Irish Standard
I.S. EN ISO 14253-1:2017

Geometrical product specifications (GPS) - Inspection by measurement of workpieces and measuring equipment - Part 1: Decision rules for verifying conformity or nonconformity with specifications (ISO 14253-1:2017)

I.S. EN ISO 14253-1:2017

Incorporating amendments/corrigenda/National Annexes issued since publication:

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NSAI
1 Swift Square,
Northwood, Santry
Dublin 9

T +353 1 807 3800
F +353 1 807 3838
E standards@nsai.ie
W NSAI.ie

Sales:
T +353 1 857 6730
F +353 1 857 6729
W standards.ie

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National Foreword

I.S. EN ISO 14253-1:2017 is the adopted Irish version of the European Document EN ISO 14253-1:2017, Geometrical product specifications (GPS) - Inspection by measurement of workpieces and measuring equipment - Part 1: Decision rules for verifying conformity or nonconformity with specifications (ISO 14253-1:2017)

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EUROPEAN STANDARD

NORME EUROPÉENNE

EUROPÄISCHE NORM

EN ISO 14253-1

December 2017

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English Version

Geometrical product specifications (GPS) - Inspection by measurement of workpieces and measuring equipment - Part 1: Decision rules for verifying conformity or nonconformity with specifications (ISO 14253-1:2017)

Spécification géométrique des produits (GPS) - Vérification par la mesure des pièces et des équipements de mesure - Partie 1: Règles de décision pour contrôler la conformité ou la non-conformité à la spécification (ISO 14253-1:2017)

Geometrische Produktspezifikationen (GPS) - Prüfung von Werkstücken und Messgeräten durch Messen - Teil 1: Entscheidungsregeln für den Nachweis von Konformität oder Nichtkonformität mit Spezifikationen (ISO 14253-1:2017)

This European Standard was approved by CEN on 28 September 2017.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

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European foreword

This document (EN ISO 14253-1:2017) 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 June 2018 and conflicting national standards shall be withdrawn at the latest by June 2018.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 14253-1:2013.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 14253-1:2017 has been approved by CEN as EN ISO 14253-1:2017 without any modification.

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I.S. EN ISO 14253-1:2017

INTERNATIONAL STANDARD

ISO 14253-1

Third edition
2017-10

Geometrical product specifications (GPS) — Inspection by measurement of workpieces and measuring equipment —

Part 1: Decision rules for verifying conformity or nonconformity with specifications

Spécification géométrique des produits (GPS) — Vérification par la mesure des pièces et des équipements de mesure —

Partie 1: Règles de décision pour contrôler la conformité ou la non-conformité à la spécification

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ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

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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 voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was 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*.

This third edition cancels and replaces the second edition (ISO 14253-1:2013), which has been technically revised with the following changes:

— The content applies ISO/IEC Guide 98-4 and gives recommendation for simplification by using intervals representing the underlying probability. As a consequence, the default coverage factor $k = 2$ has been replaced with a default conformance probability of 95 %. This makes the risk constant, regardless of the relationship between the specification interval and the measurement uncertainty. See Annex A for additional information.

— Some terminology has been updated.

— The explanation for the population specification modifier has been removed and can now be found in ISO 18391.

A list of all parts in the ISO 14253 series can be found on the ISO website.

Introduction

This document is a geometrical product specifications (GPS) standard and is to be regarded as a general GPS standard (see ISO 14638). It influences the chain link D of all chains of general GPS standards.

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 document and the default decision rules given in this document apply in ISO/GPS, unless otherwise indicated.

For more detailed information on the relation of this document to other standards and the GPS matrix model, see Annex B for additional information.

The estimated measurement uncertainty is to be taken into account when verifying conformity or nonconformity with specification.

The problem arises when a measured value falls close to the upper or lower specification limit. In this case, verification of conformity or nonconformity with specifications is not possible: the measurement uncertainty induces a probability that a true value of the characteristic is out of specification even if the measured value falls inside the specification zone, or is in specification even if the measured value falls outside.

Therefore, suppliers and customers should agree in advance in a method to resolve any issues that may arise. This document explains how to define default acceptance and rejection zones (i.e. decision rules) for verifying conformity or nonconformity with specifications.

It is not the intention of this document to consider any prior knowledge of the possible values of the measurand(s), e.g. the variability of the measured objects, which may influence the probability of making the correct decision on verification [in mathematical terms, an a priori unconstrained maximum entropy distribution (12) is assumed].

Geometrical product specifications (GPS) — Inspection by measurement of workpieces and measuring equipment —

Part 1:
Decision rules for verifying conformity or nonconformity with specifications

1 Scope

This document establishes the rules for verifying the conformity or nonconformity with a given tolerance for a characteristic of a workpiece (or a population of workpieces) or with a given maximum permissible errors for a metrological characteristic of a measuring equipment, including when the measured value falls close to the specification limits, taking measurement uncertainty into account.

This document applies to specifications defined in general GPS standards (see ISO 14638), i.e. standards prepared by ISO/TC 213, including:

— workpiece specifications and population specifications (usually given as an upper specification limit or a lower specification limit or both);

— measuring equipment specifications (usually given as maximum permissible errors).

This document only applies for characteristics and maximum permissible errors expressed as quantity values.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 3534-2, *Statistics — Vocabulary and symbols — Part 2: Applied statistics*

ISO 9000, *Quality management systems — Fundamentals and vocabulary*

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

ISO/IEC Guide 98-4, *Uncertainty of measurement — Part 4: Role of measurement uncertainty in conformity assessment*

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

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 3534-2, ISO 9000, ISO/IEC Guide 98-3, ISO/IEC Guide 98-4 and ISO/IEC Guide 99 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— ISO Online browsing platform: available at http://www.iso.org/obp