

## CALIBRATION CERTIFICATE

**Customer** : 0155600  
**Identification number** : 101322003  
**Gauge application** : Incoming inspection  
**Standard of thread** : Thread gauges according to factory standards  
**Type of gauge** : GO/NOT GO thread plug gauge  
**Thread designation** : W 24.32 x 1/14 (DIN 477)  
**Pitch** : 1,8140 mm  
**Measuring method** : Three wires method  
**Wire diameter** : 1,0101 mm  
**second wire diameter** : 1,0101 mm  
**Measuring force** : 9,90 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	Go side	Not Go side
Major diameter max.	: 24,3380 mm	23,7390 mm
Major diameter min.	: 24,3250 mm	23,7040 mm
Pitch diameter max.	: 23,1760 mm	23,3090 mm
Pitch diameter min.	: 23,1630 mm	23,2960 mm
Minor diameter max.	: 22,0160 mm	22,0160 mm

## Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	23,1686	-

## Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	23,3023	-

Valuation: usable

Operator:   
(Bantle) Date: 02.09.2019

**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 ± 1) °C. **Inspection requirement:** The inspections procedure was based on recognised German inspection specifications (VDI/VDE/DGQ/2518). 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.