

CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 108835008
Gauge application : Incoming inspection
Standard of thread : Metric thread inserts acc. to DIN 8140:1999/2017
Type of gauge : GO/NOT GO thread plug gauge
Thread designation : EG M 24x3-6H mod
Pitch : 3,0000 mm
Measuring method : Three wires method
Wire diameter : 1,6496 mm
second wire diameter : 1,6496 mm
Measuring force : 9,00 N
Measurement traceability : Mahr 828 Nr.22
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.	: 27,9200 mm	26,7510 mm
Major diameter min.	: 27,8980 mm	26,7290 mm
Pitch diameter max.	: 25,9655 mm	26,1455 mm
Pitch diameter min.	: 25,9545 mm	26,1345 mm
Minor diameter max.	: 24,2120 mm	24,3920 mm


Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	25,9586	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	26,1384	-

Valuation: usable

Operator: 
(Sahan)

Date: 31.01.2018

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: $(20 \pm 1) ^\circ\text{C}$. **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.