



CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 130370257
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
Pitch : 2,3090 mm
Measuring method : Three wires method
Wire diameter : 1,3023 mm
second wire diameter : 1,3023 mm
Measuring force : 9,60 N
Measurement traceability : Mahr 828 Nr.22
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.	: 33,2670 mm	32,4300 mm
Major diameter min.	: 33,2430 mm	32,4060 mm
Pitch diameter max.	: 31,7890 mm	31,9620 mm
Pitch diameter min.	: 31,7770 mm	31,9500 mm
Minor diameter max.	: 30,2910 mm	30,1110 mm

Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	31,7826	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	31,9579	-

Valuation: usable

Operator: 
(Buckenmayer)

Date: 20.05.2020

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.