



Certification Details for MyCare:

We offer Non-Accredited and ISO 17025 Accredited certifications. Both Non-Accredited and Accredited offer a preventive maintenance to look for potential problems and optimize the mechanics of the machine to the electronic configuration. One of two standards can be selected for the evaluation, **ISO 10360 and ASME B894.1 1997/2001**

Annual Certification - Offered as Non-Accredited

- Post Measurements only, Minor Squareness and Roll corrections only
- B89RV - Repeat (B89.4.1 sec 5.3) • Volumetric Performance (B89.4.1. sec 5.5)
 - Evaluates the machines and probes ability to repeat a measurement and determines if the machine geometry has changed.
 - Machine scale lengths are not evaluated to a calibrated standard.
- B89RVL - Repeat (B89.4.1 sec 5.3) • Volumetric Performance (B89.4.1. sec 5.5) • X, Y, & Z linear displacement accuracy (LDA) using a Step Gage (B89.4.1. sec 5.2) or a Laser (B89.4.1. sec 5.4.3) depending on equipment availability
 - Evaluates the machines and probes ability to repeat a measurement, determines if the machine geometry has changed, and determines accuracy of the scales. The combination of the LDA for X, Y, and Z axis allows a complete performance evaluation.
 - Combined tests: Repeat, Volumetric, and Linear Displacement is offered as an Accredited Test
- ISO 10360 Geometrical product specifications (GPS)
- ISO 10360- 2: (2001 or 2009 Version) — Part 2: CMMs used for measuring linear dimensions
 - ISO 10360 -3 :2000 — Part 3: CMMs with the axis of a rotary table as the fourth axis
 - ISO 10360 -4 :2000 — Part 4: CMMs used in scanning measuring mode
 - ISO 10360 -5: (2001 or 2009) — Part 5: CMMs using single and multiple stylus contacting probing systems, a single stylus is used by default, however a star probe/styli can be evaluated and tested upon request.
 - ISO 10360 -7:2011— Part 7: CMMs equipped with imaging probing systems E1, E2, E3 Tests, PFV Field of View Circle Test and PF2d Camera and Machine 2d Test
 - ISO 10360 -8:2013 — Part 8: CMMs with optical distance sensors, When the machine being tested was sold with an optical probe/sensor, this test can be provided upon request
 - ISO 10360 -9:2013 — Part 9: CMMs with multiple probing systems, When the machine being tested was sold with multiple probe systems, this test can be provided upon request





ISO 17025 Accreditations offer certifications with strict guidelines

Customers must adhere to a stable environment, requires pre and post measurements, and provides measurement and test uncertainties.

- Pre and Post measurements are defined as
 - Pre-measurements is a complete evaluation of the machine using the selected tests is performed as the machine is before adjustments are made
 - Post measurements are done as the final certification of the machine after all the geometrical adjustments are performed.
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 - ISO 10360 -7:2011— Part 7: CMMs equipped with imaging probing systems E1, E2, E3 Tests



HEXAGON

Why do B89RV or Repeat and volumetric tests say Non-Accredited within the Certification?

Hexagon process and testing comply with the ISO 17025 standard and we understand the confusion you may have with the ball bar and repeatability statement saying, "Non-Accredited Test" on our certificate. Hexagon must add this to our certification to identify that these tests are evaluating the machine's geometry by comparing the lengths from different positions on the machine but are not a traceable length standard.

The repeatability sphere and ball bar spheres are only calibrated for form and not actual size. In addition, the ball bar is screwed together to make up the overall length to measure which is then measured and compared. If the Hexagon Ball bar is disassembled and reassembled the assembled length will be different. For this reason, the tests have been removed from our scope and are marked as Non-Accredited Tests. The test, however, is a valid ISO 17025 Certification when combined with the Linear Displacement Accuracy (LDA) tests (X, Y, & Z scale measurements) as derived from B89 4.1-1997/2001b, Section 5.4 because the artifact used is a traceable length standard. Using this LDA tests in combination with the ball bar accurately validates your machine's accuracy.