

INTERNATIONAL STANDARD

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Modular units for machine tools — Workholding pallets —

Part 1: Workholding pallets up to 800 mm nominal size

Éléments standards pour machines-outils — Palettes —

Partie 1: Palettes porte-pièce de dimension nominale jusqu'à 800 mm



Reference number
ISO 8526-1 : 1990 (E)

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.

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.

International Standard ISO 8526-1 was prepared by Technical Committee ISO/TC 39, *Machine tools*.

ISO 8526 consists of the following parts, under the general title *Modular units for machine tools — Workholding pallets*:

- *Part 1: Workholding pallets up to 800 mm nominal size*
- *Part 2: Workholding pallets of nominal size greater than 800 mm*

Annex A forms an integral part of this part of ISO 8526. Annex B is for information only.

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Introduction

This part of ISO 8526 has been drawn up to facilitate interchangeability of workholding pallets, including those from different manufacturers. It deals with square pallets and rectangular pallets of length-to-width ratio of 1,25 and of nominal size up to 800 mm.

If pallets with tighter tolerances than specified in this part of ISO 8526 are required, they shall be subject to agreement between the manufacturer and user.

This part of ISO 8526 does not specify the positioning accuracy of the pallets.

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Modular units for machine tools – Workholding pallets – Part 1: Workholding pallets up to 800 mm nominal size

1 Scope

This part of ISO 8526 specifies the dimensions of workholding pallets for use with machine tools and in manufacturing systems.

It applies to the following nominal sizes of pallet:

320 mm, 400 mm, 500 mm, 630 mm and 800 mm

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 8526. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 8526 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 286-2: 1988, *ISO system of limits and fits – Part 2: Tables of standard tolerance grades and limit deviations for holes and shafts.*

ISO 299: 1987, *Machine tool tables – T-slots and corresponding bolts.*

ISO 1101: 1983, *Technical drawings – Geometrical tolerancing – Tolerancing of form, orientation, location and run-out – Generalities, definitions, symbols, indications on drawings.*

ISO 2768-1: 1989, *General tolerances – Part 1: Tolerances for linear and angular dimensions without individual tolerance indications.*

3 Terminology

3.1 Nominal size

The nominal size is given by dimension a_1 (see figure 3).

3.2 General

The terms used for the purposes of this part of ISO 8526 are listed in table 1 and illustrated in figure 1.