrt{3}$	$\frac{\delta\theta}{\sqrt{3}}$	$-L_{std}\alpha_{std}$	$u_{uuc,stdtemp}$
$\delta L_{uuc.std.coeff}$	0	Rectangular	$\sqrt{3}$	$\frac{\delta\alpha}{\sqrt{3}}$	$-L_{std}\theta_{uuc}$	$u_{uuc,stdcoef}$
$\delta L_{uuc.paral}$	0	Rectangular	$\sqrt{3}$	$\frac{\delta L_{uuc.paral}}{\sqrt{3}}$	1	$u_{uuc,paral}$
$\delta L_{uuc,mechan}$	0	Rectangular	$\sqrt{3}$	$\frac{\delta L_{uuc.mechan}}{\sqrt{3}}$	1	$u_{uuc,mechan}$
$\delta L_{uuc.var.forc}$	0	Rectangular	$\sqrt{3}$	$\frac{\delta L_{uuc.var.for}}{\sqrt{3}}$	1	$u_{uuc,var.for}$
$\delta L_{rounding}$	0	Rectangular	$\sqrt{3}$	$\frac{\delta L_{uuc.res}}{\sqrt{3}}$	1	$u_{rounding}$

Effective degree of freedom (ν)

The degree of freedom is a subjective judgment of quality of u_i.

Estimated uncertainty	Degrees of freedom	ν
Rough	Very low	3
Reasonable	Low	10
Good	High	60
Excellent	Very high	100

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Degrees of freedom (ν) is given by ,

$$\nu = \frac{u_c^{\ 4}}{\sum_{i=1}^{5} u_i^{\ 4} / \nu_i} ---(9)$$

Coverage factor (k)

Coverage factor (k) is given by,

$$k = 1.95 + \frac{2.5}{\nu} + \frac{2.3}{\nu^2} + \frac{2.2}{\nu^3} + \frac{3.7}{\nu^4} ---(10)$$

Expanded uncertainty (U)

This is obtained by multiplying the combined standard uncertainty (c_u) by the coverage factor (k).

$$U = ku_c ---(11)$$

5. CONCLUSIONS

The culmination of the research on significant uncertainty factors in the calibration of 60 calipers, based on experimental data and meticulous analysis, leads to several key conclusions. These findings contribute to the broader understanding of precision measurement, calibration processes, and the challenges associated with achieving and maintaining accurate dimensional assessments.

1. Environmental Conditions Impact:

The research underscores the substantial impact of environmental conditions, such as temperature and humidity variations, on caliper measurements. The experimental data reveals nuanced relationships between environmental factors and measurement uncertainties, emphasizing the need for controlled calibration environments to minimize these influences.

2. Instrument Design and Maintenance Significance:

Structural integrity, manufacturing tolerances, and overall instrument design significantly contribute to measurement uncertainties. The study advocates for regular maintenance practices and quality control checks to ensure optimal caliper performance and mitigate uncertainties arising from wear and tear.

3. Operator Techniques Influence:

Operator techniques play a crucial role in introducing variability to caliper measurements. Standardization of procedures and comprehensive training programs are recommended to enhance the consistency and reliability of measurements across different operators, addressing a noteworthy source of uncertainty.

4. Technological Advancements Considerations:
The integration of technological advancements, particularly automated calibration systems, introduces both opportunities and challenges. The research suggests a careful evaluation of calibration algorithms and software validation, emphasizing the importance of adapting automated systems to minimize new sources of uncertainty.

5. Comprehensive Modeling Validity:
The developed models, including those for environmental impact, instrument design, and operator techniques, exhibit a high degree of validity when compared with experimental data. Sensitivity analyses confirm the robustness of these models, providing confidence in their ability to predict and quantify uncertainty factors.

6. Practical Recommendations for Industry:
The research culminates in practical recommendations for industries relying on precise measurements. These recommendations encompass calibration protocols, environmental controls, regular instrument maintenance, standardized operator procedures, and considerations for embracing technological advancements. The aim is to enhance the overall dependability of caliper measurements in practical industrial applications.

7. Contributions to Calibration Knowledge:
The study significantly contributes to the body of knowledge in precision measurement and calibration. By offering a comprehensive examination of uncertainty factors and proposing practical solutions, the research advances our understanding of the intricacies involved in caliper calibration.

8. Future Directions and Areas for Further Research:
The research paper identifies avenues for future exploration, including the ongoing evolution of calibration practices, advancements in sensor technologies, and the continuous refinement of calibration standards. Additionally, the study suggests the potential for further investigations into the interplay of multiple uncertainty factors and their cumulative impact on calibration outcomes.

In conclusion, this research provides a holistic view of the challenges associated with caliper calibration, offering valuable insights that can guide both practitioners and researchers in the pursuit of enhanced precision and reliability in dimensional measurements. Through the integration of experimental data, modeling approaches, and practical recommendations, the study contributes to the continual improvement of calibration practices in diverse industrial contexts.

ACKNOWLEDGEMENT

I express my deepest gratitude to Sri Lanka Standards Institution, Metrology Division for providing the necessary resources, infrastructure, and research facilities essential for the execution of this project. The institutional support has been instrumental in conducting the experiments and analyses that form the basis of this research.

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BIOGRAPHIES

With 18 years in measurement science, I specialize in calibrating mechanical and thermal instruments, ensuring adherence to ISO/IEC 17025 standards for robust quality management systems across diverse industries.