

# INTERNATIONAL STANDARD

**ISO  
1708**

Fourth edition  
1989-11-01

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## **Acceptance conditions for general purpose parallel lathes — Testing of the accuracy**

*Conditions de réception des tours parallèles d'usage général — Contrôle de la  
précision*



Reference number  
ISO 1708 : 1989 (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 approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 1708 was prepared by Technical Committee ISO/TC 39, *Machine tools*.

This fourth edition cancels and replaces the third edition (ISO 1708 : 1983), of which it constitutes a minor revision.

Annex A of this International Standard is for information only.

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International Organization for Standardization

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# Acceptance conditions for general purpose parallel lathes — Testing of the accuracy

## 1 Scope

This International Standard specifies, with reference to ISO 230-1, both geometrical and practical tests on general purpose parallel lathes, and gives the corresponding permissible deviations which apply.

It deals only with the verification of the 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.), or to the checking of machine characteristics (speeds, feeds, etc.,) which shall generally be checked before the accuracy is tested.

## 2 Normative reference

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

ISO 230-1 : 1986, *Acceptance code for machine tools — Part 1: Geometric accuracy of machines operating under no-load or finishing conditions*.

## 3 Preliminary remarks

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

**3.2** To apply this International Standard, reference shall be made to ISO 230-1, especially for the installation of the machine before testing, warming up of spindles and other 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.

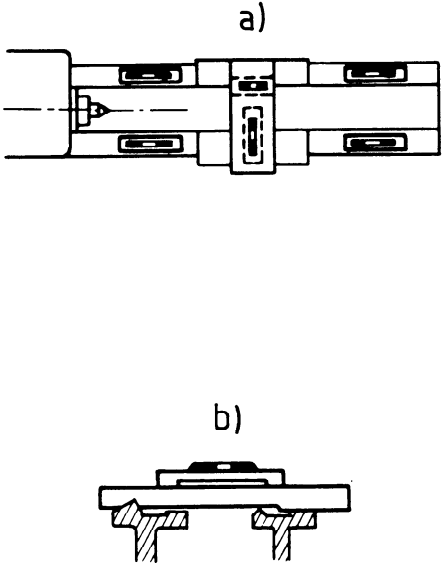
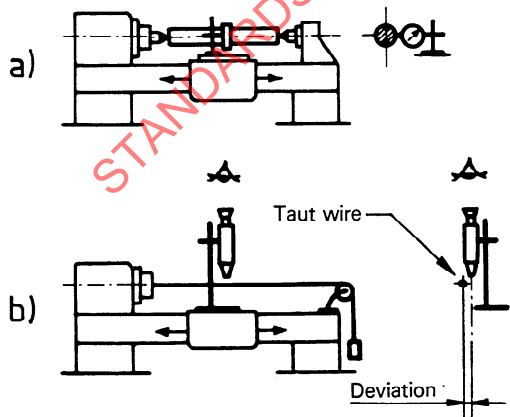
**3.4** When inspecting a machine, it is not always necessary to carry out all the tests given in this International Standard. It is up to the user to choose, in agreement with the manufacturer, those tests relating to the properties which are of interest to him, but the agreed tests shall be clearly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

**3.5** Practical tests shall be made with finishing cuts [for instance, depth = 0,1 mm (0,004 in); feed = 0,1 mm (0,004 in) per revolution] and not with roughing cuts, which are liable to generate appreciable cutting forces.

**3.6** When establishing the tolerance for a measuring range different from that indicated in this International Standard (see ISO 230-1 : 1986, 2.311) it should be taken into consideration that the minimum value of tolerance is 0,005 mm (0,000 2 in) for precision lathes and 0,01 mm (0,000 4 in) for other lathes.

## 4 Acceptance conditions and permissible deviations

### 4.1 Geometrical tests

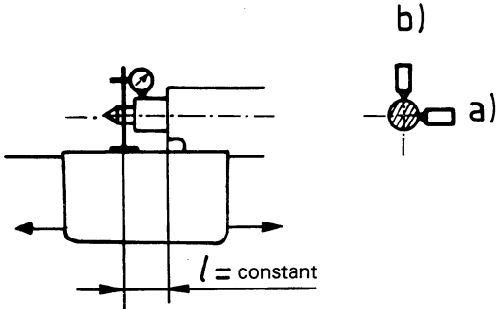
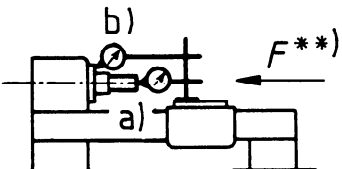
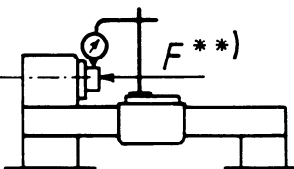
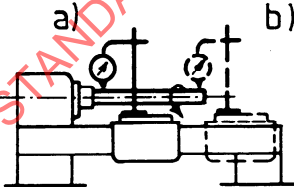
| No. | Diagram                                                                             | Object                                                                                                                                                                     | Precision lathes                                                                                      |                                                                                                     |
|-----|-------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------|
|     |                                                                                     |                                                                                                                                                                            | mm                                                                                                    | in                                                                                                  |
|     |                                                                                     |                                                                                                                                                                            | $D_a < 500$ and $DC < 1500$                                                                           | $D_a < 20$ and $DC < 60$                                                                            |
| G1  |   | <b>A — Bed</b><br>Verification of levelling of slideways.<br>a) Longitudinal verification: straightness of slideways in the vertical plane.                                | $DC < 500$<br>0,01 (convex)                                                                           | $DC < 20$<br>0,000 4 (convex)                                                                       |
|     |                                                                                     |                                                                                                                                                                            | $500 < DC < 1\ 000$<br>0,015 (convex)<br>Local tolerance**): 0,005<br>over any measured length of 250 | $20 < DC < 40$<br>0,000 6 (convex)<br>Local tolerance**): 0,000 2<br>over any measured length of 10 |
|     |                                                                                     |                                                                                                                                                                            | $1\ 000 < DC < 1\ 500$<br>0,02 (convex)                                                               | $40 < DC < 60$<br>0,000 8 (convex)                                                                  |
|     |                                                                                     |                                                                                                                                                                            | Local tolerance**): 0,005<br>over any measured length of 250                                          | Local tolerance**): 0,000 2<br>over any measured length of 10                                       |
| G2  |  | <b>B — Carriage</b><br>Checking of straightness of carriage movement in a horizontal plane or, possibly, in a plane defined by the axis of the centres and the tool point. | $DC < 500$<br>0,01                                                                                    | $DC < 20$<br>0,000 4                                                                                |
|     |                                                                                     |                                                                                                                                                                            | $500 < DC < 1\ 000$<br>0,015                                                                          | $20 < DC < 40$<br>0,000 6                                                                           |
|     |                                                                                     |                                                                                                                                                                            | $1\ 000 < DC < 1\ 500$<br>0,02                                                                        | $40 < DC < 60$<br>0,000 8                                                                           |

\*)  $DC$  = distance between centres.

$D_a$  = maximum permissible diameter above the bed.

\*\*) See clause 5.

| Permissible deviation *)                                                                                                                                                                                                            |                      |                                                                                                                                                                                                                                     |                 | Measuring instruments                                                                                                                                                         | Observations and references to the ISO 230-1 : 1986 acceptance code                                                                                                                                                                                                                                                                                                                                                                                                      |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Other lathes                                                                                                                                                                                                                        |                      |                                                                                                                                                                                                                                     |                 |                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| mm                                                                                                                                                                                                                                  |                      | in                                                                                                                                                                                                                                  |                 |                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| $D_a < 800$                                                                                                                                                                                                                         | $800 < D_a < 1\,600$ | $D_a < 32$                                                                                                                                                                                                                          | $32 < D_a < 64$ |                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| $DC < 500$<br>0,01 (convex)      0,015 (convex)                                                                                                                                                                                     |                      | $DC < 20$<br>0,000 4 (convex)      0,000 6 (convex)                                                                                                                                                                                 |                 | Precision levels, optical or other methods                                                                                                                                    | a) Subclauses 3.11, 3.21, 5.212.21 and 5.212.22<br><br>Take measurements at a number of positions equally spaced along the length of the bed.<br><br>The levels may be placed on the transverse slide.<br><br>When the slideways are not horizontal, use a special straightedge as mentioned in subclause 5.212.21 (2°), figure 12.                                                                                                                                      |
| $500 < DC < 1\,000$<br>0,02 (convex)      0,03 (convex)<br><br>Local tolerance**):<br>0,007 5      0,01<br>over any measured length of 250                                                                                          |                      | $20 < DC < 40$<br>0,000 8 (convex)      0,001 2 (convex)<br><br>Local tolerance**):<br>0,000 3      0,000 4<br>over any measured length of 10                                                                                       |                 |                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| $DC > 1\,000$<br>For each 1 000 increase in distance between centres beyond 1 000, add to the corresponding preceding tolerance:<br>0,01      0,02<br><br>Local tolerance**):<br>0,015      0,02<br>over any measured length of 500 |                      | $DC > 40$<br>For each 40 increase in distance between centres beyond 40, add to the corresponding preceding tolerance:<br>0,000 4      0,000 8<br><br>Local tolerance**):<br>0,000 6      0,000 8<br>over any measured length of 20 |                 |                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| b) Variation in level:<br>0,04/1 000                                                                                                                                                                                                |                      | b) Variation in level:<br>0,001 6/40                                                                                                                                                                                                |                 | Precision levels                                                                                                                                                              | b) Subclause 5.412.7<br><br>Place a level transversely on the slideways and take measurements at a number of positions equally spaced along the length of the slideways.<br><br>The variation in level measured at any position shall not exceed the permissible deviation.                                                                                                                                                                                              |
| $DC < 500$<br>0,015      0,02                                                                                                                                                                                                       |                      | $DC < 20$<br>0,000 6      0,000 8                                                                                                                                                                                                   |                 | a) For $DC < 1\,500$ mm (< 60 in): dial gauge and mandrel between centres or straight-edge<br><br>b) Whatever the value of $DC$ , taut wire and microscope or optical methods | a) Subclause 5.232.3 a) or 5.232.1<br><br>Touch the front generatrix of the mandrel (instead of the mandrel, a straightedge with parallel faces may be used).<br><br>The length of the mandrel between centres shall be as nearly as possible equal to the value of $DC$ .<br><br>b) Subclauses 5.212.3 and 5.232.3 b)<br><br>The deviation in straightness of carriage movement shall, other than in exceptional cases, be concave relative to the axis of the centres. |
| $500 < DC < 1\,000$<br>0,02      0,025                                                                                                                                                                                              |                      | $20 < DC < 40$<br>0,000 8      0,001                                                                                                                                                                                                |                 |                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |
| $DC > 1\,000$<br>For each 1 000 increase in distance between centres beyond 1 000, add to the corresponding preceding tolerance:<br>0,005<br><br>Maximum permissible deviation:<br>0,03      0,05                                   |                      | $DC > 40$<br>For each 40 increase in distance between centres beyond 40, add to the corresponding preceding tolerance:<br>0,000 2<br><br>Maximum permissible deviation:<br>0,001 2      0,002                                       |                 |                                                                                                                                                                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |

| No. | Diagram                                                                             | Object                                                                                                                                                                                                                 | Precision lathes                                                                                                                                                                |                                                                                                                                                                                           |
|-----|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|     |                                                                                     |                                                                                                                                                                                                                        | mm                                                                                                                                                                              | in                                                                                                                                                                                        |
|     |                                                                                     |                                                                                                                                                                                                                        | $D_a \leq 500$ and $DC \leq 1500$                                                                                                                                               | $D_a \leq 20$ and $DC \leq 60$                                                                                                                                                            |
| G3  |    | <p>Checking of parallelism of tailstock movement to carriage movement:</p> <p>a) in the horizontal plane;</p> <p>b) in the vertical plane.</p>                                                                         | <p>a) 0,02</p> <p>Local tolerance:<br/>0,01<br/>over any measured<br/>length of 500</p> <p>b) 0,03</p> <p>Local tolerance:<br/>0,02<br/>over any measured<br/>length of 500</p> | <p>a) 0,000 8</p> <p>Local tolerance:<br/>0,000 4<br/>over any measured<br/>length of 20</p> <p>b) 0,001 2</p> <p>Local tolerance:<br/>0,000 8<br/>over any measured<br/>length of 20</p> |
| G4  |   | <p><b>C — Headstock spindle</b></p> <p>a) Measurement of periodic axial slip.</p> <p>b) Measurement of camming of the face plate resting surface.</p>                                                                  | <p>a) 0,005</p> <p>b) 0,01<br/>including periodic<br/>axial slip</p>                                                                                                            | <p>a) 0,000 2</p> <p>b) 0,000 4<br/>including periodic<br/>axial slip</p>                                                                                                                 |
| G5  |  | Measurement of run-out of spindle nose centring sleeve.                                                                                                                                                                | 0,007                                                                                                                                                                           | 0,000 3                                                                                                                                                                                   |
| G6  |  | <p>Measurement of run-out of axis of centre:</p> <p>a) at the spindle nose of the housing;</p> <p>b) at a distance from the spindle nose equal to <math>D_a/2</math> or not more than 300 mm (12 in)<sup>1)</sup>.</p> | <p>a) 0,005</p> <p>b) 0,015<br/>for a measuring length<br/>of 300</p> <p>0,01<br/>for a measuring length<br/>of 200</p> <p>0,005<br/>for a measuring length<br/>of 100</p>      | <p>a) 0,000 2</p> <p>b) 0,000 6<br/>for a measuring length<br/>of 12</p> <p>0,000 4<br/>for a measuring length<br/>of 8</p> <p>0,000 2<br/>for a measuring length<br/>of 4</p>            |

\*)  $DC$  = distance between centres.

$D_a$  = maximum permissible diameter above the bed.

\*\*)  $F$  = constant pressure on headstock spindle to eliminate axial bearing end play.

| Permissible deviation *)                                                                                                                                                                                     |                                                                                                                                                                                                                |                                                          |                                                                                                                                                                                                                                               | Measuring instruments                                         | Observations and references to the ISO 230-1 : 1986 acceptance code                                                                                                                                                                    |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Other lathes                                                                                                                                                                                                 |                                                                                                                                                                                                                |                                                          |                                                                                                                                                                                                                                               |                                                               |                                                                                                                                                                                                                                        |
| mm                                                                                                                                                                                                           |                                                                                                                                                                                                                | in                                                       |                                                                                                                                                                                                                                               |                                                               |                                                                                                                                                                                                                                        |
| $D_a < 800$                                                                                                                                                                                                  | $800 < D_a < 1\,600$                                                                                                                                                                                           | $D_a < 32$                                               | $32 < D_a < 64$                                                                                                                                                                                                                               |                                                               |                                                                                                                                                                                                                                        |
| $DC < 1\,500$<br>a) and b) 0,03<br><br>Local tolerance:<br>0,02<br>over any measured length of 500<br><br>$DC > 1\,500$<br>a) and b) 0,04<br><br>Local tolerance:<br>0,03<br>over any measured length of 500 | $DC < 60$<br>a) and b) 0,001 2<br><br>Local tolerance:<br>0,000 8<br>over any measured length of 20<br><br>$DC > 60$<br>a) and b) 0,001 6<br><br>Local tolerance:<br>0,001 2<br>over any measured length of 20 | Dial gauge                                               | Subclause 5.422.5<br><br>With the tailstock as close as possible to the carriage take the readings when both are moved together; keep the tailstock sleeve locked so that the dial gauge fixed on the carriage always touches the same point. |                                                               |                                                                                                                                                                                                                                        |
| a) 0,01<br><br>b) 0,02<br>including periodic axial slip                                                                                                                                                      | a) 0,015<br><br>b) 0,02                                                                                                                                                                                        |                                                          |                                                                                                                                                                                                                                               | a) 0,000 4<br><br>b) 0,000 8<br>including periodic axial slip | a) 0,000 6<br><br>b) 0,000 8                                                                                                                                                                                                           |
| 0,01                                                                                                                                                                                                         | 0,015                                                                                                                                                                                                          | 0,000 4                                                  | 0,000 6                                                                                                                                                                                                                                       | Dial gauge                                                    | Subclauses 5.612.2 and 5.621.2<br><br>The value of force $F$ to be applied shall be specified by the manufacturer.<br><br>In the case of a tapered spindle nose, fix the dial gauge perpendicular to the generating line of the taper. |
| a) 0,01<br>b) 0,02<br>for a measuring length of 300                                                                                                                                                          | a) 0,015<br>b) 0,05<br>for a measuring length of 500                                                                                                                                                           | a) 0,000 4<br>b) 0,000 8<br>for a measuring length of 12 | a) 0,000 6<br>b) 0,002<br>for a measuring length of 20                                                                                                                                                                                        | Dial gauge and test mandrel                                   | Subclause 5.612.3<br><br><br><br>1) For lathes such that $D_a > 800$ mm (32 in), the measuring length might be increased up to 500 mm (20 in).                                                                                         |

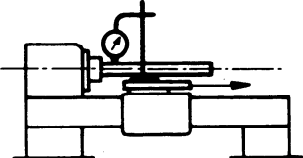
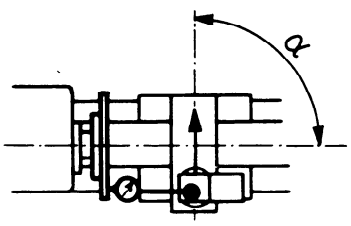
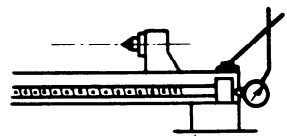
| No. | Diagram | Object                                                                                                                                                                                                                                          | Precision lathes                                                 |                                                                     |
|-----|---------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------|---------------------------------------------------------------------|
|     |         |                                                                                                                                                                                                                                                 | mm                                                               | in                                                                  |
|     |         |                                                                                                                                                                                                                                                 | $D_a < 500$ and $DC < 1500$                                      | $D_a < 20$ and $DC < 60$                                            |
| G7  |         | <p>Checking of parallelism of spindle axis to carriage longitudinal movement on a length equal to <math>D_a/2</math> or a maximum equal to 300 mm (12 in)<sup>1)</sup>:</p> <p>a) in the horizontal plane;</p> <p>b) in the vertical plane.</p> | <p>a) 0,01/300 frontwards</p> <p>b) 0,02/300 upwards</p>         | <p>a) 0,000 4/12 frontwards</p> <p>b) 0,000 8/12 upwards</p>        |
| G8  |         | <p>Measurement of run-out of headstock centre.</p>                                                                                                                                                                                              | 0,01                                                             | 0,000 4                                                             |
| G9  |         | <p><b>D — Tailstock</b></p> <p>Checking of parallelism of the axis of the outside of tailstock sleeve to carriage movement:</p> <p>a) in the horizontal plane;</p> <p>b) in the vertical plane.</p>                                             | <p>a) 0,01/100 frontwards</p> <p>b) 0,015/100 upwards</p>        | <p>a) 0,000 4/4 frontwards</p> <p>b) 0,000 6/4 upwards</p>          |
| G10 |         | <p>Checking of parallelism of taper bore of sleeve to carriage movement on a length equal to <math>D_a/4</math> or a maximum equal to 300 mm (12 in)<sup>1)</sup>:</p> <p>a) in the horizontal plane;</p> <p>b) in the vertical plane.</p>      | <p>a) 0,02/300 frontwards</p> <p>b) 0,02/300 upwards</p>         | <p>a) 0,000 8/12 frontwards</p> <p>b) 0,000 8/12 upwards</p>        |
| G11 |         | <p><b>E — Centres</b></p> <p>Checking of difference in height between headstock centre and tailstock centre.</p>                                                                                                                                | <p>0,02</p> <p>Tailstock centre higher than headstock centre</p> | <p>0,000 8</p> <p>Tailstock centre higher than headstock centre</p> |

\*)  $DC$  = distance between centres.

$D_a$  = maximum permissible diameter above the bed.

\*\*)  $F$  = constant pressure on headstock spindle to eliminate axial bearing end play.

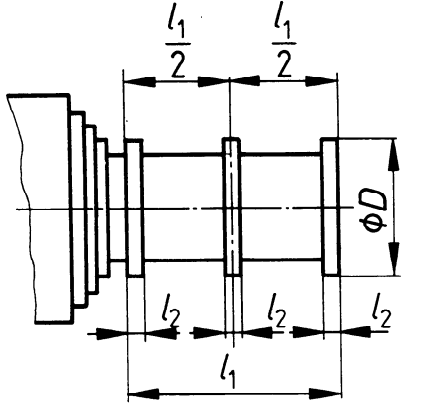
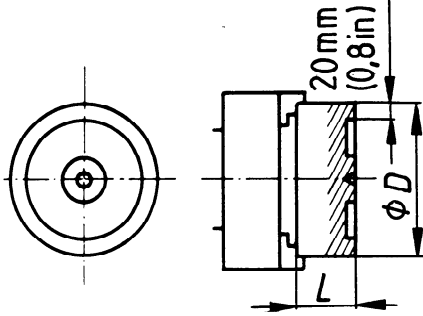
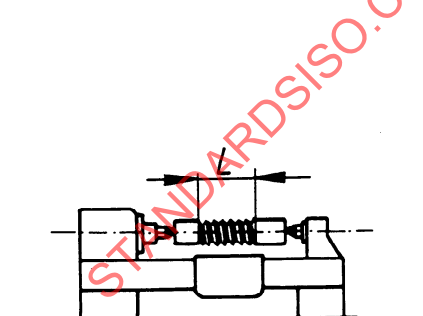
| Permissible deviation *)                              |                                               |                                                          |                                                   | Measuring instruments       | Observations and references to the ISO 230-1 : 1986 acceptance code                                                                                                                                                                                                                                                                                                          |
|-------------------------------------------------------|-----------------------------------------------|----------------------------------------------------------|---------------------------------------------------|-----------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Other lathes                                          |                                               |                                                          |                                                   |                             |                                                                                                                                                                                                                                                                                                                                                                              |
| mm                                                    |                                               | in                                                       |                                                   |                             |                                                                                                                                                                                                                                                                                                                                                                              |
| $D_a < 800$                                           | $800 < D_a < 1\,600$                          | $D_a < 32$                                               | $32 < D_a < 64$                                   |                             |                                                                                                                                                                                                                                                                                                                                                                              |
| a) 0,015/300 frontwards<br>b) 0,02/300 upwards        | a) 0,03/500 frontwards<br>b) 0,04/500 upwards | a) 0,000 6/12 frontwards<br>b) 0,000 8/12 upwards        | a) 0,001 2/20 frontwards<br>b) 0,001 6/20 upwards | Dial gauge and test mandrel | Subclauses 5.412.1 and 5.422.3<br><br>1) For lathes such that $D_a > 800$ mm (32 in), the measuring length might be increased up to 500 mm (20 in).                                                                                                                                                                                                                          |
| 0,015                                                 | 0,02                                          | 0,000 6                                                  | 0,000 8                                           | Dial gauge                  | Subclauses 5.612.2 and 5.621.2<br>The dial gauge being placed perpendicularly to the taper surface of the head centre, and tolerance being given in a plane perpendicular to the spindle axis, divide the readings observed by $\cos \alpha$ , $\alpha$ being the semi cone angle of the taper. The value of force $F$ to be applied shall be specified by the manufacturer. |
| a) 0,015/100 frontwards<br>b) 0,02/100 upwards        | a) 0,02/100 frontwards<br>b) 0,03/100 upwards | a) 0,000 6/4 frontwards<br>b) 0,000 8/4 upwards          | a) 0,000 8/4 frontwards<br>b) 0,001 2/4 upwards   | Dial gauge                  | Subclause 5.422.3<br>After the tailstock sleeve has been sufficiently extended, it shall be locked as under normal working conditions.                                                                                                                                                                                                                                       |
| a) 0,03/300 frontwards<br>b) 0,03/300 upwards         | a) 0,05/500 frontwards<br>b) 0,05/500 upwards | a) 0,001 2/12 frontwards<br>b) 0,001 2/12 upwards        | a) 0,002/20 frontwards<br>b) 0,002/20 upwards     | Dial gauge and test mandrel | Subclause 5.422.3<br>Lock the tailstock sleeve as under normal working conditions.<br><br>1) For lathes such that $D_a > 800$ mm (32 in), the measuring length might be increased up to 500 mm (20 in).                                                                                                                                                                      |
| 0,04<br>Tailstock centre higher than headstock centre | 0,06                                          | 0,001 6<br>Tailstock centre higher than headstock centre | 0,002 4                                           | Dial gauge and test mandrel | Subclause 5.422.3<br>Touch the top generatrix of the mandrel. Take readings at the extremities of the test mandrel with the tailstock and tailstock sleeve locked, as under normal working conditions.                                                                                                                                                                       |

| No. | Diagram                                                                             | Object                                                                                                                 | Precision lathes                                                                            |                                                                                                   |
|-----|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------|
|     |                                                                                     |                                                                                                                        | mm                                                                                          | in                                                                                                |
|     |                                                                                     |                                                                                                                        | $D_a < 500$ and $DC < 1500$                                                                 | $D_a < 20$ and $DC < 60$                                                                          |
|     |                                                                                     |                                                                                                                        |                                                                                             |                                                                                                   |
| G12 |    | <b>F — Upper slide</b><br>Checking of parallelism of the longitudinal movement of the upper slide to the spindle axis. | 0,015/150                                                                                   | 0,000 6/6                                                                                         |
| G13 |    | <b>G — Cross slide</b><br>Measurement of squareness of the transverse movement of the cross slide to the spindle axis. | 0,01/300<br>Direction of deviation:<br>$\alpha > 90^\circ$                                  | 0,000 4/12<br>Direction of deviation:<br>$\alpha > 90^\circ$                                      |
| G14 |   | <b>H — Lead screw</b><br>Measurement of periodic axial slip due to camming of each thrust bearing.                     | 0,01                                                                                        | 0,000 4                                                                                           |
| G15 |  | Checking of the cumulative pitch error generated by the lead screw.                                                    | a) 0,03<br>over any measured length of 300<br><br>b) 0,01<br>over any measured length of 60 | a) 0,001 2<br>over any measured length of 12<br><br>b) 0,000 4<br>over any measured length of 2,4 |

\*)  $DC$  = distance between centres.  
 $D_a$  = maximum permissible diameter above the bed.

| Permissible deviation *)                                                                                                                                                                                                                                                                             |                                                            |                                                                                                                                                                                                                                                                                                |                                                              | Measuring instruments                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | Observations and references to the ISO 230-1 : 1986 acceptance code                                                                                                                                         |                                                                                                      |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------|
| Other lathes                                                                                                                                                                                                                                                                                         |                                                            |                                                                                                                                                                                                                                                                                                |                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                                                                                             |                                                                                                      |
| mm                                                                                                                                                                                                                                                                                                   |                                                            | in                                                                                                                                                                                                                                                                                             |                                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                                                                                             |                                                                                                      |
| $D_a < 800$                                                                                                                                                                                                                                                                                          | $800 < D_a < 1\,600$                                       | $D_a < 32$                                                                                                                                                                                                                                                                                     | $32 < D_a < 64$                                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                                                                                                                                                             |                                                                                                      |
|                                                                                                                                                                                                                                                                                                      | 0,04/300                                                   |                                                                                                                                                                                                                                                                                                | 0,001 6/12                                                   | Dial gauge and test mandrel                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Subclause 5.422.3<br>Make the measurement in the vertical plane (after setting up the upper slide parallel with the spindle axis in the horizontal plane), only in the working position of the upper slide. |                                                                                                      |
|                                                                                                                                                                                                                                                                                                      | 0,02/300<br>Direction of deviation:<br>$\alpha > 90^\circ$ |                                                                                                                                                                                                                                                                                                | 0,000 8/12<br>Direction of deviation:<br>$\alpha > 90^\circ$ | Dial gauge and flat disk or straightedge                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Subclauses 5.522.3 and 3.22                                                                                                                                                                                 |                                                                                                      |
|                                                                                                                                                                                                                                                                                                      | 0,015                                                      | 0,02                                                                                                                                                                                                                                                                                           | 0,000 6                                                      | 0,000 8                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | Dial gauge                                                                                                                                                                                                  | Subclauses 5.622.1 and 5.622.2<br>This operation may be deleted if practical test P3 is carried out. |
| a) $DC < 2\,000$<br>0,04<br>over any measured length of 300<br><br>$DC > 2\,000$<br>For each 1 000 increase in distance between centres beyond 2 000, add to the corresponding preceding tolerance:<br>0,005<br>Maximum permissible deviation:<br>0,05<br>b) 0,015<br>over any measured length of 60 |                                                            | a) $DC < 80$<br>0,001 6<br>over any measured length of 12<br><br>$DC > 80$<br>For each 40 increase in distance between centres beyond 80, add to the corresponding preceding tolerance:<br>0,000 2<br>Maximum permissible deviation:<br>0,002<br>b) 0,000 6<br>over any measured length of 2,4 |                                                              | Subclauses 6.1 and 6.2<br><br><i>Precision lathes.</i> A record of the pitch accuracy will be made by means of an electric pick-up, for instance, feeling the flanks of the threads of a master lead screw of 300 mm (12 in) length held between centres.<br><br><i>Other lathes.</i> Length bars will be used associated with a dial gauge so as to compare the carriage travel to the number of corresponding revolutions of the spindle.<br><br>However, for both classes of lathes, a record of the lead screw accuracy (over a specified length and checked along four generators shifted 90° forward) should be satisfactory.<br><br>NOTE — By agreement between manufacturer and user on the measuring method and the values of the permissible deviation, total error may be checked over 300 mm. |                                                                                                                                                                                                             |                                                                                                      |

## 4.2 Practical tests

| No. | Diagram                                                                             | Nature of test                                                                                                                                                                                                                                                               | Cutting conditions                                                                                                                                                  | Checks to be applied                                                                                                                                                                                                                                                                                                                                                                                   |
|-----|-------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| P1  |    | <p>Machining of cylindrical test-pieces**) held in a chuck (the cylindrical test-piece may be inserted in the taper bore of the spindle)</p> $D > \frac{D_a}{8}$ $l_1 = 0,5 D_a$ <p><math>l_1</math> max. = 500 mm (20 in)</p> <p><math>l_2</math> max. = 20 mm (0,8 in)</p> | <p>Machining of three diameters [two, if <math>l_1 &lt; 50</math> mm (2 in)] on a cylinder with a single-point tool.</p>                                            | <p>a) <b>Circularity</b></p> <p>Variation in diameter at the location end of the test-piece for at least four readings (see ISO 1101 : 1983, 14.3).</p> <p>b) <b>Consistency of machined diameters</b></p> <p>Variation between machined diameters at either end of the test-piece measured in a single axial plane.</p> <p>Any taper shall be such that the major diameter is near the headstock.</p> |
| P2  |   | <p>Machining of cylindrical test-pieces**) held in a chuck</p> $D > 0,5 D_a$ $L_{\text{max.}} = \frac{D_a}{8}$                                                                                                                                                               | <p>Facing of flat surfaces perpendicular to the spindle (facing only two or three surfaces, one of which is central).</p>                                           | <p>Surface flatness.</p> <p>Deviation of flatness should only be allowed in a concave direction.</p>                                                                                                                                                                                                                                                                                                   |
| P3  |  | <p>Threading of a cylindrical test-piece**)</p> $L = 300 \text{ mm (2 in)}$ <p>ISO triangular thread (ISO 68)</p>                                                                                                                                                            | <p>The start of the screw thread is taken from any point on the lead screw.</p> <p>Diameter and pitch shall be as close as possible to those of the lead screw.</p> | <p>Cumulative error over 300 mm.</p>                                                                                                                                                                                                                                                                                                                                                                   |

\*)  $DC$  = distance between centres.

$D_a$  = maximum permissible diameter above the bed.

\*\*) Test-pieces shall be made of free cutting steel or cast iron.