

CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 127126010
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 : 1 1/4 - 12 UNF -2B
Pitch : 2,1170 mm
Measuring method : Three wires method
Wire diameter : 1,1553 mm
second wire diameter : 1,1553 mm
Measuring force : 9,90 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.	: 31,7652 mm	31,4960 mm
Major diameter min.	: 31,7500 mm	31,4808 mm
Pitch diameter max.	: 30,3835 mm	30,5791 mm
Pitch diameter min.	: 30,3759 mm	30,5714 mm
Minor diameter max.	: 29,0017 mm	29,1973 mm

Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	30,3810	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	30,5760	-

Valuation: usable

Operator:


(Buckenmayer)

Date: 27.08.2019

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.