

## CALIBRATION CERTIFICATE

**Customer** : 0155600  
**Identification number** : 131717009  
**Gauge application** : Incoming inspection  
**Standard of thread** : Unified threads acc. to ANSI/ASME B1.1-1989(R2001), B1.2  
**Type of gauge** : GO thread ring gauge (solid)  
**Thread designation** : 7/8 - 9 UNC -2A  
**Pitch** : 2,8220 mm  
**Measuring method** : Measure with IAC Master Scanner  
**Measurement traceability** : IAC MSXP 100x60 Nr.598  
**Measurement traceability** : Set of setting rings ID 01-04150

### Gauge nominal values

**Major diameter min.** : 22,1767 mm  
**Pitch diameter max.** : 20,3429 mm  
**Pitch diameter min.** : 20,3352 mm  
**Minor diameter max.** : 19,1211 mm  
**Minor diameter min.** : 19,1033 mm

### Measuring values Pitch

Parameter	Nominal value [mm]	Actual value [mm]	Valuation
Pitch	2,8220 ± 8,0 µm	2,8226	ok

### Measuring values Thread angle and flank angle

Parameter	Nominal value	Actual value	Valuation
Thread angle	60 ° 00 ' 00 "	59 ° 59 ' 55 "	ok
left flank angle	30 ° 00 ' 00 " ± 10 '	30 ° 01 ' 13 "	ok
right flank angle	30 ° 00 ' 00 " ± 10 '	29 ° 58 ' 42 "	ok

### Measuring values Pitch diameter

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
1	0 Degree	20,3388	-
3	0 Degree	20,3391	-
1	90 Degree	20,3387	-
3	90 Degree	20,3392	-

### Measuring values Minor diameter

Plane	Axial section	MinorØ [mm]	Out of tolerance [µm]
2	0 Degree	19,1168	-
2	90 Degree	19,1162	-

### Valuation: usable

Operator:

  
(Bantle)

Date: 23.09.2022

**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 ± 1) °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.