



CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 100413010
Gauge application : Incoming inspection
Standard of thread : Metric ISO threads acc. to ISO 965:1998/ISO 1502:1996
Type of gauge : GO thread plug gauge
Thread designation : M 85x2-6H
Pitch : 2,0000 mm
Measuring method : Three wires method
Wire diameter : 1,1553 mm
Measuring force : 9,20 N
Measurement traceability : Mahr 828 Nr.31
Measurement traceability : Gauge block set ID 3997 57308 D-K-15190-01-00 2015-06

Gauge nominal values

Major diameter max. : 85,0300 mm
 Major diameter min. : 85,0020 mm
 Pitch diameter max. : 83,7240 mm
 Pitch diameter min. : 83,7100 mm
 Minor diameter max. : 82,5460 mm

Measuring values Pitch diameter

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	83,7209	-

Valuation: usable

Operator:  Date: 12.12.2017
 (Lehmann)

Uncertainty of measurement: $U = 2.5 \mu\text{m} + 10 \cdot 10^{-6} \cdot d$. The uncertainty stated is the expanded uncertainty of measurement obtained by multiplying the standard uncertainty by the coverage factor $k = 2$. They were established according to DAkkS-DKD-3. The value of the measured variable is within the assigned value range with 95 % probability.
Ref.temp: $(20 \pm 1) ^\circ\text{C}$. **Inspection requirement:** The inspections procedure was based on recognised German inspection specifications (VDI/VDE/DGQ/2618). The measuring equipment and standards used are compared regularly with reference standards calibrated by a calibration service accredited by the European Cooperation for Accreditation (EA) and therefore traceable to the national standards of the PTB. Hence the inspection certificate complies with the traceability requirements of DIN EN ISO 9001.