
**Geometrical product specifications
(GPS) — Acceptance and reverification
tests for coordinate measuring
systems (CMS) —**

**Part 10:
Laser trackers for measuring point-to-
point distances**

*Spécification géométrique des produits (GPS) — Essais de
réception et de vérification périodique des systèmes à mesurer
tridimensionnels (SMT) —*

*Partie 10: Laser de poursuite pour mesurer les distances de point à
point*



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Contents

Page

Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Symbols	5
5 Rated operating conditions	6
5.1 Environmental conditions	6
5.2 Operating conditions	6
6 Acceptance tests and reverification tests	7
6.1 General	7
6.2 Probing size and form errors	7
6.2.1 Principle	7
6.2.2 Measuring equipment	8
6.2.3 Procedure	8
6.2.4 Derivation of test results	10
6.3 Location errors (two-face tests)	10
6.3.1 Principle	10
6.3.2 Measuring equipment	10
6.3.3 Procedure	10
6.3.4 Derivation of test results	11
6.4 Length errors	11
6.4.1 General	11
6.4.2 Principle	12
6.4.3 Measuring equipment	12
6.4.4 Procedure	13
6.4.5 Derivation of test results	20
7 Compliance with specification	20
7.1 Acceptance tests	20
7.2 Reverification tests	21
8 Applications	21
8.1 Acceptance test	21
8.2 Reverification test	22
8.3 Interim check	22
9 Indication in product documentation and data sheets	22
Annex A (informative) Forms	24
Annex B (normative) Calibrated test lengths	27
Annex C (normative) Thermal compensation of workpieces	29
Annex D (informative) Achieving the alternative measuring volume	30
Annex E (informative) Specification of MPEs	32
Annex F (informative) Interim testing	35
Annex G (normative) Testing of a stylus and retroreflector combination (SRC)	36
Annex H (normative) Testing of an optical distance sensor and retroreflector combination (ODR)	39
Annex I (informative) Relation to the GPS matrix model	41
Bibliography	42

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT), see the following URL: [Foreword — Supplementary information](#).

The committee responsible for this document is ISO/TC 213, *Dimensional and geometrical product specifications and verification*.

ISO 10360 consists of the following parts, under the general title *Geometrical product specifications (GPS) — Acceptance and reverification tests for coordinate measuring machines (CMM)*:

- Part 1: Vocabulary
- Part 2: CMMs used for measuring linear dimensions
- Part 3: CMMs with the axis of a rotary table as the fourth axis
- Part 4: CMMs used in scanning measuring mode
- Part 5: CMMs using single and multiple stylus contacting probing systems
- Part 6: Estimation of errors in computing of Gaussian associated features
- Part 7: CMMs equipped with imaging probing systems

ISO 10360 also consists of the following parts, under the general title *Geometrical product specifications (GPS) — Acceptance and reverification tests for coordinate measuring systems (CMS)*:

- Part 8: CMMs with optical distance sensors
- Part 9: CMMs with multiple probing systems
- Part 10: Laser trackers for measuring point-to-point distances

The following part is under preparation:

- Part 12: Articulated-arm CMMs

Computed tomography is to form the subject of a future part 11

Introduction

This part of ISO 10360 is a geometrical product specification (GPS) standard and is to be regarded as a general GPS standard (see ISO 14638). It influences link F of the chains of standards on size, distance, radius, angle, form, orientation, location, and run-out.

The ISO/GPS matrix model given in ISO 14638 gives an overview of the ISO/GPS system of which this document is a part. The fundamental rules of ISO/GPS given in ISO 8015 apply to this part of ISO 10360 and the default decision rules given in ISO 14253-1 apply to specifications made in accordance with this part of ISO 10360, unless otherwise indicated.

More detailed information on the relation of this part of ISO 10360 to other standards and the GPS matrix model can be found in Annex I.

The objective of this part of ISO 10360 is to provide a well-defined testing procedure for a) laser tracker manufacturers to specify performance by maximum permissible errors (MPEs), and b) to allow testing of these specifications using calibrated, traceable test lengths, test spheres, and flats. The benefits of these tests are that the measured result has a direct traceability to the unit of length, the metre, and that it gives information on how the laser tracker will perform on similar length measurements.

This part of ISO 10360 is **distinct** from that of ISO 10360-2, which is for coordinate measuring machines (CMMs) equipped with contact probing systems, in that the orientation of the test lengths reflect the different instrument geometry and error sources within the instrument.

Geometrical product specifications (GPS) — Acceptance and reverification tests for coordinate measuring systems (CMS) —

Part 10: Laser trackers for measuring point-to-point distances

1 Scope

This part of ISO 10360 specifies the acceptance tests for verifying the performance of a laser tracker by measuring calibrated test lengths, test spheres and flats according to the specifications of the manufacturer. It also specifies the reverification tests that enable the user to periodically reverify the performance of the laser tracker. The acceptance and reverification tests given in this part of ISO 10360 are applicable only to laser trackers utilizing a retro-reflector as a probing system. Laser trackers that use interferometry (IFM), absolute distance meter (ADM) measurement, or both can be verified using this part of ISO 10360. This part of ISO 10360 can also be used to specify and verify the relevant performance tests of other spherical coordinate measurement systems that use cooperative targets, such as “laser radar” systems.

NOTE Systems, such as laser radar systems, which do not track the target, will not be tested for probing performance.

This part of ISO 10360 does not explicitly apply to measuring systems that do not use a spherical coordinate system (i.e. two orthogonal rotary axes having a common intersection point with a third linear axis in the radial direction). However, the parties can apply this part of ISO 10360 to such systems by mutual agreement.

This part of ISO 10360 specifies

- performance requirements that can be assigned by the manufacturer or the user of the laser tracker,
- the manner of execution of the acceptance and reverification tests to demonstrate the stated requirements,
- rules for proving conformance, and
- applications for which the acceptance and reverification tests can be used.

2 Normative references

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

ISO 10360-8:2013, *Geometrical product specifications (GPS) — Acceptance and reverification tests for coordinate measuring systems (CMS) — Part 8: CMMs with optical distance sensors*

ISO 10360-9:2013, *Geometrical product specifications (GPS) — Acceptance and reverification tests for coordinate measuring systems (CMS) — Part 9: CMMs with multiple probing systems*

ISO 14253-1, *Geometrical product specifications (GPS) — Inspection by measurement of workpieces and measuring equipment — Part 1: Decision rules for proving conformity or nonconformity with specifications*