Sjöborgs Maskin AB

Mått Johanssons Väg 16
SE-633 46 Eskilstuna

Co.No.: 00423

Calibration certificate No.: JUZ-00575176

Inspection date : 26.09.2024

Identity number	**: 124-1326**
Gauge type	**: GO thread ring gauge (solid)**
Designation	: G 1/4 A (-0,04)
Inspection procedure	: VDI/VDE/DGQ 2618, Blatt 4.9, April 2006
Inspection device and traceability	: ConturoMatic TS-UD No. 8368 Certificate number: 22042713
Measuring uncertainty U(95)	: 3 µm + 10 · 10^{-6} · l
Ambient temperature	: 20°C ± 1K
Comments	: as found = as left
Valuation	**: usable**

Thread designation:	**G 1/4 A (-0,04)**		
Thread standard:	**ISO 228:2003**		
1./2. Flank angle:	27,50° ± 13' / 27,50° ± 13'		
Pitch:	1,3370 mm ± 5,0 µm	Ganganzahl:	1
Best ball diameter:	0,7537 mm		
Constant of T-shaped probe:	0,7537 mm		
Measuring method:	Auswertung von Konturdaten		

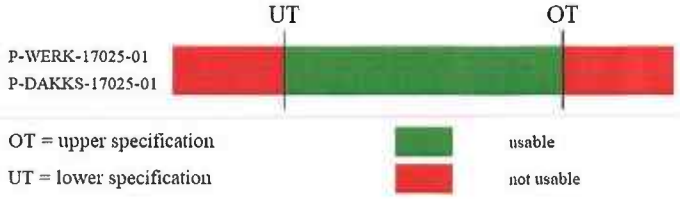
Gauge nominal values

Major diameter (min):	13,1170 mm
Effective diameter new (min):	12,2510 mm
Effective diameter new (max):	12,2670 mm
Effective diameter wear limit:	12,2770 mm
Minor diameter (min):	11,3890 mm
Minor diameter (max):	11,4050 mm

Measuring values of Effective diameter GO side - Effective diameter

measuring position	Effective diameter mm	Tolerance graphic / Out of tolernce	Conformity
Front / Section 0°-180°	12,2522	|-x----------|	IO
Middle / Section 90° - 270°	12,2542	|---x----------|	IO

The measurement results are evaluated according to the decision rule:



Operator: Tilo Hunger

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.

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