

CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 128078047
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 : 7/8 - 14 UNF -2B
Pitch : 1,8140 mm
Measuring method : Three wires method
Wire diameter : 1,0101 mm
second wire diameter : 1,0101 mm
Measuring force : 4,50 N
Measurement traceability : Zeiss ULM 600-C Nr.439
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.	: 22,2402 mm	22,0091 mm
Major diameter min.	: 22,2250 mm	21,9939 mm
Pitch diameter max.	: 21,0541 mm	21,2242 mm
Pitch diameter min.	: 21,0464 mm	21,2166 mm
Minor diameter max.	: 19,8679 mm	20,0381 mm

Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	21,0503	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	21,2216	-

Valuation: usable

Operator:


(Eisele)

Date: 30.09.2019

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.