

Sjöborgs Maskin AB

Mått Johanssons Väg 16
SE-633 46 Eskilstuna

Co.No.: 00423

Calibration certificate No.: JUZ-00571339

Inspection date : 11.10.2024

Identity number : 124-3201
Gauge type : GO thread ring gauge (solid)
Designation : Tr 20x4 - 7e LH
Inspection procedure : VDI/VDE/DGQ 2618, Blatt 4.9, April 2006
Inspection device and traceability : ULM 600 OPAL No. 101716 Certificate number: 006822 D-K-15048-01-00
Hanteltaster im Satz No. Hanteltaster für DAKKS-Kalibrierung
Hanteltaster im Satz No. Hanteltaster für Werkskalibrierung
Measuring uncertainty U(95) : $3 \mu\text{m} + 10 \cdot 10^{-6} \cdot l$
Ambient temperature : $20^\circ\text{C} \pm 1\text{K}$
Comments : as found = as left
Valuation : usable

Thread designation: Tr 20x4 - 7e LH
Thread standard: DIN 103:1977(1985)
1./2. Flank angle: $15,00^\circ \pm 8'$ / $15,00^\circ \pm 8'$
Pitch: $4,0000 \text{ mm} \pm 5,0 \mu\text{m}$ Ganganzahl: 1
Best ball diameter: 2,0705 mm
Use ball diameter: 2,0694 mm
Measuring method: Drei-Kugel-Verfahren

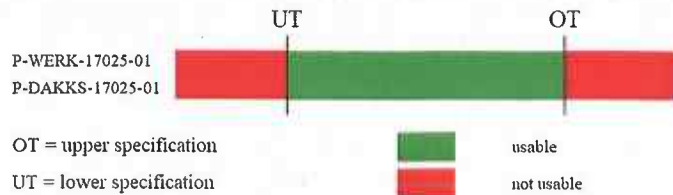
Gauge nominal values

Major diameter (min): 20,5000 mm
Effective diameter new (min): 17,8715 mm
Effective diameter new (max): 17,9045 mm
Effective diameter wear limit: 17,9250 mm
Minor diameter (min): 15,9835 mm
Minor diameter (max): 16,0165 mm

Measuring values of Effective diameter GO side - Effective diameter

measuring position	Effective diameter mm	Tolerance graphic / Out of tolerance	Conformity
Schnitt A-B / Ebene 1	17,8843	-----X-----	IO
Schnitt C-D / Ebene 1	17,8792	---X-----	IO
Schnitt C-D / Ebene 2	17,8771	--X-----	IO
Schnitt A-B / Ebene 2	17,8830	-----X-----	IO

The measurement results are evaluated according to the decision rule:



Operator: Daniel Peukert

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.