

Geometrical product specifications (GPS) - Coordinate measuring machines (CMM): Technique for determining the uncertainty of measurement - Part 3: Use of calibrated workpieces or measurement standards (ISO 15530-3:2011)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN ISO 15530-3:2011 sisaldab Euroopa standardi EN ISO 15530-3:2011 ingliskeelset teksti.

Standard on kinnitatud Eesti Standardikeskuse 31.10.2011 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.

Euroopa standardimisorganisatsioonide poolt rahvuslikele liikmetele Euroopa standardi teksti kättesaadavaks tegemise kuupäev on 15.10.2011.

Standard on kättesaadav Eesti standardiorganisatsioonist.

This Estonian standard EVS-EN ISO 15530-3:2011 consists of the English text of the European standard EN ISO 15530-3:2011.

This standard is ratified with the order of Estonian Centre for Standardisation dated 31.10.2011 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.

Date of Availability of the European standard text 15.10.2011.

The standard is available from Estonian standardisation organisation.

ICS 17.040.30

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English Version

Geometrical product specifications (GPS) - Coordinate measuring machines (CMM): Technique for determining the uncertainty of measurement - Part 3: Use of calibrated workpieces or measurement standards (ISO 15530-3:2011)

Spécification géométrique des produits (GPS) - Machines à mesurer tridimensionnelles (MMT): Technique pour la détermination de l'incertitude de mesure - Partie 3: Utilisation de pièces étalonnées ou d'étalons de mesure (ISO 15530-3:2011)

Geometrische Produktspezifikation und -prüfung (GPS) - Verfahren zur Ermittlung der Messunsicherheit von Koordinatenmessgeräten (KMG) - Teil 3: Anwendung von kalibrierten Werkstücken oder Normalen (ISO 15530-3:2011)

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EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: Avenue Marnix 17, B-1000 Brussels

Foreword

This document (EN ISO 15530-3:2011) 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 April 2012, and conflicting national standards shall be withdrawn at the latest by April 2012.

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Endorsement notice

The text of ISO 15530-3:2011 has been approved by CEN as a EN ISO 15530-3:2011 without any modification.

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Introduction

This part of ISO 15530 is a Geometrical Product Specification (GPS) and is to be regarded as a general GPS document (see ISO/TR 14638). It influences chain link 6 of the chain of standards on size, distance, radius, angle, form, orientation, location, run-out and datums.

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

For more detailed information on the relation of this standard to the GPS matrix model, see Annex B.

Coordinate measuring machines (CMMs) have become essential for the verification of geometry in industry. According to the ISO 9000 series of standards, in a quality management system, the relevant measuring equipment is required to be calibrated against certified equipment having a known and valid relationship to internationally or nationally recognized standards in order to establish traceability. According to the *International vocabulary of basic and general terms in metrology* (VIM), a calibration comprises — besides the establishment of the relationship between the measured and the correct values of a quantity — the uncertainty evaluation in the final results (measurands) of the measurement task. However, uncertainty evaluation methods covering the errors arising in the innumerable measurement tasks a CMM can actually perform are often very complex. In these cases, the risk of an unrealistic estimation of task-related uncertainty is likely to arise.

The aim of this part of ISO 15530 is to provide an experimental technique for simplifying the uncertainty evaluation of CMM measurements. In this experimental approach, measurements are carried out in the same way as actual measurements, but with calibrated workpieces or measurement standards of similar dimension and geometry instead of the unknown objects to be measured. The description of this experimental technique to evaluate measurement uncertainty is the key element of this part of ISO 15530. The standardization of such procedures for the uncertainty evaluation serves the worldwide mutual recognition of calibrations and other measurement results.

This part of ISO 15530 is applicable for non-substitution measurement of workpieces or measurement standards, where the measurement result is given by the indication of the CMM. Furthermore, this part of ISO 15530 is applicable for substitution measurement, where, in opposition to the non-substitution measurement, a check standard is used to correct for the systematic errors of the CMM. The latter will generally decrease the measurement uncertainty and is often used, especially in the field of gauge calibration.

This part of ISO 15530 describes one of several methods of uncertainty evaluation, which will be outlined in later ISO documents. Because of the experimental approach, it is simple to perform, and it provides realistic statements of measurement uncertainties.

The limitations of this method can be summarized as: the availability of artefacts with sufficiently defined geometrical characteristics, stability, reasonable costs, and the possibility of being calibrated with sufficiently small uncertainty.

Geometrical product specifications (GPS) — Coordinate measuring machines (CMM): Technique for determining the uncertainty of measurement —

Part 3: Use of calibrated workpieces or measurement standards

1 Scope

This part of ISO 15530 specifies the evaluation of measurement uncertainty for results of measurements obtained by a CMM (coordinate measuring machine) and by using calibrated workpieces or measurement standards. It provides an experimental technique for simplifying the uncertainty evaluation of CMM measurements, whose approach (substitution measurements) leads to measurements being carried out in the same way as actual measurements, but with calibrated workpieces of similar dimension and geometry instead of the unknown workpieces to be measured.

Non-substitution measurements on CMMs are also covered, as are the requirements of the uncertainty evaluation procedure, the measurement equipment needed, and the reverification and interim check of the measurement uncertainty.

NOTE The evaluation of measurement uncertainty is always related to a specific measuring task.

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 10360-1:2000, *Geometrical Product Specifications (GPS) — Acceptance and reverification tests for coordinate measuring machines (CMM) — Part 1: Vocabulary*

ISO/IEC Guide 98-3:2008, *Uncertainty of measurement — Part 3: Guide to the expression of uncertainty in measurement (GUM:1995)*

ISO/IEC Guide 99:2007, *International vocabulary of metrology — Basic and general concepts and associated terms (VIM)*

ISO 14978:2006, *Geometrical product specification (GPS) — General concepts and requirements for GPS measuring equipment*

3 Terms and definitions

For the purpose of this part of ISO 15530, the terms and definitions given in ISO 10360-1, ISO/IEC Guide 98-3, ISO/IEC Guide 99 and the following apply.