

CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 121082001
Gauge application : Incoming inspection
Standard of thread : Unified threads acc. to ANSI/ASME B1.1-1989(R2001), B1.2
Type of gauge : GO/NOT GO thread plug gauge
Thread designation : 1 3/8 - 12 UNF -2B
Pitch : 2,1170 mm
Measuring method : Three wires method
Wire diameter : 1,1553 mm
second wire diameter : 1,1553 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.	: 34,9402 mm	34,6761 mm
Major diameter min.	: 34,9250 mm	34,6608 mm
Pitch diameter max.	: 33,5585 mm	33,7591 mm
Pitch diameter min.	: 33,5509 mm	33,7515 mm
Minor diameter max.	: 32,1767 mm	32,3774 mm

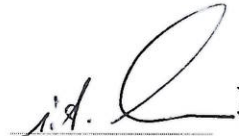
Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	33,5551	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	33,7543	-

Valuation: usable

Operator: 
 (Ammann) Date: 01.04.2019

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.