

CALIBRATION CERTIFICATE

(Inspection certificate 3.1 e.g. EN 10204)

Customer : 0155600
Identification number : 84126002
Gauge application : Incoming inspection
Standard of thread : ISO metric threads acc. to DIN ISO 1502 (DIN 13)
Type of gauge : solid NO GO thread ring gauge
Thread designation: : M 24x1.5-6h
Pitch: : 1,5000 mm
Measuring method: : Measure with IAC Master Scanner

Gauge nominal values

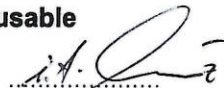
External diameter min. value : 24,0110 mm
Effective diameter - min. value : 22,8580 mm
Effective diameter - max. value : 22,8760 mm
Minor diameter - min. value : 22,5490 mm
Minor diameter - max. value : 22,5850 mm

Measuring values of Effective diameter

Meas. plane No.	Meas. value No.	Effective diameter [mm]	Out of tolerance [μm]
1	1	22,8629	-

Valuation: usable

Operator:


(Buckenmayer)

Inspection date: 08.12.2016

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 $\varnothing 20$ 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)