

Calibration certificate No.: JUZ-00510136

Inspection date : 06.11.2023

Identity number : 123-3320
Gauge type : NO GO thread ring gauge (solid)
Designation : 1/4 - 24 UNS -2A LH
Inspection procedure : VDI/VDE/DGQ 2618, Blatt 4.9, April 2006
Inspection device and traceability : ULM 600 OPAL No. 101716 Certificate number: 8452 D-K-12037-01-00
Measuring uncertainty U(95) : $3 \mu\text{m} + 10 \cdot 10^{-6} \cdot l$
Reference temperature : $20^\circ\text{C} \pm 1\text{K}$
Comments : as found = as left
Valuation : usable

Thread designation: 1/4 - 24 UNS -2A LH
Thread standard: ANSI/ASME B1.2 (ASME B1.1-2019)
 1./2. Flank angle: $30,00^\circ \pm 15'$ / $30,00^\circ \pm 15'$
 Pitch: 1,0580 mm \pm 8,0 μm Ganganzahl: 1
 Best ball diameter: 0,6108 mm
 Use ball diameter: 0,6239 mm
 Measuring method: Drei-Kugel-Verfahren

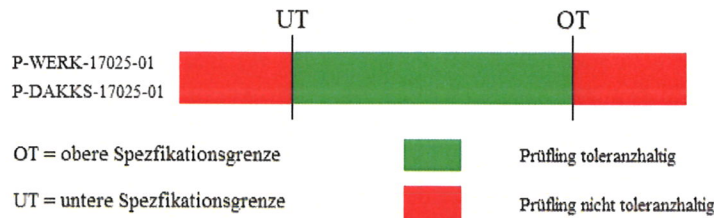
Gauge nominal values

Major diameter (min): 6,3221 mm
 Effective diameter new (min): 5,5397 mm
 Effective diameter new (max): 5,5473 mm
 Minor diameter (min): 5,3111 mm
 Minor diameter (max): 5,3238 mm

Measuring values No Go side - Effective diameter

Messposition	Effective diamter mm	Tolerance graphic / Out of tolernce	Conformity
Schnitt A-B / Ebene 1	5,5426	-----X-----	IO
Schnitt C-D / Ebene 2	5,5416	----X-----	IO

The measurement results are evaluated according to the decision rule:



Operator: Gabi Müller

The valuation refers exclusively to the measured parameters / option. The user is responsible for adhering to an appropriate inspection period furthermore, the measured values correspond to the time of calibration. This calibration certificate is valid without a signature.