



CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 117596020
Gauge application : Incoming inspection
Standard of thread : Thread gauges according to factory standards
Type of gauge : GO thread plug with NO GO plain plug for minor diameter
Thread designation : Pg 21
Pitch : 1,5880 mm
Measuring method : Three wires method
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.	: 28,3400 mm	27,0450 mm
Major diameter min.	: 28,3000 mm	27,0150 mm
Pitch diameter max.	: 27,5800 mm	
Pitch diameter min.	: 27,5400 mm	
Kerndurchmesser Höchstmaß	: 26,8200 mm	

Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	27,5581	-

Measuring values - Not go side

Plane	Axial section	MajorØ [mm]	Out of tolerance [µm]
1	0 Degree	27,0324	-

Valuation: usable

Operator:

(Signature)
(Stark)

Date: 21.03.2019

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