



CALIBRATION CERTIFICATE

Customer : 0155600
 Identification number : 21933002
 Gauge application : Incoming inspection
 Standard of thread : Unified threads acc. to ANSI/ASME B1.1, B1.2
 Type of gauge : solid NO GO thread ring gauge
 Thread designation: : 1 - 20 UNEF -2A
 Pitch: : 1,2700 mm
 Measuring method: : "Three balls" method (using T-probe)
 Used ball diameter: : 0,7249 mm
 Constant of T-shaped probe : 4,9810 mm

Gauge nominal values

External diameter min. value : 25,3644 mm
 Effective diameter - min. value : 24,4246 mm
 Effective diameter - max. value : 24,4322 mm
 Minor diameter - min. value : 24,1497 mm
 Minor diameter - max. value : 24,1624 mm

Measuring values of Effective diameter

Meas. plane No.	Meas. value No.	Effective diameter [mm]	Out of tolerance [μ m]
1	1	24,4256	-

Valuation: in tolerance

Operator: *i. A. J. P. Müller* Inspection date: 03.02.2009
 (Salvaggio)

measuring accuracy: U95 = 2.5 μ m; **Ref.temp.** [deg C°]: 20; **Measuring machine:** MAHR 828 Nr.19372; MAHR 828 Nr. 38013; Zeiss ULM 01-600C Nr.6908; IAC Master Scanner MSXP 6025 Nr.101064; IAC Master Scanner MSXP 10060 Nr.100971; **reference standard:** Setting ring gauge \varnothing 20 342-DKD-K-14201-05-07; Parallel gauge block: 10mm 5328-DKD-K-17301-2005-07; **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 Co-operation 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 9000:2000, section 7.6.

*Physikalisch Technische Bundesanstalt (Federal Physical and Technical Institute)

