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CALIBRATION CERTIFICATE

Customer : 0155600
 Identification number : 266424
 Gauge application : Incoming inspection
 Standard of thread : Metrical threads according DIN ISO 1502 (DIN 13)
 Type of gauge : GO / NO GO thread plug gauge
 Thread designation: : M 28x1-6G
 Pitch: : 1,0000 mm
 Measuring method: : Three wires method
 Used wire diameter: : 0,5773 mm
 Measuring force: : 4,1 N

Gauge nominal values	GO side	NO GO side
External diameter - max. value	: 28,0490 mm	27,7625 mm
External diameter - min. value	: 28,0270 mm	27,7405 mm
Effective diameter - max. value	: 27,3935 mm	27,5570 mm
Effective diameter - min. value	: 27,3825 mm	27,5460 mm
Minor diameter - max. value	: 26,7990 mm	26,7990 mm

Measuring values of Effective diameter - GO side

Meas. plane No.	Meas. value No.	Effective diameter [mm]	Out of tolerance [µm]
1	1	27,3925	-

Measuring values of Effective diameter - NO GO side

Measuring plane No.	Meas. value No.	Effective diameter [Einheit]	Out of tolerance [µm]
1	1	27,5544	-

Valuation: in tolerance

Operator:
(Gjigjani)

Inspection date: 03.07.2008

measuring accuracy: U95 = 2.5 µm; **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 Ø20 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)

