

CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 139891024
Gauge application : Incoming inspection
Standard of thread : Unified threads acc. to ANSI/ASME B1.1-1989(R2001), B1.2
Type of gauge : GO/NOT GO thread plug gauge
Thread designation : 1 1/8 - 12 UNF -2B
Pitch : 2,1170 mm
Measuring method : Three wires method
Wire diameter : 1,1558 mm
second wire diameter : 1,1558 mm
Measuring force : 9,90 N
Measurement traceability : Mahr 828 Nr.31
Measurement traceability : Parallelendmaß Nr. 316275 014252 D-K-15048-01-00 2019-03

Gauge nominal values	Go side	Not Go side
Major diameter max.	: 28,5902 mm	28,3159 mm
Major diameter min.	: 28,5750 mm	28,3007 mm
Pitch diameter max.	: 27,2085 mm	27,3990 mm
Pitch diameter min.	: 27,2009 mm	27,3914 mm
Minor diameter max.	: 25,8267 mm	26,0172 mm

Measuring values Pitch diameter - Go side


Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	27,2041	-

Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	27,3959	-

Valuation: usable

Operator:


 (Ammann)

Date: 14.05.2020

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 ± 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.