



CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 129360007
Gauge application : Incoming inspection
Standard of thread : Pipe threads according to ISO 228:2003
Type of gauge : GO/NOT GO thread plug gauge
Thread designation : G 1/4
Pitch : 1,3370 mm
Measuring method : Three wires method
Wire diameter : 0,7242 mm
second wire diameter : 0,7242 mm
Measuring force : 4,10 N
Measurement traceability : Mahr 828 Nr.31
Measurement traceability : single gauge ID 316275 014252 D-K-15048-01-00 2019-03

Gauge nominal values	Go side	Not Go side
Major diameter max.	: 13,1720 mm	12,7080 mm
Major diameter min.	: 13,1520 mm	12,6880 mm
Pitch diameter max.	: 12,3140 mm	12,4360 mm
Pitch diameter min.	: 12,3040 mm	12,4260 mm
Minor diameter max.	: 11,4450 mm	11,3200 mm

Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	12,3102	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	12,4314	-

Valuation: usable

Operator:


(Ammann)

Date: 08.04.2020

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/22618). 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.