



INTERNATIONAL STANDARD ISO 10360-4:2000
TECHNICAL CORRIGENDUM 1

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**Geometrical Product Specifications (GPS) — Acceptance and
reverification tests for coordinate measuring machines
(CMM) —**

**Part 4:
CMMs used in scanning measuring mode**

TECHNICAL CORRIGENDUM 1

*Spécification géométrique des produits (GPS) — Essais de réception et de vérification périodique des
machines à mesurer tridimensionnelles (MMT) —*

Partie 4: MMT utilisées en mode de mesure par scanning

RECTIFICATIF TECHNIQUE 1

Technical Corrigendum 1 to ISO 10360-4:2000 was prepared by Technical Committee ISO/TC 213,
Dimensional and geometrical product specifications and verification.

Throughout ISO 10360-4:2000, symbols

Replace the symbols τ , MPT_{τ} , T_{ij} and $MPE_{T_{ij}}$ by the following symbols, respectively, wherever the former appear in the document.

“ τ_{ij} ”

“ $MPT_{\tau_{ij}}$ ”

“ T_{ij} ”

“ $MPE_{T_{ij}}$ ”

ICS 17.040.30

Ref. No. ISO 10360-4:2000/Cor.1:2002(E)

Page 5, 5.4

Replace the penultimate paragraph of 5.4 with the following.

“Record the time(s) for scanning test(s), π_{ij} , from the intermediate point at the start of the first scan sequence to the intermediate point at the end of the fourth scan sequence.”

Page 5, 6.1

Replace 6.1 c) with the following.

“c) the time(s) taken for scanning test(s), π_{ij} , is (are) no greater than the maximum permissible time(s) for scanning test, $MPT_{\pi_{ij}}$, as specified by the manufacturer taking into account the uncertainty measurement in accordance with ISO 14253-1.”

Page 6, 6.2

Replace 6.2 c) with the following.

“c) the time(s) taken for scanning test(s), π_{ij} , is (are) no greater than the maximum permissible time(s) for scanning test, $MPT_{\pi_{ij}}$, as specified by the user. If compliance with the specification shall be proved, the uncertainty of measurement shall be taken into account in accordance with ISO 14253-1.”

Page 6, 7.1

Replace the last two paragraphs of 7.1 with the following paragraphs, respectively.

... “the acceptance test specified in this part of ISO 10360 can be used as a test to verify the performance of a CMM used in scanning measuring mode in accordance with the specified maximum permissible scanning probing error(s), $MPE_{T_{ij}}$, and maximum permissible time(s) for scanning test(s), $MPT_{\pi_{ij}}$, as agreed upon by the supplier and the customer.”

“If the supplier does not specify any limitation, the stated maximum permissible scanning probing error(s), $MPE_{T_{ij}}$, and maximum permissible time(s) for scanning test(s), $MPT_{\pi_{ij}}$, apply for any orientation of the stylus and for any location and orientation of the test sphere on the CMM.”

Page 6, 7.2

Replace the text of 7.2 by the following.

“In an organization’s internal quality assurance system, the reverification test specified in this part of ISO 10360 may be used as a test to verify the performance of a CMM used in scanning measuring mode in accordance with the specified maximum permissible scanning probing error(s), $MPE_{T_{ij}}$, and maximum permissible time(s) for scanning test(s), $MPT_{\pi_{ij}}$, as stated by the user with possible detailed limitation applied.”

Page 7, 7.3

Replace the text of the first paragraph of 7.3 by the following.

“In an organization’s internal quality assurance system, a reduced reverification test may be used periodically to demonstrate the probability that the CMM conforms with specified requirements regarding the maximum permissible scanning probing error(s), $MPE_{T_{ij}}$, and maximum permissible time(s) for scanning test(s), $MPT_{\pi_{ij}}$.”