

<b>STN</b>	<b>Geometrické špecifikácie výrobkov (GPS) Meradlá dĺžok Časť 2: Posuvné hĺbkomery Konštrukcia a metrologické požiadavky (ISO 13385-2: 2020)</b>	<b>STN EN ISO 13385-2</b>  99 2011
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Geometrical product specifications (GPS) - Dimensional measuring equipment - Part 2: Design and metrological characteristics of calliper depth gauges (ISO 13385-2:2020)

Táto norma obsahuje anglickú verziu európskej normy.  
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 10/20

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English Version

## Geometrical product specifications (GPS) - Dimensional measuring equipment - Part 2: Design and metrological characteristics of calliper depth gauges (ISO 13385-2:2020)

Spécification géométrique des produits (GPS) -  
Équipement de mesurage dimensionnel - Partie 2:  
Caractéristiques de conception et caractéristiques  
métrologiques des jauges de profondeur (ISO 13385-  
2:2020)

Geometrische Produktspezifikation (GPS) -  
Längenmessgeräte - Teil 2: Tiefenmessschieber;  
Konstruktionsmerkmale und messtechnische  
Anforderungen (ISO 13385-2:2020)

This European Standard was approved by CEN on 22 March 2020.

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**EN ISO 13385-2:2020 (E)**

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## **European foreword**

This document (EN ISO 13385-2:2020) 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of an identical text or by endorsement, at the latest by November 2020, and conflicting national standards shall be withdrawn at the latest by November 2020.

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 13385-2:2011.

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, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

## **Endorsement notice**

The text of ISO 13385-2:2020 has been approved by CEN as EN ISO 13385-2:2020 without any modification.

**INTERNATIONAL  
STANDARD**

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2020-05

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**Geometrical product specifications  
(GPS) — Dimensional measuring  
equipment —**

**Part 2:  
Design and metrological  
characteristics of calliper depth gauges**

*Spécification géométrique des produits (GPS) — Équipement de  
mesurage dimensionnel —*

*Partie 2: Caractéristiques de conception et caractéristiques  
métrologiques des jauges de profondeur*



Reference number  
ISO 13385-2:2020(E)

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## ISO 13385-2:2020(E)

### 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](http://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](http://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 of 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 [www.iso.org/iso/foreword.html](http://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 the European Committee for Standardization (CEN) Technical Committee CEN/TC 290, *Dimensional and geometrical product specification and verification*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

This second edition cancels and replaces the first edition (ISO 13385-2:2011), which has been technically revised.

The main changes to the previous edition are as follows:

- figures have been updated to show more modern technology;
- general design characteristics have been removed and reference to ISO 14978:2018 included;
- metrological characteristics have been clarified and modified;
- requirements for test methods have been included;
- default values for maximum permissible errors have been added.

A list of all parts in the ISO 13385 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

## Introduction

This document is a geometrical product specification (GPS) standard and is to be regarded as a general GPS standard (see ISO 14638). It influences chain links F and G of the chain of standards on size and distance in the general GPS matrix (see [Annex C](#)).

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 ISO 14253-1 apply to specifications made in accordance with this document, unless otherwise indicated; see ISO/TR 14253-6 for additional information on the selection of alternative decision rules.

For more detailed information on the relation of this document to other standards and the GPS matrix model, see [Annex C](#).

# Geometrical product specifications (GPS) — Dimensional measuring equipment —

## Part 2: Design and metrological characteristics of calliper depth gauges

### 1 Scope

This document specifies the most important design and metrological characteristics of calliper depth gauges

- with analogue indication: vernier scale or circular scale (dial); and
- with digital indication: digital display.

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

ISO 14253-5, *Geometrical product specifications (GPS) — Inspection by measurement of workpieces and measuring equipment — Part 5: Uncertainty in verification testing of indicating measuring instruments*

ISO/TR 14253-6, *Geometrical product specifications (GPS) — Inspection by measurement of workpieces and measuring equipment — Part 6: Generalized decision rules for the acceptance and rejection of instruments and workpieces*

ISO 14978:2018, *Geometrical product specifications (GPS) — General concepts and requirements for GPS measuring equipment*

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

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

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