



CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 136736017
Gauge application : Incoming inspection
Standard of thread : UNJ Aerospace threads acc. to ISO 3161:1999 (ASME B1.15)
Type of gauge : GO/NOT GO thread plug gauge
Thread designation : 10 (0.190) - 32 UNJF -3B
Pitch : 0,7940 mm
Measuring method : Three wires method
Wire diameter : 0,4551 mm
second wire diameter : 0,4551 mm
Measuring force : 4,00 N
Measurement traceability : Mahr 828 Nr.22
Measurement traceability : Parallelendmaß Nr. 316275 014252 D-K-15048-01-00 2019-03

Gauge nominal values	Go side	Not Go side
Major diameter max.	: 4,8387 mm	4,7269 mm
Major diameter min.	: 4,8260 mm	4,7142 mm
Pitch diameter max.	: 4,3180 mm	4,3840 mm
Pitch diameter min.	: 4,3104 mm	4,3764 mm
Minor diameter max.	: 3,7948 mm	3,8608 mm

Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	4,3143	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	4,3815	-

Valuation: usable

Operator:  Date: 09.07.2020
(Ammann-Mayer)

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.