

CALIBRATION CERTIFICATE

(Inspection certificate 3.1 e.g. EN 10204)

Customer : 0155600
Identification number : 81394040
Gauge application : Incoming inspection
Standard of thread : ISO metric threads acc. to DIN ISO 1502 (DIN 13)
Type of gauge : GO / NOGO thread plug gauge
Thread designation: : M 8x0.75-6H
Pitch: : 0,7500 mm
Measuring method: : Three wires method
Used wire diameter: : 0,4553 mm
Measuring force: : 3,90 N

Gauge nominal values	GO side	NO GO side
External diameter - max. value	: 8,0230 mm	7,8115 mm
External diameter - min. value	: 8,0010 mm	7,7895 mm
Effective diameter - max. value	: 7,5305 mm	7,6560 mm
Effective diameter - min. value	: 7,5195 mm	7,6450 mm
Minor diameter - max. value	: 7,0800 mm	7,0800 mm

Measuring values of Effective diameter - GO side

Meas. plane No.	Meas. valueNo.	Effective diameter [mm]	Out of tolerance [µm]
1	1	7,5250	-

Measuring values of Effective diameter - NO GO side

Meas. plane No.	Meas. valueNo.	Effective diameter [mm]	Out of tolerance [µm]
1	1	7,6498	-

Valuation: usable

Operator: 
(Lehmann) Inspection date: 08.09.2016

measuring accuracy: $U95 = 2.5 \mu\text{m} + 1.4 \cdot 10^{-6} \cdot l$; **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)