DIN EN ISO 13385-1:2020-03 (E)

Geometrical product specifications (GPS) - Dimensional measuring equipment - Part 1: Design and metrological characteristics of callipers (ISO 13385-1:2019)

Contents

Page

European foreword ... **3**

Foreword ... **4**

Introduction ... **5**

1 Scope ... **6**

2 Normative references ... **6**

3 Terms and definitions ... **6**

4 Design characteristics ... **7**
4.1 General design and nomenclature ... 7
4.2 Dimensions ... 7

5 Metrological characteristics ... **10**
5.1 General ... 10
5.2 Rated operating conditions ... 10
5.3 Reference point ... 10
5.4 Test methods ... 10
5.5 Partial surface contact error, E (limited by E_{MPE}) ... 10
5.6 Shift error, S (limited by S_{MPE}) ... 12
5.6.1 General ... 12
5.6.2 Shift error — Internal measuring faces ... 12
5.6.3 Shift error — Crossed knife-edge internal measuring faces ... 12
5.6.4 Shift error — Depth or step measuring faces ... 13
5.7 MPE values ... 14
5.8 Special cases ... 14

6 Determination of conformity to specifications ... **14**
6.1 General ... 14
6.2 Measurement uncertainty ... 14
6.3 Decision rule ... 15

7 Marking ... **15**

Annex A (informative) **Calibration guidelines for metrological characteristics** ... **16**

Annex B (normative) **Default MPE values for metrological characteristics** ... **17**

Annex C (informative) **Relation to the GPS matrix model** ... **18**

Bibliography ... **19**