INTERNATIONAL STANDARD

ISO 10791-2

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Test conditions for machining centres —

Part 2: Geometric tests for machines with vertical spindle or universal heads with vertical primary rotary axis (vertical Z-axis)

Conditions d'essai des centres d'usinage —

Partie 2: Essais géométriques des machines à broche verticale ou à têtes universelles à axe principal de rotation vertical (axe Z vertical)

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Contents

Page

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 3.

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 part of ISO 10791 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 10791-2 was prepared by Technical Committee ISO/TC 39, *Machine tools*, Subcommittee SC 2, *Test conditions for metal-cutting machine tools*.

ISO 10791 consists of the following parts, under the general title *Test conditions for machining centres*:

— *Part 1: Geometric tests for machines with horizontal spindle and with accessory heads (horizontal Z-axis)*

— *Part 2: Geometric tests for machines with vertical spindle or universal heads with vertical primary rotary axis (vertical Z-axis)*

— *Part 3: Geometric tests for machines with integral indexable or continuous universal heads (vertical Z-axis)*

— *Part 4: Accuracy and repeatability of positioning of linear and rotary axes*

— *Part 5: Accuracy and repeatability of positioning of work-holding pallets*

— *Part 6: Accuracy of feeds, speeds and interpolations*

— *Part 7: Accuracy of a finished test piece*

— *Part 8: Evaluation of the contouring performance in the three coordinate planes*

— *Part 9: Evaluation of the operating times of tool change and pallet change*

— *Part 10: Evaluation of the thermal distortions*

— *Part 11: Evaluation of the noise emission*

Annexes A, B and C form a normative part of this part of ISO 10791.

Introduction

A machining centre is a numerically controlled machine tool capable of performing multiple machining operations, including milling, boring, drilling and tapping, as well as automatic tool changing from a magazine or similar storage unit in accordance with a machining programme.

The purpose of ISO 10791 is to supply information as wide and comprehensive as possible on tests and checks which can be carried out for comparison, acceptance, maintenance or any other purpose.

ISO 10791 specifies, by reference to the relevant parts of ISO 230, *Test code for machine tools*, several families of tests for machining centres with horizontal or vertical spindle or with universal heads of different types, standing alone or integrated in flexible manufacturing systems. ISO 10791 also establishes the tolerances or maximum acceptable values for the test results corresponding to general purpose and normal accuracy machining centres.

ISO 10791 is also applicable, totally or partially, to numerically controlled milling and boring machines, when their configuration, components and movements are compatible with the tests described herein.

Test conditions for machining centres —

Part 2:
Geometric tests for machines with vertical spindle or universal heads with vertical primary rotary axis (vertical Z-axis)

1 Scope

This part of ISO 10791 specifies, with reference to ISO 230-1, the geometric tests for machining centres (or numerically controlled milling machines, boring machines, etc., where applicable) with vertical spindle (that is vertical Z-axis).

This part of ISO 10791 applies to machining centres having basically three numerically controlled axes, that is three linear axes (X, Y and Z) of up to 2 000 mm length, but also refers to supplementary motions, such as rotary axes (A′, B′ and C′), those of rams, quill, or universal heads. Motions other than those mentioned are considered as special features and the relevant tests are not included in this part of ISO 10791.

This part of ISO 10791 describes geometric tests for optional horizontal spindles as well as for two possible types of universal heads in the following annexes:

— annex A: optional horizontal spindles (tests AG1 to AG6);

— annex B: rotary heads, with one numerically controlled rotary axis (tests BG1 and BG2);

— annex C: swivel heads, with two numerically controlled rotary axes perpendicular to each other (tests CG1 to CG7).

This part of ISO 10791 deals only with the verification of the accuracy of the machine. It does not apply to the testing of the machine operation, which should be checked separately. Some tests concerning the performance of the machine operating under no-load or finishing conditions are included in other parts of ISO 10791.

2 Normative references

The following normative documents contain provisions, which, through reference in this text, constitute provisions of this part of ISO 10791. For dated references, subsequent amendments to, or revisions of, any of these publications do not apply. However, parties to agreements based on this part of ISO 10791 are encouraged to investigate the possibility of applying the most recent editions of the normative documents indicated below. For undated references, the latest edition of the normative document referred to applies. Members of ISO and IEC maintain registers of currently valid International Standards.

ISO 230-1:1996, *Test code for machine tools — Part 1: Geometric accuracy of machines operating under no-load or finishing conditions*.

ISO 8526-1:1990, *Modular units for machine tools — Workholding pallets — Part 1: Workholding pallets up to 800 mm nominal size*.

ISO 8526-2:1990, *Modular units for machine tools — Workholding pallets — Part 2: Workholding pallets of nominal size greater than 800 mm*.