
International Standard



6480

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Conditions of acceptance for horizontal internal broaching machines — Testing of the accuracy

Conditions de réception des machines horizontales à brocher les intérieurs — Contrôle de la précision

Second edition — 1983-04-01

UDC 621.919.3-187

Ref. No. ISO 6480-1983 (E)

Descriptors : machine tools, broaching machines, designation, tests, testing conditions, dimensional deviations, precision.

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been authorized 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 6480 was developed by Technical Committee ISO/TC 39, *Machine tools*.

This second edition was submitted directly to the ISO Council, in accordance with clause 6.11.2 of part 1 of the Directives for the technical work of ISO. It cancels and replaces the first edition (i.e. ISO 6480-1980), which had been approved by the member bodies of the following countries :

Australia	India	South Africa, Rep. of
Belgium	Italy	Spain
Brazil	Japan	Sweden
Chile	Korea, Dem. P. Rep. of	Turkey
Czechoslovakia	Korea, Rep. of	United Kingdom
France	Libyan Arab Jamahiriya	USA
Germany, F.R.	Poland	USSR
Hungary	Romania	Yugoslavia

No member body had expressed disapproval of the document.

Conditions of acceptance for horizontal internal broaching machines — Testing of the accuracy

1 Scope and field of application

This International Standard specifies, with reference to ISO/R 230, geometrical tests for general purpose and normal accuracy machines and gives the corresponding permissible deviations which apply. This International Standard also gives the terminology used for the main elements of the machine.

NOTE — In addition to terms used in the three official ISO languages (English, French and Russian), this International Standard gives, in the annex, the equivalent terms in German and Italian. These have been included at the request of ISO Technical Committee TC 39 and are published under the responsibility of the Member Bodies for Germany, F.R. (DIN) and Italy (UNI). However, only the terms given in the official languages can be considered as ISO terms.

It deals only with the verification of accuracy of the machine. It does not apply to the testing of the running of the machine (vibrations, abnormal noises, stick-slip motion of components, etc.), nor to its characteristics (speeds, feeds, etc.) which should generally be checked before testing accuracy.

2 Reference

ISO/R 230, *Machine tool test code*.

3 Preliminary remarks

3.1 In this International Standard, all dimensions and permissible deviations are expressed in millimetres and in inches.

3.2 To apply this International Standard, reference should be made to ISO/R 230, especially for installation of the machine before application of the methods of acceptance, warming up of moving parts, description of measuring methods, and recommended accuracy of testing equipment.

3.3 The sequence in which the geometrical tests are given is related to the sub-assemblies of the machine and this in no way defines the practical order of testing. In order to make the mounting of instruments or gauging easier, tests may be applied in any order.

3.4 When inspecting a machine, it is not always necessary to carry out all the tests given in this International Standard. The user may choose, in agreement with the manufacturer, those tests relating to the properties which are of interest to him, but these tests shall be clearly stated when ordering a machine.

3.5 Because of the diversity of shape of the pieces, practical tests have not been included. If the user wishes to carry out a practical test, this test shall be stated in agreement with the manufacturer.

3.6 When establishing the tolerance for a measuring range different from that given in this International Standard (see clause 2.311 in ISO/R 230), it should be taken into consideration that the minimum value of tolerance, for geometrical tests as well as for practical tests, is 0,01 mm (0.000 4 in).