

## CALIBRATION CERTIFICATE

**Customer** : 0155600  
**Identification number** : 136514004  
**Gauge application** : Incoming inspection  
**Standard of thread** : Unified threads acc. to ANSI/ASME B1.1-1989(R2001), B1.2  
**Type of gauge** : NO GO thread ring gauge (solid)  
**Thread designation** : 1/4 - 28 UNF -2A LH  
**Pitch** : 0,9070 mm  
**Measuring method** : "Three balls" method (using T-probe)  
**Used ball diameter** : 0,5285 mm  
**Constant of T-shaped probe** : 3,3031 mm  
**Measurement traceability** : Mahr 828 ID 381  
**Measurement traceability** : Set of setting rings ID 01-04150

### Gauge nominal values

**Major diameter min.** : 6,3246 mm  
**Pitch diameter max.** : 5,6591 mm  
**Pitch diameter min.** : 5,6515 mm  
**Minor diameter max.** : 5,4686 mm  
**Minor diameter min.** : 5,4559 mm

### Measuring values Pitch diameter

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	5,6540	-

**Valuation: usable**

Operator:

(Salvaggio)

Date: 27.05.2020

**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.