



**CALIBRATION CERTIFICATE**  
MultiCheck-thread plug gauge

Customer : 0155600  
 Identification number : 125453162  
 Gauge application : Incoming inspection  
 Standard of thread : Metric ISO threads acc. to ISO 965:2013/ISO 1502:1996  
 Type of gauge : GO / NOGO thread plug gauge  
 Thread designation: : M 6x1-6H  
 Pitch: : 1,0000 mm  
 Measuring method: : Three wires method  
 Used wire diameter: : 0,5770 mm  
 Measuring force: : 4,50 N  
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Gauge nominal values	GO side	NO GO side
External diameter - max. value	: 6,0230 mm	5,7165 mm
External diameter - min. value	: 6,0010 mm	5,6945 mm
Effective diameter - max. value	: 5,3675 mm	5,5110 mm
Effective diameter - min. value	: 5,3565 mm	5,5000 mm
Minor diameter - max. value	: 4,7730 mm	4,7730 mm

**Measuring values of Effective diameter - GO side**

Meas. plane No.	Meas. valueNo.	Effective diameter [mm]	Out of tolerance [µm]
1	1	5,3630	-

**Measuring values of Effective diameter - NO GO side**

Meas. plane No.	Meas. valueNo.	Effective diameter [mm]	Out of tolerance [µm]
1	1	5,5068	-

**Valuation: usable**

Operator:   
(Kirschbaum)

Inspection date: 21.04.2020

Measuring uncertainty:  $U_{95} = 2.5 \mu\text{m} + 1.4 \cdot 10^{-6} \cdot l$ ; Ref.temp. [deg C°]: 20; Measuring machine: MAHR 828 Nr.19372; MAHR 828 Nr. 38013; Zeiss ULM 01-600C Nr.6908; IAC Master Scanner MSXP 6025 Nr.101064; IAC Master Scanner MSXP 10060 Nr.100971; Reference standard: Set Setting ring gauge 8138 DAKKS-101590-D-K-15089-01-01\_2016-09; Set Parallel gauge block: 3997-DAKKS-57308-D-K-15190-01-00-2015-06; 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 Co-operation 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; \*Physikalisch Technische Bundesanstalt (Federal Physical and Technical Institute)