

CALIBRATION CERTIFICATE

Customer : 0155600
 Identification number : 125344102
 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 : 6 - 32 UNC -2B
 Pitch : 0,7940 mm
 Measuring method : Three wires method
 Wire diameter : 0,4553 mm
 second wire diameter : 0,4553 mm
 Measuring force : 4,10 N
 Measurement traceability : Mahr 828 Nr.31
 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.	: 3,5179 mm	3,4265 mm
Major diameter min.	: 3,5052 mm	3,4138 mm
Pitch diameter max.	: 2,9972 mm	3,0836 mm
Pitch diameter min.	: 2,9896 mm	3,0759 mm
Minor diameter max.	: 2,4740 mm	2,5603 mm

Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	2,9936	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	3,0808	-

Valuation: usable

Operator:


(Buckenmayer)

Date: 28.08.2019

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: $(20 \pm 1) ^\circ\text{C}$. **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.