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Statistical methods in process management — Capability and performance —

Part 7: Capability of measurement processes

*Méthodes statistiques dans la gestion de processus — Aptitude et
performance —*

Partie 7: Aptitude des processus de mesure



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Contents

	Page
Foreword	v
Introduction	vi
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Symbols and abbreviated terms	6
4.1 Symbols.....	6
4.2 Abbreviated terms.....	9
5 Basic principles	9
5.1 General.....	9
5.2 Resolution.....	12
5.3 Maximum permissible error known and used.....	12
5.3.1 General.....	12
5.3.2 MPE, maximum permissible deviation of the measuring system — u_{MPE}	12
5.4 Capability and performance limits for a measuring system and measurement process.....	13
6 Implementation	13
6.1 General.....	13
6.2 Factors that influence the measurement process.....	13
6.2.1 General.....	13
6.2.2 Uncertainty components that belong to the measuring system.....	14
6.2.3 Additional uncertainty components belonging to the measurement process.....	16
7 Studies for calculating the uncertainty components	19
7.1 Measuring system.....	19
7.1.1 General.....	19
7.1.2 Repeatability and bias based on one reference standard.....	19
7.1.3 Standard uncertainty from the linearity deviation — u_{LIN}	20
8 Calculation of combined uncertainty	23
8.1 General.....	23
8.2 Calculation of expanded uncertainty.....	25
9 Capability	26
9.1 Performance ratios.....	26
9.1.1 General.....	26
9.1.2 Performance ratio of the measuring system.....	26
9.1.3 Performance ratio of the measurement process.....	26
9.2 Capability indices.....	26
9.3 Capability of a measurement process with one-sided specifications.....	27
10 Capability of the measurement process compared to the capability of the production process	31
10.1 Relation between observed process capability and measurement capability ratios.....	31
10.2 Relation between observed process capability and measurement capability.....	32
11 Ongoing review of the measurement process stability	33
11.1 Ongoing review of the stability.....	33
12 Capability of attribute measurement processes	34
12.1 General.....	34
12.2 Capability calculations without using reference values.....	34
12.3 Capability calculations using reference values.....	35
12.3.1 Calculation of the uncertainty range.....	35
12.3.2 Symbols.....	36
12.3.3 Working steps for determining the uncertainty range.....	37

This is a preview of "ISO 22514-7:2021". [Click here to purchase the full version from the ANSI store.](#)

12.4 Ongoing review.....	38
Annex A (informative) Examples.....	40
Annex B (informative) Statistical methods used.....	46
Bibliography.....	51

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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).

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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.

This document was prepared by Technical Committee ISO/TC 69, *Applications of statistical methods*, Subcommittee SC 4, *Applications of statistical methods in product and process management*.

This second edition cancels and replaces the first edition (ISO 22514-7:2012), which has been technically revised.

The main changes compared to the previous edition are as follows:

- use of the MPE values in the calculations;
- revision of the calculation of the linearity, with amendments in the example in [Clause A.1](#);
- addition of a method to calculate the capability when the specifications of the characteristic of interest is defined as a one-sided specification (new [9.3](#)).

A list of all parts in the ISO 22514 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.

Introduction

The purpose of a measurement process is to produce measurement results obtained from defined characteristics on parts or processes. The capability of a measurement process is derived from the statistical properties of measurements from a measurement process that is operating in a predictable manner.

Calculations of capability and performance indices are based on measurement results. The uncertainty of the measurement process used to generate capability and performance indices are estimated before the indices can be meaningful. The actual measurement uncertainty should be adequately small.

If the measurement process is used to judge whether a characteristic of a product conforms to a specification or not, the uncertainty of the measurement process is compared to the specification itself. If the measurement process is used for process control of a characteristic, the uncertainty should be compared with the process variation. Limits of acceptability are stated for both cases.

The quality of measurement results is given by the uncertainty of the measurement process. This is defined by the statistical properties of multiple measurements, or estimates of properties, based on the knowledge of the measurement process.

The methods specified in this document address the implementation uncertainty (for more information on implementation uncertainty, see ISO 17450-2). Therefore, they are only useful if it is known that the method uncertainty and the specification uncertainty are small compared to the implementation uncertainty. This document specifies methods to define and calculate capability indices for measurement processes based on estimated uncertainties. The approach given in ISO/IEC Guide 98-3 (GUM) is the basis of this approach.