

Standard Operating Procedure Digital Inclinometer Calibration	SOP No. 6.008
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- 1 Purpose
  - 1.1 To establish a standard procedure for calibrating digital inclinometers (i.e. SmartLevel) used to measure and verify piping slope.
- 2 Scope
  - 2.1 This procedure applies to all digital inclinometers used to measure and verify piping slope.
- 3 Responsibility
  - 3.1 Therma's Quality Control Examiner (QCE) shall calibrate the digital inclinometers.
  - 3.2 Therma's QC Manager shall audit the calibration reports periodically and ensure that the digital inclinometers are calibrated once a year.
- 4 Reference
  - 4.1 SmartTool Owner's Manual for Digital Inclinometers.
- 5 Procedures
  - 5.1 Place digital inclinometer on flat surface with 0.1% of zero (0) reading.
  - 5.2 After ten (10) seconds, QC Examiner shall push "Reset" or "Calibration" button for two (2) seconds. The digital display window shall indicate "CAL 1".
 

Note: SmartTool's digital inclinometer has the calibration button.  
Wedge's digital inclinometer has the reset button.
  - 5.3 When "CAL 1" disappears from the display window, rotate the digital inclinometer to 180 degrees and don't touch the inclinometer for 10 seconds.

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- 5.4 After ten (10) seconds, QC Examiner shall push the “Reset” or “Calibration” button for two (2) seconds. The digital display window shall indicate “CAL 2”.

Note: SmartTool’s digital inclinometer has the calibration button.  
Wedge’s digital inclinometer has the reset button.

- 5.5 Once “CAL 2” disappears from the display window, the digital inclinometer has been calibrated.

- 5.6 QC Examiner shall fill out the following information in a digital inclinometer calibration sheet, FN 6.008.1.

5.6.1 Digital inclinometer’s manufacturer,

5.6.2 Therma’s serial number,

5.6.3 QC Examiner who performed the calibration,

5.6.4 Calibration date,

5.6.5 Next calibration date,

5.6.6 As found data,

5.6.7 Comments if have any

## 6 Review and Approval

- 6.1 Therma’s QC Examiner shall submit the digital inclinometer calibration sheet, FN 6.008.1 to QC manager for review.

- 6.2 Therma’s QC Manager shall review and file the calibration sheet.

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## Document Approval

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3/06/12  
Date

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