

## SCOPE OF ACCREDITATION

**J AND K MEASURING SERVICES INC.**  
**385 Red Maple Road, Unit #5**  
**Richmond Hill, ON**  
**L4C 6P4**

Accredited Laboratory No. 407  
(Conforms with requirements of CAN-P-4E (ISO/IEC 17025:2005))

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CLIENTS SERVED: All interested parties

FIELDS OF TESTING: Mechanical/Physical

ISSUED ON: 2009-11-03

VALID TO: 2013-12-05

### **MACHINERY**

#### **Transportation, Agricultural and Construction Vehicles and Components:**

**Automobiles, Light Trucks, Vans & Trailers**

**(Coordinate Measuring Machine Service)**

**(Coordinate Measurements) (Manufactured Metal Components) (Jigs & Fixtures)**

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**(COORDINATE MEASUREMENTS)**

Parameter	Range	Best Measurement Capability expressed as an Uncertainty ( $\pm$ )  See Notes: 1 & 2	Remarks
<b><u>Length (L)</u></b>			
Three-dimensional	900 1400 900 mm  X Y Z	$10_{-3} (12 + 8 \cdot L) [\mu\text{m}]$  Note: L in "metres"	
Three-dimensional	35.4 55.1 35.4 in  X Y Z	$10_{-4} (4.72 + 0.08 \cdot L) [\text{in}]$  Note: L in "inches"	
Two-dimensional	Any two of the above axes	$10_{-3} (6.7 + 6 \cdot L) [\mu\text{m}]$  Note: L in "metres"	
Two-dimensional	Any two of the above axes	$10_{-4} (2.63 + 0.06 \cdot L) [\text{in}]$  Note: L in "inches"	
One-dimensional	Any one of the above axes		

		$10_{-3} (5 + 4 \cdot L) [\mu\text{m}]$ Note: L in "metres"	
One-dimensional	Any one of the above axes	$10_{-4} (1.97 + 0.04 \cdot L) [\text{in}]$ Note: L in "inches"	

**(MANUFACTURED METAL COMPONENTS)**

Parameter/Product	Range	Best Measurement Capability expressed as an Uncertainty ( $\pm$ )	Remarks
		See Notes: 1, 2, 4	
<b><u>Length (L)</u></b>			
Manufactured metal Components (Sheet Metal)	900 1400 900 mm X Y Z	U=16.5 + 10.5 L [ $\mu$ m] Note: Where L in meters	See Note: 5
Manufactured metal Components (Sheet Metal)	35.4 55.1 35.4 in X Y Z	U=(.650 + .0105 L) 10-3 [in] Note: Where L in inches	See Note: 5
<b>(JIGS &amp; FIXTURES - Used for the inspection of manufactured components &amp; assemblies.)</b>			
Parameter/Product	Range	Best Measurement Capability expressed as an Uncertainty ( $\pm$ )	Remarks
		See Notes: 1 & 2	
<b><u>Length (L)</u></b>			
Jigs & Fixtures See Note: 2	900 1400 900 mm X Y Z	U=9 + 18.3 L [ $\mu$ m] Note: Where L in meters	See Note: 3
Jigs & Fixtures See Note: 2	35.4 55.1 35.4 in X Y Z	U=(.354 + .0183 L) 10-3 [in] Note: Where L in inches	See Note: 3

Notes:

1. Represents an Expanded Uncertainty using a coverage factor,  $k=2$
  
2. The *Best Measurement Capability* listed can be achieved only if the items being measured are suitable for such measurement.
  
3. Service includes, but is not limited to: net and datum pads, tooling balls, bushings, pins (made of steel) and contoured profiles (made of aluminum). Components listed above are mounted on aluminum base.
  
4. *ISO/TS 14253-2 Geometrical Product Specifications (GPS)-Inspection by measurement of workpieces and measuring equipment- Part 2: Guide to the estimation of uncertainty in GPS measurement, in calibration of measuring equipment and in product verification* was used as a reference document.
  
5. Service includes, but is not limited to: holes, contoured profiles and trim edges.

**Notes:**

**CAN-P-4E (ISO/IEC 17025):** General Requirements for the Competence of Testing and Calibration Laboratories (ISO/IEC 17025-2005)

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S. Cross, Director, Conformity Assessment

Date: 2009-11-03

Number of Scope Listings: 3

SCC 1003-15/525

Partner File #0

Partner: None