

# ISO/TS 17865:2016-08 (E)

## Geometrical product specifications (GPS) - Guidelines for the evaluation of coordinate measuring machine (CMM) test uncertainty for CMMs using single and multiple stylus contacting probing systems

---

<b>Contents</b>		<b>Page</b>
Foreword .....		iv
Introduction .....		v
1	Scope .....	1
2	Normative references .....	1
3	Terms and definitions .....	1
4	Test value uncertainty evaluation .....	2
4.1	Effects of fixturing and bending of the test sphere stem .....	2
4.2	Form of the test sphere .....	2
4.3	Test of the probing system form error .....	2
4.4	Test of the probing system size value .....	3
4.5	Test of the probing system location value .....	4
Annex A (informative) Using roundness to approximate form .....		5
Annex B (informative) Relation to the GPS matrix model .....		7
Bibliography .....		8