

ISO 10360-2:2009-12 (E)

Geometrical product specifications (GPS) - Acceptance and reverification tests for coordinate measuring machines (CMM) - Part 2: CMMs used for measuring linear dimensions

Contents		Page
Foreword		v
Introduction		vi
1	Scope	1
2	Normative references	1
3	Terms and definitions	2
4	Symbols	4
5	Environmental and metrological requirements	4
5.1	Environmental conditions	4
5.2	Operating conditions	5
5.3	Length measurement error, EL	5
5.4	Repeatability range of the length measurement error, R0	5
5.5	Workpiece loading effects	5
6	Acceptance tests and reverification tests	6
6.1	General	6
6.2	Principle	6
6.3	Length measurement error with zero ram axis stylus tip offset, E0	7
6.3.1	General	7
6.3.2	Measuring equipment	7
6.3.3	Procedure	8
6.3.4	Derivation of test results	9
6.4	Repeatability range of the length measurement error, R0	9
6.5	Length measurement error with ram axis stylus tip offset of 150 mm, E150	10
6.5.1	Measuring equipment	10
6.5.2	Procedure	10
6.5.3	Derivation of test results	12
6.6	Dual ram CMMs	12
6.6.1	Simplex operating mode	12
6.6.2	Duplex operating mode	12
7	Compliance with specifications	13
7.1	Acceptance test	13
7.1.1	Acceptance criteria	13
7.1.2	Data rejection and repeated measurements	14
7.2	Reverification test	14
8	Applications	14
8.1	Acceptance test	14
8.2	Reverification test	15
8.3	Interim check	15
9	Indication in product documentation and data sheets	15

Annex A (informative) Interim check	16
Annex B (normative) Artefacts that represent a calibrated test length	18
Annex C (informative) Alignment of gauges	23
Annex D (normative) Mathematical adjustments to low CTE artefacts	25
Annex E (informative) Location of the single stylus probing test	27
Annex F (informative) Relation to the GPS matrix model	28
Bibliography	29