

Content

1	Introduction.....	15
1.1	Functions and Objectives of Production Metrology.....	15
1.2	Historical Development of Production Metrology.....	19
1.3	Production Metrology as a Component of Quality Management.....	22
1.4	Overview of Production Metrology.....	27
2	Fundamentals of Production Metrology.....	33
2.1	Basic Concepts.....	33
2.1.1	Introduction to the SI-System of Units.....	33
2.1.2	Definitions.....	37
2.1.3	Measuring Methods.....	41
2.1.4	Measurement Strategies.....	43
2.2	Measure Embodiments.....	44
2.2.1	Gauge Blocks.....	45
2.2.2	Incremental Measure Embodiments.....	50
2.2.3	Absolute encoded measure embodiments.....	55
2.3	Measurement Uncertainty and Measurement Error.....	57
2.3.1	Definitions and Terms.....	57
2.3.2	Factors Influencing Measurement Error.....	59
2.3.3	Procedures for estimating measurement uncertainty.....	72

2.3.4	Measurement Uncertainty and Tolerance	78
2.4	Measurement rooms.....	79
2.5	Drawings specifications and tolerances.....	83
2.5.1	Dimensions, dimensional tolerances and fits.....	85
2.5.2	Tolerance of form and position.....	90
2.5.3	Tolerancing principles	107
2.5.4	Geometrical product specification and inspection (GPS).....	109
3	Inspection Planning	119
3.1	Tasks of Inspection Planning	120
3.2	Procedure for Setting Up an Inspection Plan.....	121
3.2.1	Definition of the Inspection Plan Header	122
3.2.2	Selection of Inspection Characteristics.....	123
3.2.3	Determining Inspection Time	125
3.2.4	Determining Inspection Type	125
3.2.5	Determining the Inspection Extent	127
3.2.6	Selection of Inspection Site and Personnel.....	129
3.2.7	Selection of Inspection Equipment	130
3.2.8	Inspection Text and Documentation	132
3.3	Utilisation of Results	133
3.4	Possible fields of application	134
4	Test Data Acquisition	137
4.1	Shop floor Inspection Equipment	137
4.1.1	Callipers and Height Measuring Devices	138
4.1.2	Micrometers	141
4.1.3	Display Sensors with Mechanical Transmission	143
4.1.4	Angle Measuring Devices.....	146

4.2	Measuring Sensors.....	147
4.2.1	Potentiometer Sensors.....	147
4.2.2	Inductive Sensors.....	151
4.2.3	Capacitive Sensors.....	158
4.2.4	Pneumatic Sensors.....	160
4.2.5	Ultrasonic Measuring Methods.....	164
4.2.6	Measuring Sensors with an Incremental Material Measure.....	167
4.2.7	Sensors with Encoded Material Measures.....	174
4.3	Optical and Optoelectronic Testing Equipment.....	176
4.3.1	Optical and Optoelectronic Elements.....	177
4.3.2	Camera Metrology.....	185
4.3.3	Laser Metrology.....	220
4.3.4	Optical Measuring Devices.....	242
4.4	Coordinate Measuring Technology.....	252
4.4.1	Fundamentals of Coordinate Measuring Technology.....	252
4.4.2	System Components and Designs of Coordinate Measuring Machines.....	265
4.4.3	Application of Coordinate Metrology.....	274
4.5	Form and Surface Testing Technology.....	280
4.5.1	Form Testing Technology.....	280
4.5.2	Surface Inspection Technology.....	294
4.6	Gauging Inspection.....	304
4.6.1	Taylor's Principle.....	305
4.6.2	Types of Gauging Inspections.....	306
4.6.3	Norms for Gauging Inspection.....	312
4.6.4	Principle of Virtual Gauging.....	313
4.7	Integration of inspection devices into automated measuring applications.....	315
4.7.1	Electronic Handheld Measuring Devices at the Computer-Aided Measuring Station.....	316
4.7.2	Robot-Aided Measurement Devices.....	318

4.7.3	Multi-Point Measuring Devices.....	321
5	Test Data Evaluation	333
5.1	Fundamental Statistical Principles.....	334
5.1.1	Descriptive Statistics	335
5.1.2	Distributions.....	345
5.1.3	Inductive Statistics	352
5.2	Statistical Process Control	365
5.2.1	Random Sample Testing Schedules.....	365
5.2.2	Structure, Design and Application of Shewart-Quality Control Charts	366
5.2.3	Statistical Background	370
5.2.4	Practical use of the Control Chart Technique.....	374
5.2.5	Newer Types of Quality Control charts.....	377
5.2.6	Boundary Conditions for the Use of Control Charts	381
5.3	Capability of Production Processes	382
6	Management of Inspection Equipment.....	392
6.1	Inspection Equipment Monitoring	394
6.1.1	Traceability	396
6.1.2	Inspection Equipment-Specific Monitoring.....	398
6.1.3	Inspection Task-Specific Monitoring	401
6.1.4	Dynamic Inspection Equipment Monitoring.....	406
6.2	Inspection Equipment Planning and Provision	407
6.3	Inspection Equipment Management	408
7	Index.....	415