

CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 102498010
Gauge application : Incoming inspection
Standard of thread : Pipe threads according to ISO 228:2003
Type of gauge : GO/NOT GO thread plug gauge
Thread designation : G 7/8
Pitch : 1,8140 mm
Measuring method : Three wires method
Wire diameter : 1,0098 mm
second wire diameter : 1,0098 mm
Measuring force : 4,00 N
Measurement traceability : Zeiss ULM 600-C Nr.439
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.	: 30,2190 mm	29,5620 mm
Major diameter min.	: 30,1950 mm	29,5380 mm
Pitch diameter max.	: 29,0580 mm	29,1930 mm
Pitch diameter min.	: 29,0460 mm	29,1810 mm
Minor diameter max.	: 27,8770 mm	27,7350 mm

Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	29,0526	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	29,1904	-

Valuation: usable

Operator:


(Hogg)

Date: 06.06.2018

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/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.