



CALIBRATION CERTIFICATE

(Inspection certificate 3.1 e.g. EN 10204)

Customer : 0155600
 Identification number : 72415010
 Gauge application : Incoming inspection
 Standard of thread : Pipe threads according to ISO 228:2000
 Type of gauge : GO thread plug gauge
 Thread designation: : G 2 1/4
 Pitch: : 2,3090 mm
 Measuring method: : Three wires method
 Used wire diameter: : 1,3495 mm
 Measuring force: : 8,60 N

Gauge nominal values

External diameter - max. value : 65,7340 mm
 External diameter - min. value : 65,7020 mm
 Effective diameter - max. value : 64,2570 mm
 Effective diameter - min. value : 64,2410 mm
 Minor diameter - max. value : 62,7520 mm

Measuring values of Effective diameter

Meas. plane No.	Meas. value No.	Effective diameter [mm]	Out of tolerance [µm]
1	1	64,2474	-

Valuation: usable

Operator:  Inspection date: 10.05.2015
 (Buckenmayer)

measuring accuracy: $U_{95} = 2,5 \mu\text{m} + 1,4 \cdot 10^{-6} \cdot l$; Ref.temp. [deg C°]: 20; Measuring machine: MAHR 828 Nr.19372; MAHR 828 Nr. 38013; Zeiss ULM 01-600C Nr.6908; IAC Master Scanner XP 10025 Nr.103374-1; IAC Master Scanner XP 16060 Nr.103374-2; reference standard: Setting ring gauge Ø20 640-DKD-K-14201-10-12; Parallel gauge block: 10mm 25994-DKD-K-17301-2010-12; 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 9001, section 7.6.
 *Physikalisch Technische Bundesanstalt (Federal Physical and Technical Institute)