

**Geometrical product specifications (GPS) - Cylindricity -
Part 2: Specification operators (ISO 12180-2:2011)**

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 12180-2:2011 sisaldab Euroopa standardi EN ISO 12180-2:2011 ingliskeelset teksti.

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English Version

Geometrical product specifications (GPS) - Cylindricity - Part 2:
Specification operators (ISO 12180-2:2011)

Spécification géométrique des produits (GPS) - Cylindricité
- Partie 2: Opérateurs de spécification (ISO 12180-2:2011)

Geometrische Produktspezifikation (GPS) - Zylindrizität -
Teil 2: Spezifikationsoperatoren (ISO 12180-2:2011)

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Foreword

This document (EN ISO 12180-2:2011) has been prepared by Technical Committee ISO/TC 213 "Dimensional and geometrical product specifications and verification" in collaboration with Technical Committee CEN/TC 290 "Dimensional and geometrical product specification and verification" the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2011, and conflicting national standards shall be withdrawn at the latest by October 2011.

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Endorsement notice

The text of ISO 12180-2:2011 has been approved by CEN as a EN ISO 12180-2:2011 without any modification.

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Introduction

This part of ISO 12180 is a geometrical product specification (GPS) standard and is to be regarded as a general GPS standard (see ISO/TR 14638). It influences chain link 3 of the chain of standards on form of a surface (independent of a datum).

The ISO/GPS Masterplan given in ISO/TR 14638 gives an overview of the ISO/GPS system of which this part of ISO 12180 is a part. The fundamental rules of ISO/GPS given in ISO 8015 apply to this part of ISO 12180 and the default decision rules given in ISO 14253-1 apply to specifications made in accordance with this part of ISO 12180, unless otherwise indicated.

For more detailed information on the relationship of this part of ISO 12180 to other standards and the GPS matrix model, see Annex C.

This part of ISO 12180 specifies the specification operators according to ISO 17450-2 for cylindricity of integral features.

At the time of publication of this part of ISO 12180, ISO/TC 213 has not been able to reach consensus on defaults for filter undulation per revolution (UPR), probe tip radius and method of association (reference cylinder). This means that it is necessary for a cylindricity specification to explicitly state which values are intended for use with these specification operators in order for it to be unique.

Consequently, if a specification does not explicitly state which values are to be used for one or more of these operators, the specification is ambiguous (see ISO 17450-2) and a supplier can use any value for the operator(s) not specified when proving conformance.

Extracting data always involves applying a certain filtering process. An additional filtering of the extracted data might or might not be applied. This additional filter can be a mean line filter (Gaussian, spline, wavelet, etc.) or a non-linear filter (e.g. morphological filter). The type of filtering influences the definition of cylindricity and the specification operators and, therefore, needs to be stated unambiguously.

NOTE 1 Stylus filtering is not sufficient on its own to smooth a profile. In certain circumstances, it can create spurious high-frequency content, thus giving incorrect values. To correct this, a longwave pass filter is employed. A Gaussian filter is used, since this is the state-of-the-art in International Standards. This filter has some shortcomings, e.g. it can distort, rather than eliminate some roughness features and it can distort, rather than transmit correctly some waviness features. It is envisioned that new filters under development within ISO provide better solutions for several of these issues.

NOTE 2 If a smaller tip radius than the one specified is used for a given cut-off length, the resulting measured value is generally higher. This effect is usually insignificant. If a larger tip radius is used, the resulting measured value is generally lower. The amount of change is heavily dependent on the surface measured.

NOTE 3 The measuring force of 0 N is chosen to eliminate effects of elastic deformation of the workpiece from the specification operator. On metal surfaces with adequate thickness, the effect of normally occurring measuring forces is negligible.

NOTE 4 Aliasing and other problems during extraction (see Annex A) due to the higher harmonic content of the skin model, in the roundness and straightness directions, can cause specification uncertainty.

This part of ISO 12180 is not intended to disallow any means of measuring cylindricity.

Geometrical product specifications (GPS) — Cylindricity —

Part 2: Specification operators

1 Scope

This part of ISO 12180 specifies the complete specification operator for cylindricity of complete integral features only, i.e. geometrical characteristics of features of type cylinder.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 11562:1996, *Geometrical Product Specifications (GPS) — Surface texture: Profile method — Metrological characteristics of phase correct filters*

ISO 12180-1:2011, *Geometrical product specifications (GPS) — Cylindricity — Part 1: Vocabulary and parameters of cylindrical form*

ISO 12181-1:2011, *Geometrical product specifications (GPS) — Roundness — Part 1: Vocabulary and parameters of roundness*

ISO 12780-1:2011, *Geometrical product specifications (GPS) — Straightness — Part 1: Vocabulary and parameters of straightness*

ISO 14253-1:1998, *Geometrical Product Specifications (GPS) — Inspection by measurement of workpieces and measuring equipment — Part 1: Decision rules for proving conformance or non-conformance with specifications*

ISO 17450-2:—¹⁾, *Geometrical product specifications (GPS) — General concepts — Part 2: Basic tenets, specifications, operators and uncertainties*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 11562, ISO 12180-1, ISO 12181-1, ISO 12780-1 and ISO 17450-2 apply.

1) To be published. (Revision of ISO/TS 17450-2:2002)