Dimension measured on the tolerance limit — the three ways of doing it

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Fictional document

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> **Fictional document**, produced for the demonstration. The organisation, the files, the people and the figures are invented. **None of the ways of doing it was applied before the client chose.**

The inspection sheet says « within tolerance ». It does not say whether the limit is included, nor what is done with the instrument's uncertainty: that is the point that had not yet been configured.

The ways of doing it, put to the client

Way of doing it	What it brings	What it costs	Outcome
Limit included, conforming	The part ships today	Half the instrument's uncertainty lies outside tolerance	Set aside by inspection

Way of doing it	What it brings	What it costs	Outcome
Limit excluded, non-conforming	No risk of shipping out of tolerance	Good parts scrapped, and a bore reworks badly	Set aside by inspection
Limit included, instrument uncertainty deducted, calculation written on the sheet	**The decision bears on what the instrument can measure**	One more calculation line on the sheet	**Recommended, then approved — the inspector signs**

How often the case arises

Period	Measurements falling on a limit	Of which on the TR-118 bore
Last twelve months	**41**	**29**
Of which the last quarter	12	9

The figure is what turns a one-off decision into a rule: **29 measurements on the same dimension** are worth an entry in the inspection sheet, and inspection decides it knowing the volume.

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