



CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 120874001
Gauge application : Incoming inspection
Standard of thread : Metric ISO threads acc. to ISO 965:2013/ISO 1502:1996
Type of gauge : GO/NOT GO thread plug gauge
Thread designation : M 24x1.5-6G
Pitch : 1,5000 mm
Measuring method : Three wires method
Wire diameter : 0,8658 mm
second wire diameter : 0,8658 mm
Measuring force : 9,90 N
Measurement traceability : Mahr 828 Nr.31
Measurement traceability : single gauge ID 316275 033416 D-K-15048-01-00 2020-06

Gauge nominal values	Go side	Not Go side
Major diameter max.	: 24,0550 mm	23,5745 mm
Major diameter min.	: 24,0330 mm	23,5525 mm
Pitch diameter max.	: 23,0755 mm	23,2690 mm
Pitch diameter min.	: 23,0645 mm	23,2580 mm
Minor diameter max.	: 22,1910 mm	22,1910 mm


Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	23,0708	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	23,2653	-

Valuation: usable

Operator: 
(Sahan-Bitzer)

Date: 13.01.2021

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.