

CALIBRATION CERTIFICATE

Customer : 0155600
Identification number : 147923002
Gauge application : Incoming inspection
Standard of thread : Unified threads acc. to ANSI/ASME B1.1-1989(R2001), B1.2
Type of gauge : GO thread ring gauge (solid)
Thread designation : 9/16 - 18 UNF -2A LH
Pitch : 1,4110 mm
Measuring method : Measure with IAC Master Scanner
Measurement traceability : IAC XLP-C 300 Nr.579
Measurement traceability : DAkkS Einstellringe im Satz Nr. 01-04150

Gauge nominal values

Major diameter min. : 14,2519 mm
Pitch diameter max. : 13,3350 mm
Pitch diameter min. : 13,3274 mm
Minor diameter max. : 12,7229 mm
Minor diameter min. : 12,7102 mm

Measuring values Pitch

Parameter	Nominal value [mm]	Actual value [mm]	Valuation
Pitch	1,4110 ± 8,0 µm	0,0000	ok

Measuring values Thread angle and flank angle

Parameter	Nominal value	Actual value	Valuation
Thread angle	60 ° 00 ' 00 "	29 ° 46 ' 25 "	not ok
left flank angle	30 ° 00 ' 00 " ± 10 '	0 ° 00 ' 00 "	ok
right flank angle	30 ° 00 ' 00 " ± 10 '	29 ° 46 ' 25 "	not ok

2	0 Degree	13,3309	-
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Valuation: usable

Operator: 
 (Eisele) 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.