

CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 134849002
Gauge application : Incoming inspection
Standard of thread : Metric thread inserts acc. to DIN 8140:1999/2017
Type of gauge : GO/NOT GO thread plug gauge
Thread designation : EG M 18x2.5-6H mod
Pitch : 2,5000 mm
Measuring method : Three wires method
Wire diameter : 1,4440 mm
second wire diameter : 1,4440 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.	: 21,2710 mm	20,2950 mm
Major diameter min.	: 21,2490 mm	20,2730 mm
Pitch diameter max.	: 19,6415 mm	19,7895 mm
Pitch diameter min.	: 19,6305 mm	19,7785 mm
Minor diameter max.	: 18,1810 mm	18,3290 mm

Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	19,6385	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	19,7857	-

Valuation: usable

Operator:



(Buckenmayer)

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: $(20 \pm 1) ^\circ\text{C}$. **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.