

CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 130369140
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 1/2
Pitch : 1,8140 mm
Measuring method : Three wires method
Wire diameter : 1,0101 mm
second wire diameter : 1,0101 mm
Measuring force : 9,90 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. | : 20,9730 mm | 20,3160 mm |
| Major diameter min. | : 20,9490 mm | 20,2920 mm |
| Pitch diameter max. | : 19,8120 mm | 19,9470 mm |
| Pitch diameter min. | : 19,8000 mm | 19,9350 mm |
| Minor diameter max. | : 18,6310 mm | 18,4890 mm |

Measuring values Pitch diameter - Go side


| Plane | Axial section | PitchØ [mm] | Out of tolerance [µm] |
|-------|---------------|-------------|-----------------------|
| 2 | 0 Degree | 19,8071 | - |

Measuring values Pitch diameter - Not go side

| Plane | Axial section | PitchØ [mm] | Out of tolerance [µm] |
|-------|---------------|-------------|-----------------------|
| 2 | 0 Degree | 19,9414 | - |

Valuation: usable

Operator:


(Buckenmayer)

Date: 29.01.2020

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/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.