



Prüfprotokoll Calibration Certificate



FB PAW 16.5.1, Rev. 1

Incoming inspection of GO / NO GO thread plug gauge

Thread designation: M 14 x 1,5 - 6H
 Thread standard: ISO metric threads acc. to DIN ISO 965:1998
 Identity number:
 1st Flank angle: 30,00° ± 16'
 2nd Flank angle: 30,00° ± 16'
 Pitch: 1,500 mm ± 5 µm
 Thread starts: 1
 Best wire diameter: 0,8950
 Used wire diameter: 0,8950 mm
 Measuring force: 2 N
 Measuring method: Three wires method

Gauge nominal values

	GO side	NO GO side
External diameter - max. value:	14,0230 mm	13,5320 mm
External diameter - min. value:	14,0010 mm	13,5100 mm
Effective diameter - max. value:	13,0430 mm	13,2270 mm
Effective diameter - min. value:	13,0320 mm	13,2160 mm
Effective diameter - Wear limit:	13,0200 mm	13,2100 mm
Minor diameter - max. value:	12,1598 mm	12,1598 mm

Values for Flank angles, Pitch,.. - GO side

Parameter	Nominal value	Actual value	Valuation
1st Flank angle	30,00	30,000	ok
2nd Flank angle	30,00	30,000	ok
Pitch	1,500	1,500	ok

Measuring values of Effective diameter - GO side

Meas. plane No.	Meas. value No.	Measure [mm]	Effective diameter [mm]	Tolerance graphic / Out of tolerance [µm]
1	1	14,4257	13,0397	-----X-----
2	1	14,4255	13,0395	-----X-----

Values for Flank angles, Pitch,.. - NO GO side

Parameter	Nominal value	Actual value	Valuation
1st Flank angle	30,00	30,000	ok
2nd Flank angle	30,00	30,000	ok
Pitch	1,500	1,500	ok

Measuring values of Effective diameter - NO GO side

Measuring plane No.	Meas. value No.	Measure [mm]	Effective diameter [mm]	Tolerance graphic / Out of tolerance [µm]
1	1	14,6062	13,2202	-----X-----
2	1	14,6064	13,2204	-----X-----

Valuation: in tolerance / new condition

Measuring uncertainty: 2.50 µm

Inspection procedure: referenced to VDI/VDE/DGQ 2618 (Page 23)

Bei Überwachungsprüfungen nach VDI/VDE/DGQ/2618 werden die Istwerte, welche außerhalb der zulässigen Herstelltoleranz, aber innerhalb der zulässigen Abnutzung und Messunsicherheit liegen, als in Ordnung abgezeichnet. Die Sicherstellung des nationalen Schlusses wird durch Benutzung von eines 87-teiligen Gen.1 DKD-geprüften Parallelendmaßsatzes No.4615 DKD-K-17301 - 06/2009 und eines Einstellringes (SIP-Etalon) No.41941 DKD-K-14201 - 06/2009, Einstellhorn (Cary-Etalon) No.00512 DKD-K-14201 - 04/2010 gewährleistet. The traceability of measurement will be provided by the use of a set of 87 Gen.1 parallel callipers proved by DKD No. 4615 DKD-K-17301 - 06/2009 and a setting ring gauge (SIP-Etalon) No.41941 DKD-K-14201 - 06/2009, setting plug gauge (Cary-Etalon) No. 2008 DKD-K-14201 - 04/2010. Prüfmittel/measurement instruments: SIP 302 M Nr.2402 / 12-99 SIP 302 M Nr. 2306 / 12-99
 Bezugstemperatur/temperature: 20°C ± 1
 Dieser Kalibrierschein erfüllt die Anforderungen der ISO 9000 : 9001. This certificate complies with the demands of ISO 9000 : 9001

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Datum Unterschrift

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