

CALIBRATION CERTIFICATE

Customer : 0155600
 Identification number : 135252038
 Gauge application : Incoming inspection
 Standard of thread : Metric ISO threads acc. to ISO 965:2013/ISO 1502:1996
 Type of gauge : GO/NOT GO thread plug gauge
 Thread designation : M 22x2.5-6H
 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.	: 22,0300 mm	21,1210 mm
Major diameter min.	: 22,0020 mm	21,0930 mm
Pitch diameter max.	: 20,3990 mm	20,6140 mm
Pitch diameter min.	: 20,3850 mm	20,6000 mm
Minor diameter max.	: 18,9330 mm	18,9330 mm

Measuring values Pitch diameter - Go side


Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	20,3905	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	20,6057	-

Valuation: usable

Operator:


 (Ammann)

Date: 06.02.2020

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.