
**Hand-held portable power tools — Test
methods for evaluation of vibration
emission —**

**Part 4:
Straight grinders**

*Machines à moteur portatives — Méthodes d'essai pour l'évaluation de
l'émission de vibrations —*

Partie 4: Meuleuses droites



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Contents

Page

Foreword	iv
Introduction.....	vi
1 Scope.....	1
2 Normative references.....	1
3 Terms, definitions and symbols	2
3.1 Terms and definitions	2
3.2 Symbols.....	2
4 Basic standards and vibration test codes	3
5 Description of the family of machines	3
6 Characterization of vibration.....	4
6.1 Direction of measurement	4
6.2 Location of measurements.....	4
6.3 Magnitude of vibration	5
6.4 Combination of vibration directions.....	5
7 Instrumentation requirements	5
7.1 General	5
7.2 Mounting of transducers	5
7.3 Frequency-weighting filter.....	6
7.4 Integration time.....	6
7.5 Auxiliary equipment	6
7.6 Calibration	6
8 Testing and operating conditions of the machinery.....	6
8.1 General	6
8.2 Operating conditions	7
8.3 Other quantities to be specified.....	7
8.4 Attached equipment, work piece and task.....	7
8.5 Operator	10
9 Measurement procedure and validity	10
9.1 Reported vibration values	10
9.2 Declaration and verification of the vibration emission value	11
10 Measurement report	11
Annex A (informative) Model test report for vibration emission of straight grinders.....	13
Annex B (normative) Determination of uncertainty	15
Annex C (normative) Design of test wheel.....	17
Bibliography.....	23

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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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.

ISO 28927-4 was prepared by Technical Committee ISO/TC 118, *Compressors and pneumatic tools, machines and equipment*, Subcommittee SC 3, *Pneumatic tools and machines*.

This first edition of ISO 28927-4, together with ISO 28927-1, cancels and replaces ISO 8662-4:1994, of which it constitutes a technical revision. The most important changes are

- vibration measurement in three axes and at both hand positions;
- new transducer locations with improved definitions of the transducer positions and orientation are used;
- rotational speed is raised to no load free running speed;
- the test wheels are modified and the definition is improved.

ISO 28927 consists of the following parts, under the general title *Hand-held portable power tools — Test methods for evaluation of vibration emission*:

- *Part 1: Angle and vertical grinders*
- *Part 2: Wrenches, nutrunners and screwdrivers¹⁾*
- *Part 3: Polishers and rotary, orbital and random orbital sanders²⁾*
- *Part 4: Straight grinders³⁾*
- *Part 5: Drills and impact drills⁴⁾*

1) Replaces ISO 8662-7, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 7: Wrenches, screwdrivers and nut runners with impact, impulse or ratchet action*. All screwdrivers and nutrunners except for one-shot tools now covered.

2) Replaces ISO 8662-8, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 8: Polishers and rotary, orbital and random orbital sanders*.

3) Together with ISO 28927-1, replaces ISO 8662-4, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 4: Grinders*.

- Part 6: Rammers⁵⁾
- Part 7: Nibblers and shears⁶⁾
- Part 8: Saws, polishing and filing machines with reciprocating action and small saws with oscillating or rotating action⁷⁾
- Part 9: Scaling hammers and needle scalers⁸⁾
- Part 10: Percussive drills, hammers and breakers⁹⁾
- Part 11: Stone hammers¹⁰⁾
- Part 12: Die grinders¹¹⁾

4) Replaces ISO 8662-6, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 6: Impact drills*. Non-impacting drills now covered.

5) Replaces ISO 8662-9, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 9: Rammers*.

6) Replaces ISO 8662-10, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 10: Nibblers and shears*.

7) Replaces ISO 8662-12, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 12: Saws and files with reciprocating action and saws with oscillating or rotating action*.

8) Together with ISO 28927-11 (to be published), replaces ISO 8662-14, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 14: Stone-working tools and needle scalers*.

9) To be published. Replaces ISO 8662-2, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 2: Chipping hammers and riveting hammers*, ISO 8662-3, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 3: Rock drills and rotary hammers*, and ISO 8662-5, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 5: Pavement breakers and hammers for construction work*. It also incorporates the Amendments ISO 8662-2:1992/Amd.1:1999, ISO 8662-3:1992/Amd.1:1999 and ISO 8662-5:1992/Amd.1:1999. Chipping and riveting hammers, rock drills and rotary hammers all covered.

10) To be published. Together with ISO 28927-9, replaces ISO 8662-14, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 14: Stone-working tools and needle scalers*.

11) To be published. Replaces ISO 8662-13, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 13: Die grinders*. It also incorporates the Technical Corrigendum ISO 8662-13:1997/Cor.1:1998.

Introduction

This document is a type-C standard as stated in ISO 12100.

When requirements of this type-C standard are different from those which are stated in type-A or -B standards, the requirements of this type-C standard take precedence over the requirements of the other standards for machines that have been designed and built according to the requirements of this type-C standard.

The vibration test codes for portable hand-held machines given in ISO 28927 (all parts) are based on ISO 20643, which gives general specifications for the measurement of the vibration emission of hand-held and hand-guided machinery. ISO 28927 (all parts) specifies the operation of the machines under type-test conditions and other requirements for the performance of type tests. The structure/numbering of its clauses follows that of ISO 20643.

The basic principle for transducer positioning first introduced in the EN 60745 series of European standards is followed, representing a deviation from ISO 20643 for reasons of consistency. The transducers are primarily positioned next to the hand in the area between the thumb and the index finger, where they give the least disturbance to the operator gripping the machine.

It has been found that vibrations generated by grinders vary considerably in typical use. The variation is largely due to the variances in the unbalance of the machine with the grinding wheel mounted. The unbalance also changes when the wheel is worn through the operation.

In order to provide a method that gives good measurement reproducibility, the procedure adopted in this part of ISO 28927 uses a test wheel of known unbalance mounted on a machine and run under no-load conditions. The unbalance for the different types of test wheels are chosen to give vibration values that are as far as possible in accordance with ISO 20643. The procedures of ISO 5349 (all parts) are required whenever exposure at the workplace is to be assessed.

Underestimation of the vibration for machines equipped with technical means to automatically reduce unbalances is taken into account by multiplying the vibration values of such machines with a correction factor of 1,3.

The values obtained are type-test values intended to be representative of the average of the upper quartile of typical vibration magnitudes in real-world use of the machines. However, the actual magnitudes vary considerably from time to time and depend on many factors, including the operator, the task and the inserted tool or consumable. The state of maintenance of the machine itself might also be of importance. Under real working conditions the influences of the operator and process can be particularly important at low magnitudes. It is therefore not recommended that emission values below $2,5 \text{ m/s}^2$ be used for estimating the vibration magnitude under real working conditions. In such cases, $2,5 \text{ m/s}^2$ is the recommended vibration magnitude for estimating the machine vibration.

If accurate values for a specific work place are required, then measurements [according to ISO 5349 (all parts)] in that work situation could be necessary. Vibration values measured in real working conditions can be either higher or lower than the values obtained using this part of ISO 28927.

Higher vibration magnitudes can easily occur in real work situations caused by the use of excessively unbalanced grinding wheels, worn flanges or bent spindles.

The vibration test codes given in ISO 28927 (all parts) supersede those given in ISO 8662 (all parts), which has been replaced by the corresponding parts of ISO 28927 (see Foreword).

NOTE ISO 8662-11, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 11: Fastener driving tools* could be replaced by a future part of ISO 28927.

Hand-held portable power tools — Test methods for evaluation of vibration emission —

Part 4: Straight grinders

1 Scope

This part of ISO 28927 specifies a laboratory method for measuring hand-transmitted vibration emission at the handles of straight grinders. It is a type-test procedure for establishing the magnitude of vibration in the gripping areas of a machine fitted with a specified test wheel and run under no-load conditions.

This part of ISO 28927 is applicable to hand-held machines (see Clause 5), driven pneumatically or by other means, intended for grinding and surface finishing using straight grinding wheels type 1, tapered wheels type 4 and cylindrical plugs, e.g. of type 16 (cylindrical plug, tapered cone), 18 (cylindrical plug, flat end), 18R (cylindrical plug, rounded end) and 19 (cylindrical plug, taper-roll shaped), for use on all kinds of materials. It is not applicable to grinders used with wire brushes, nor is it applicable to die grinders where the inserted tool is mounted in a collet.

NOTE 1 Typical machines covered by this part of ISO 28927 are illustrated in Figures 1 to 3.

It is intended that the results be used to compare different models of the same type of machine.

NOTE 2 To avoid confusion with the terms “power tool” and “inserted tool”, “machine” is used hereinafter for the former.

2 Normative references

The following referenced documents are indispensable for the application 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 603-12:1999, *Bonded abrasive products — Dimensions — Part 12: Grinding wheels for deburring and fettling on a straight grinder*

ISO 2787:1984, *Rotary and percussive pneumatic tools — Performance tests*

ISO 4026:2003, *Hexagon socket set screws with flat point*

ISO 4027:2003, *Hexagon socket set screws with cone point*

ISO 4029:2003, *Hexagon socket set screws with cup point*

ISO 5349-1:2001, *Mechanical vibration — Measurement and evaluation of human exposure to hand-transmitted vibration — Part 1: General requirements*

ISO 5349-2:2001, *Mechanical vibration — Measurement and evaluation of human exposure to hand-transmitted vibration — Part 2: Practical guidance for measurement at the workplace*

ISO 5391:2003, *Pneumatic tools and machines — Vocabulary*

ISO 17066:2007, *Hydraulic tools — Vocabulary*

ISO 20643:2005, *Mechanical vibration — Hand-held and hand-guided machinery — Principles for evaluation of vibration emission*

EN 755-2:2008, *Aluminium and aluminium alloys — Extruded rod/bar, tube and profiles — Part 2: Mechanical properties*

EN 12096:1997, *Mechanical vibration — Declaration and verification of vibration emission values*

3 Terms, definitions and symbols

For the purposes of this document, the terms and definitions given in ISO 5391, ISO 17066 and ISO 20643, and the following apply.

3.1 Terms and definitions

3.1.1

straight grinder

grinder where the handle, motor and the spindle are coaxially aligned

[ISO 5391:2003, definition 2.1.3.1]

3.1.2

test wheel

aluminium wheel geometrically similar to a real grinding wheel with holes on specified radii to give defined unbalances

3.2 Symbols

Symbol	Description	Unit
a_{hw}	root-mean-square (r.m.s.) single-axis acceleration value of the frequency-weighted hand-transmitted vibration	m/s ²
a_{hv}	vibration total value of frequency-weighted r.m.s. acceleration is the root sum of squares of the a_{hw} values for the three measured axes of vibration	m/s ²
a_{hvmeas}	a_{hv} as measured during the test	m/s ²
a_{hvrat}	a_{hv} at rated no-load speed	m/s ²
$\overline{a_{hv}}$	arithmetic mean value of a_{hv} values of runs for one operator for one hand position	m/s ²
$\overline{a_h}$	arithmetic mean value of $\overline{a_{hv}}$ values for all operators for one hand position	m/s ²
$\overline{\overline{a_h}}$	arithmetic mean value of $\overline{a_h}$ values for one hand position on several machines	m/s ²
a_{hd}	declared vibration emission value	m/s ²
n_{meas}	measured no-load speed during the test with the test wheel mounted	r/min
n_{rat}	rated no-load speed is the maximum rotational-speed of the machine according to the speed marking of the machine	r/min
s_{n-1}	standard deviation for a test series (for a sample)	m/s ²
σ_R	standard deviation of reproducibility (for a population)	m/s ²
C_V	coefficient of variation for a test series	—
K	uncertainty	m/s ²