



## CALIBRATION CERTIFICATE

**Customer** : 0155600  
**Identification number** : 9021332-277 (152179005)  
**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** : 1 1/16 - 12 UNJ -3B  
**Pitch** : 2,1170 mm  
**Measuring method** : Three wires method  
**Wire diameter** : 1,1555 mm  
**second wire diameter** : 1,1556 mm  
**Measuring force** : 3,40 N  
**Measurement traceability** : Mahr 828 Nr.31  
**Measurement traceability** : Parallelendmaß Nr.318378 069832 D-K-15048-01-00 2019-11

Gauge nominal values	Go side	Not Go side
Major diameter max.	: 27,0027 mm	26,6700 mm
Major diameter min.	: 26,9875 mm	26,6548 mm
Pitch diameter max.	: 25,6210 mm	25,7531 mm
Pitch diameter min.	: 25,6134 mm	25,7454 mm
Minor diameter max.	: 24,2392 mm	24,3713 mm

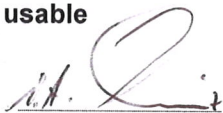
### Measuring values Pitch diameter - Go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	25,6182	-

### Measuring values Pitch diameter - Not go side

Plane	Axial section	PitchØ [mm]	Out of tolerance [µm]
2	0 Degree	25,7515	-

**Valuation: usable**

Operator:   
(Ammann-Mayer)

Date: 19.01.2022

**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.