

---

---

**Machine tools — Test conditions for  
testing the accuracy of boring and milling  
machines with horizontal spindle —**

**Part 1:  
Machines with fixed column and movable  
table**

*Machines-outils — Conditions d'essai pour le contrôle de l'exactitude  
des machines à aléser et à fraiser à broche horizontale —*

*Partie 1: Machines à montant fixe et à table mobile*



**PDF disclaimer**

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

STANDARDSISO.COM : Click to view the full PDF of ISO 3070-1:2007



**COPYRIGHT PROTECTED DOCUMENT**

© ISO 2007

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office  
Case postale 56 • CH-1211 Geneva 20  
Tel. + 41 22 749 01 11  
Fax + 41 22 749 09 47  
E-mail [copyright@iso.org](mailto:copyright@iso.org)  
Web [www.iso.org](http://www.iso.org)

Published in Switzerland

# Contents

Page

|                                                                                |    |
|--------------------------------------------------------------------------------|----|
| Foreword.....                                                                  | iv |
| Introduction .....                                                             | v  |
| 1 Scope .....                                                                  | 1  |
| 2 Normative references .....                                                   | 1  |
| 3 Terminology and designation of axes .....                                    | 2  |
| 4 Definition of the machining operations carried out on these machines.....    | 3  |
| 4.1 Boring operations.....                                                     | 3  |
| 4.2 Milling operations .....                                                   | 4  |
| 5 Special remarks concerning particular elements.....                          | 4  |
| 5.1 Spindle heads.....                                                         | 4  |
| 5.2 Tables.....                                                                | 5  |
| 5.3 Steady blocks.....                                                         | 5  |
| 6 Preliminary remarks .....                                                    | 5  |
| 6.1 Measuring units .....                                                      | 5  |
| 6.2 Reference to ISO 230-1.....                                                | 5  |
| 6.3 Testing sequence.....                                                      | 5  |
| 6.4 Tests to be performed .....                                                | 5  |
| 6.5 Measuring instruments .....                                                | 6  |
| 6.6 Machining tests.....                                                       | 6  |
| 6.7 Software compensation .....                                                | 6  |
| 6.8 Minimum tolerance .....                                                    | 6  |
| 7 Geometric tests.....                                                         | 7  |
| 7.1 Straightness and angular deviations of coordinate axes.....                | 7  |
| 7.2 Squareness between coordinate axes.....                                    | 13 |
| 7.3 Table.....                                                                 | 15 |
| 7.4 Indexing or rotary table.....                                              | 18 |
| 7.5 Boring spindle.....                                                        | 21 |
| 7.6 Milling spindle.....                                                       | 27 |
| 7.7 Ram .....                                                                  | 28 |
| 7.8 Integral facing head.....                                                  | 31 |
| 7.9 Steady block.....                                                          | 35 |
| 8 Machining tests.....                                                         | 36 |
| 9 Checking accuracy and repeatability of positioning by numerical control..... | 43 |
| 10 Geometric accuracy of axes of rotation of tool-holding spindles .....       | 49 |
| Bibliography .....                                                             | 51 |

## 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 3070-1 was prepared by Technical Committee ISO/TC 39, *Machine tools*, Subcommittee SC 2, *Test conditions for metal cutting machine tools*.

This third edition cancels and replaces ISO 3070-0:1982 and ISO 3070-2:1997, of which it constitutes a technical revision.

ISO 3070 consists of the following parts, under the general title *Machine tools — Test conditions for testing the accuracy of boring and milling machines with horizontal spindle*:

- *Part 1: Machines with fixed column and movable table*
- *Part 2: Machines with movable column and fixed table*
- *Part 3: Machines with movable column and movable table*

## Introduction

It is generally accepted that horizontal spindle boring and milling machines fall into three categories characterized by their particular configuration:

- a) machines with fixed column and movable table;
- b) machines with movable column and fixed table;
- c) machines with movable column and movable table.

In the past, all these types of machines and associated terminology were described in ISO 3070-0:1982. The relevant accuracy tests were described in ISO 3070-2:1997, ISO 3070-3:1997, and ISO 3070-4:1998 respectively. However, ISO/TC 39/SC 2 decided to integrate the descriptions and the terminology of these machines into appropriate parts of ISO 3070 describing the accuracy tests and to renumber the parts of this series accordingly.

STANDARDSISO.COM : Click to view the full PDF of ISO 3070-1:2007

STANDARDSISO.COM : Click to view the full PDF of ISO 3070-1:2007

# Machine tools — Test conditions for testing the accuracy of boring and milling machines with horizontal spindle —

## Part 1: Machines with fixed column and movable table

### 1 Scope

This part of ISO 3070 specifies, with reference to ISO 230-1, ISO 230-2 and ISO 230-7, geometric tests, machining tests, spindle tests and tests for checking the accuracy and repeatability of positioning by numerical control of general purpose, normal accuracy, horizontal spindle boring and milling machines having a fixed column and movable table. This part of ISO 3070 also specifies the applicable tolerances corresponding to these tests.

This type of machine can be provided with spindle heads of different types, such as those with sliding boring spindle and milling spindle, sliding boring spindle and facing head, or ram or milling ram.

This part of ISO 3070 concerns machines having both longitudinal (Z-axis) and transverse (X-axis) movement of the table, a vertical movement of the spindle head (Y axis), movement of the boring spindle or ram (W axis) and, possibly, a feed movement of radial facing slide in the facing head (U axis), and that may include a rotary or indexing table.

NOTE In other parts of ISO 3070 spindle ram movement is designated as the Z axis.

This part of ISO 3070 deals only with the verification of the accuracy of the machine. It does not apply to the operational testing of the machine (e.g. vibration, abnormal noise, stick-slip motion of components) nor to machine characteristics (e.g. speeds, feeds), as such checks are generally carried out before testing the accuracy.

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

ISO 230-2:2006, *Test code for machine tools — Part 2: Determination of accuracy and repeatability of positioning numerically controlled axes*

ISO 230-7:2006, *Test code for machine tools — Part 7: Geometric accuracy of axes of rotation*

ISO 1101:2004, *Geometrical Product Specifications (GPS) — Geometrical tolerancing — Tolerances of form, orientation, location and run-out*

### 3 Terminology and designation of axes

#### 3.1 General

A boring and milling machine is a machine tool in which the principal cutting motion is the rotation of the cutting tool against the non-rotating workpiece and where the cutting energy is brought by the cutting tool rotation.

The cutting movement is generated by the rotation of the spindle(s) and, possibly, of the facing head.

#### 3.2 Types of movement

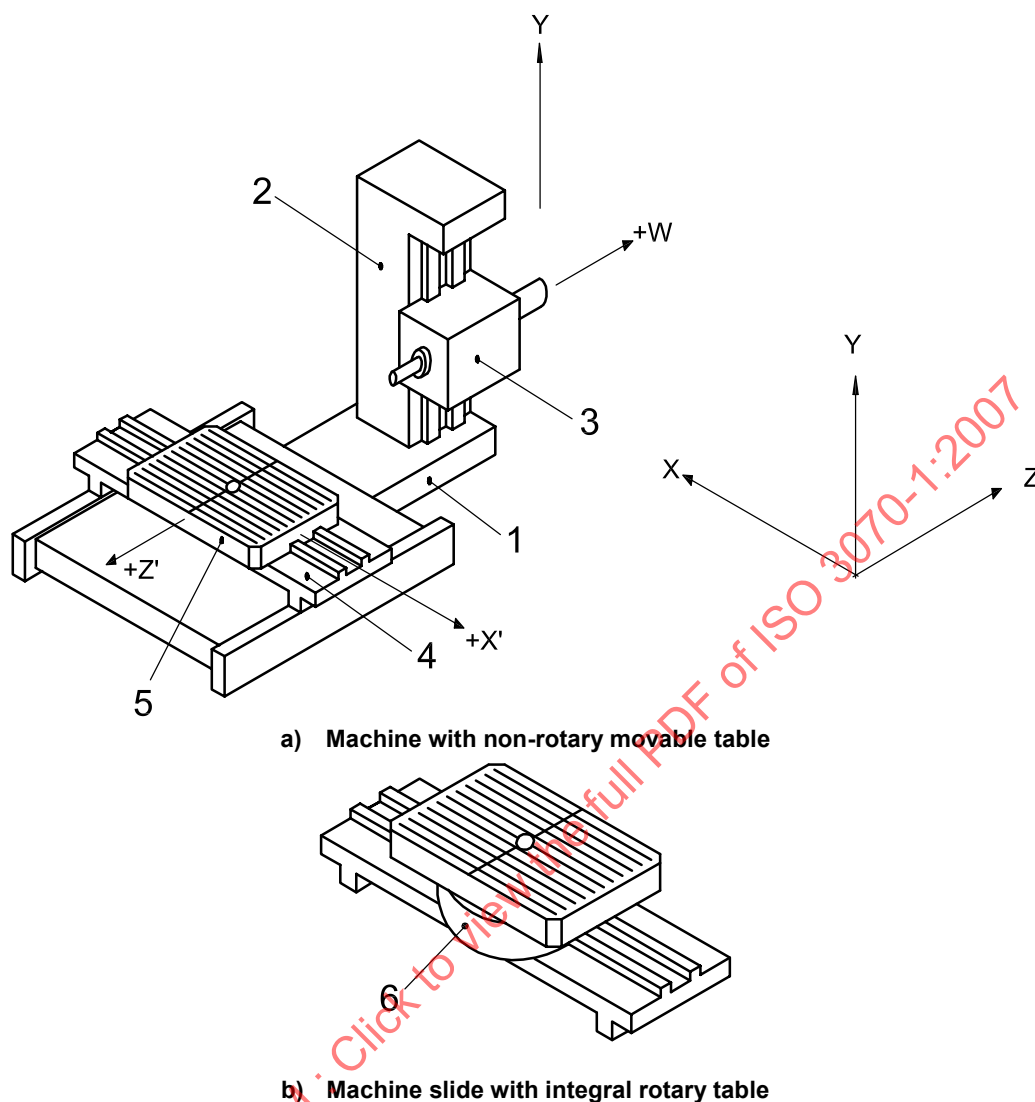
The feed movements are as follows:

- a) longitudinal, transverse and possibly rotary movements of the table;
- b) vertical movement of the spindle head;
- c) axial movement of the spindle;
- d) possible movement of radial facing slide in the facing head.

Table 1 provides the nomenclature for various structural components of machines shown in Figure 1. Figure 1 shows two possible configurations of boring and milling machines with fixed column and movable table: one with a non-rotary movable table and the other with an integral rotary table.

**Table 1 — Nomenclature** (see Figure 1)

| Figure 1<br>ref. | English      | French                          | German           |
|------------------|--------------|---------------------------------|------------------|
| 1                | bed          | banc                            | Maschinenbett    |
| 2                | column       | montant du chariot porte-broche | Maschinenständer |
| 3                | spindle head | chariot porte-broche            | Spindelstock     |
| 4                | table saddle | traînard                        | Bettschlitten    |
| 5                | table        | table                           | Aufspanntisch    |
| 6                | rotary table | table pivotante                 | Drehtisch        |



NOTE 1 ISO 841 nomenclature was not used here in respect of the W axis in order to ensure consistency in this part of ISO 3070 for machines with and without W axis.

NOTE 2 For components 1 to 6, see Table 1.

**Figure 1 — Machines with movable table with and without integral rotary table**

## 4 Definition of the machining operations carried out on these machines

### 4.1 Boring operations

Boring is a machining operation for generating holes of various sizes and geometries in which the principal cutting motion is the rotation of a single-point cutting tool against the non-rotating workpiece and where the cutting energy is brought by the cutting tool rotation.

Boring the diameter of cylindrical, conical, blind or through holes to the required size is achieved by using a boring bar to locate the cutting edge of the boring tool in a well-defined position with respect to the axis average line of the boring spindle.

In the case of coaxial bores situated on opposite faces of the same workpiece, the operation may be carried out using a boring bar, supported between the machine boring spindle and the steady stock located on the other side of the table. Alternatively, if the machine has a rotary table, such an operation can be carried out by rotating the table 180° to bore the opposite side of the workpiece with the same boring tool located on the

boring bar that is mounted on the boring spindle without any steady support (reverse boring). Although more economical, this alternative method requires closer tolerances for table angular positioning as well as for the axis of rotation errors.

## 4.2 Milling operations

Milling is a machining operation to generate non-axisymmetrical (non-rotational) surfaces of various geometries in which the principal cutting motion is the rotation of a cutting tool with multiple cutting edges against the non-rotating workpiece, and where the cutting energy is brought by the cutting tool rotation.

Milling operations mostly involve face milling or end milling. The tools are mounted either in the boring spindle taper (see Figure 2) or, as for face milling cutters, on the milling spindle nose.

## 5 Special remarks concerning particular elements

### 5.1 Spindle heads

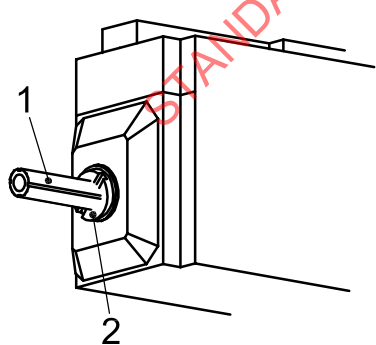
Reference should be made to Figure 2 for examples of the various types of head. Related nomenclature is given in Table 2.

Facing heads generally have a radial facing slide and are either integral or removable; the latter is considered an accessory.

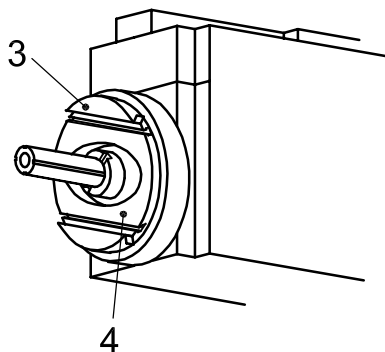
It should be noted that the integral facing head may not always be mounted onto the milling spindle and may have its own bearing independent from the main spindle bearings.

**Table 2 — Nomenclature** (see Figure 2)

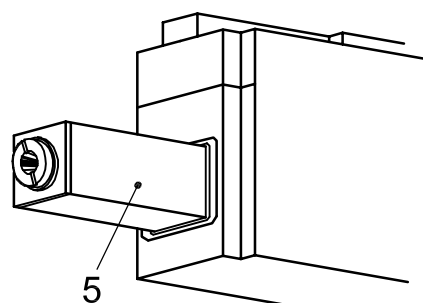
| Figure 2 ref. | English                       | French                                 | German                       |
|---------------|-------------------------------|----------------------------------------|------------------------------|
| 1             | boring spindle                | broche à aléser                        | Bohrerspindel                |
| 2             | milling spindle               | broche à fraiser                       | Frässpindel                  |
| 3             | facing head                   | plateau à surfacer                     | Planscheibe                  |
| 4             | spindle head with facing head | tête de broche avec plateau à surfacer | Spindelstock mit Planscheibe |
| 5             | ram                           | coulisseau                             | Traghülse                    |



a) Spindle head for boring and milling



b) Spindle head with facing head



c) Spindle head with ram

NOTE For elements 1 to 5, see Table 2.

**Figure 2 — Types of spindle head**

## 5.2 Tables

Tables may have various rectilinear and rotary movements for positioning and feed.

The two main rectilinear movements, the directions of which are perpendicular to each other, are used either for positioning the table or giving specified work feeds.

The rotary movement of the table may be used

- a) for angular positioning in the plane of the table rotation,
- b) as a circular work feed for milling operations,
- c) for circular cutting movements for turning operations.

## 5.3 Steady blocks

Due to the decreasing use of long boring bars, there is an increasing tendency to treat steady blocks as optional parts or auxiliary equipment.

# 6 Preliminary remarks

## 6.1 Measuring units

In this part of ISO 3070, all linear dimensions, deviations and corresponding tolerances are expressed in millimetres; angular dimensions are expressed in degrees, and angular deviations and the corresponding tolerances are expressed in ratios (e.g. 0,00x/1 000) as the primary method; but in some cases microradians or arcseconds may be used for clarification purposes. The equivalence of the following expressions should always be kept in mind:

$$0,010/1\ 000 = 10 \times 10^{-6} = 10\ \mu\text{rad} \approx 2\ \text{arcsec}$$

## 6.2 Reference to ISO 230

In applying this part of ISO 3070, reference shall be made to ISO 230-1, especially for the installation of the machine before testing, warming up of the spindle and other moving components, description of the measuring methods and recommended accuracy of the test equipment.

In the "Observations" block of the tests described in the following sections, the instructions are to be followed by reference to the corresponding clause or subclause of ISO 230-1, ISO 230-2 or ISO 230-7, in cases where the test concerned is in compliance with the specifications of one or another of those parts of ISO 230.

## 6.3 Testing sequence

The sequence in which the tests are presented in this part of ISO 3070 in no way defines the practical order of testing. In order to make the mounting of instruments or gauging easier, tests may be performed in any order.

## 6.4 Tests to be performed

When testing a machine, it is not always necessary or possible to carry out all the tests described in this part of ISO 3070. When the tests are required for acceptance purposes, it is for the user to choose, in agreement with the supplier/manufacturer, those tests relating to the components and/or the properties of the machine which are of interest. These tests are to be clearly stated when ordering a machine. The mere reference to this part of ISO 3070 for the acceptance tests, without specifying the tests carried out or without agreement on the relevant expenses, cannot be considered binding for any contracting party.

## 6.5 Measuring instruments

The measuring instruments indicated in the tests described in the following sections are examples only.

Other instruments capable of measuring the same quantities and having the same, or a smaller, measuring uncertainty may be used. Linear displacement sensors shall have a resolution of 0,001 mm or better.

## 6.6 Machining tests

Machining tests shall be made with finishing cuts only, not with roughing cuts, which are liable to generate appreciable cutting forces.

## 6.7 Software compensation

When built-in software facilities are available for compensating geometric, positioning, contouring and thermal deviations, their use during these tests should be based on agreement between the user and the supplier/manufacturer. When the software compensation is used, this shall be stated in the test report.

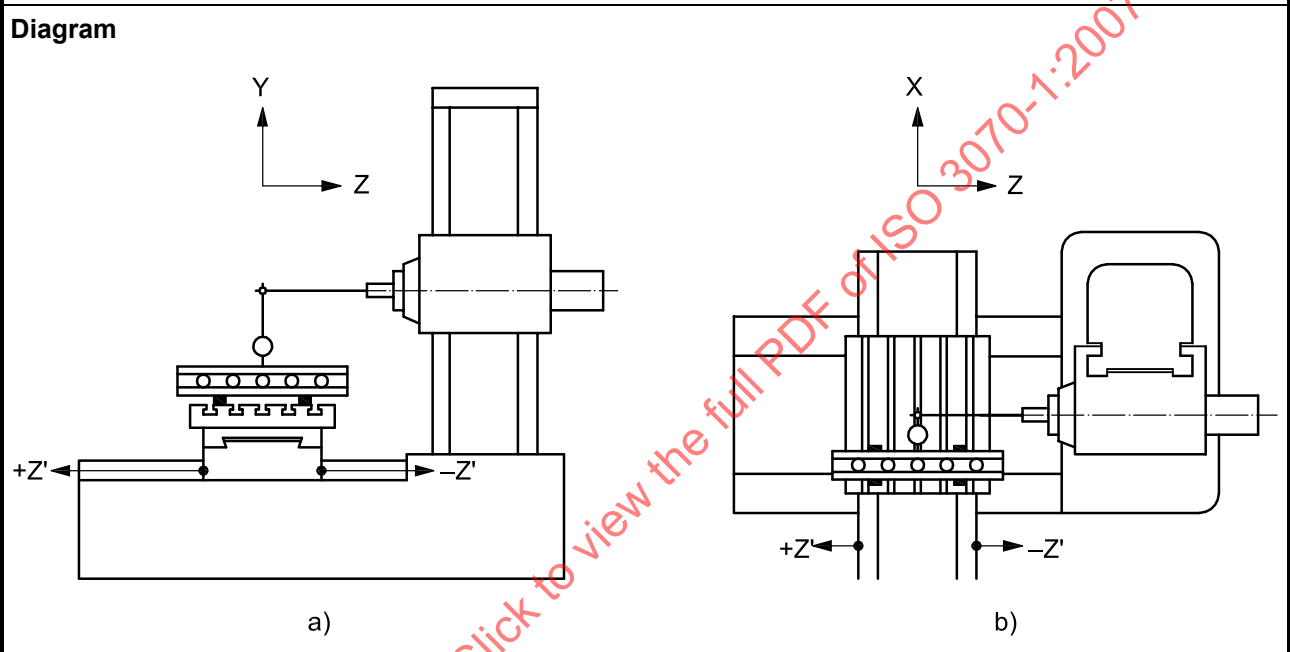
## 6.8 Minimum tolerance

When the tolerance for a geometric test is established for a measuring length different from that given in this part of ISO 3070 (see ISO 230-1:1996, 2.311), it shall be taken into consideration that the minimum value of tolerance is 0,005 mm.

STANDARDSISO.COM : Click to view the full PDF of ISO 3070-1:2007

## 7 Geometric tests

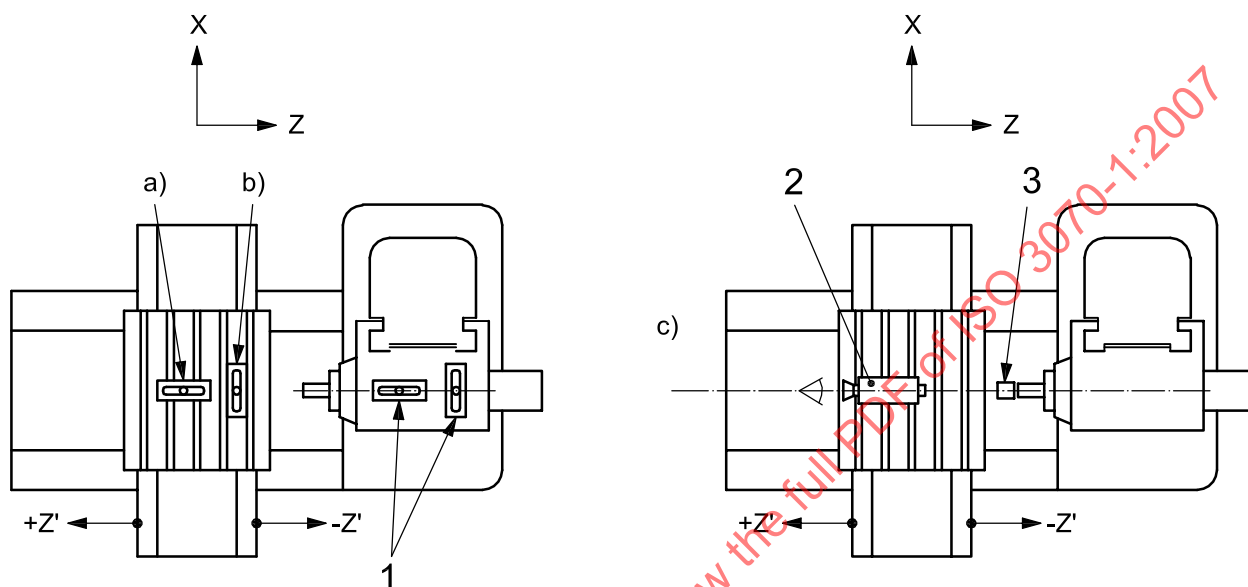
### 7.1 Straightness and angular deviations of linear axes

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                           |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------|
| <b>Object</b><br><br>Checking of the straightness of the table saddle movement (Z axis):<br>a) in the YZ plane (vertical plane) (EYZ);<br>b) in the ZX plane (horizontal plane) (EXZ).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | <b>G1</b>                                 |
| <b>Diagram</b><br><br>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                           |
| <b>Tolerance</b><br><br>a) and b)<br><br>0,02 for measuring lengths up to 1 000<br>0,03 for measuring lengths above 1 000<br><br>Local tolerance: 0,006 for any measuring length of 300                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | <b>Measured deviation</b><br><br>a)<br>b) |
| <b>Measuring instruments</b><br><br>Straightedge, linear displacement sensor/support and gauge blocks or optical methods                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                           |
| <b>Observations and references to ISO 230-1:1996</b> <span style="float: right;"><b>5.232.11 and 5.232.13</b></span><br><br>Lock the table in the mid-travel position in the X-axis direction and lock the spindle head in mid-travel.<br>Set a straightedge on the table, parallel to the table saddle movement (Z axis) for a) vertically and b) horizontally ( <i>parallel</i> means that the reading of the linear displacement sensor touching the straightedge at both ends of the movement is the same value).<br>If the spindle can be locked, mount the linear displacement sensor on it. If the spindle cannot be locked, mount the linear displacement sensor on the spindle head.<br>The stylus shall be normal to the reference face of the straightedge.<br>Traverse the table saddle in the Z-axis direction and note the readings. |                                           |

**Object****G2**

Checking of the angular deviation of the table saddle movement (Z axis):

- a) in the YZ plane (EAZ: pitch);
- b) in the XY plane (ECZ: roll);
- c) in the ZX plane (EBZ: yaw).

**Diagram****Key**

- 1 reference level
- 2 autocollimator
- 3 mirror

**Tolerance**

a), b) and c)

0,04/1 000

Local tolerance: 0,02/1 000 for any measuring length of 300

**Measured deviation**

a)

b)

c)

**Measuring instruments**

- a) Precision level, laser interferometer or other optical angular deviation measuring instruments
- b) Precision level
- c) Laser interferometer or other optical angular deviation measuring instruments

**Observations and references to ISO 230-1:1996****5.231.3 and 5.232.2**

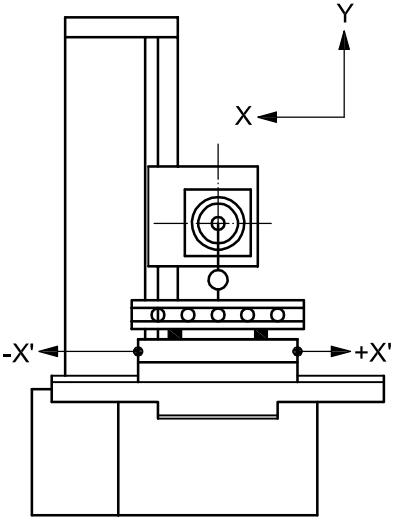
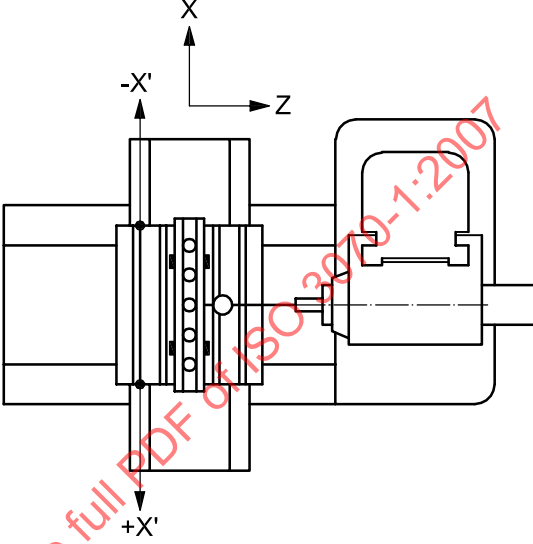
The level or instrument shall be placed on the table:

- a) (EAZ: pitch) in the Z-axis direction (set vertically for an autocollimator);
- b) (ECZ: roll) in the X-axis direction
- c) (EBZ: yaw) in the Z-axis direction (set horizontally for an autocollimator).

The reference level shall be located on the spindle head, and the spindle head shall be in mid-travel.

When Z-axis motion causes an angular movement of both spindle head and table, differential measurements of the two angular movements shall be made and this shall be stated.

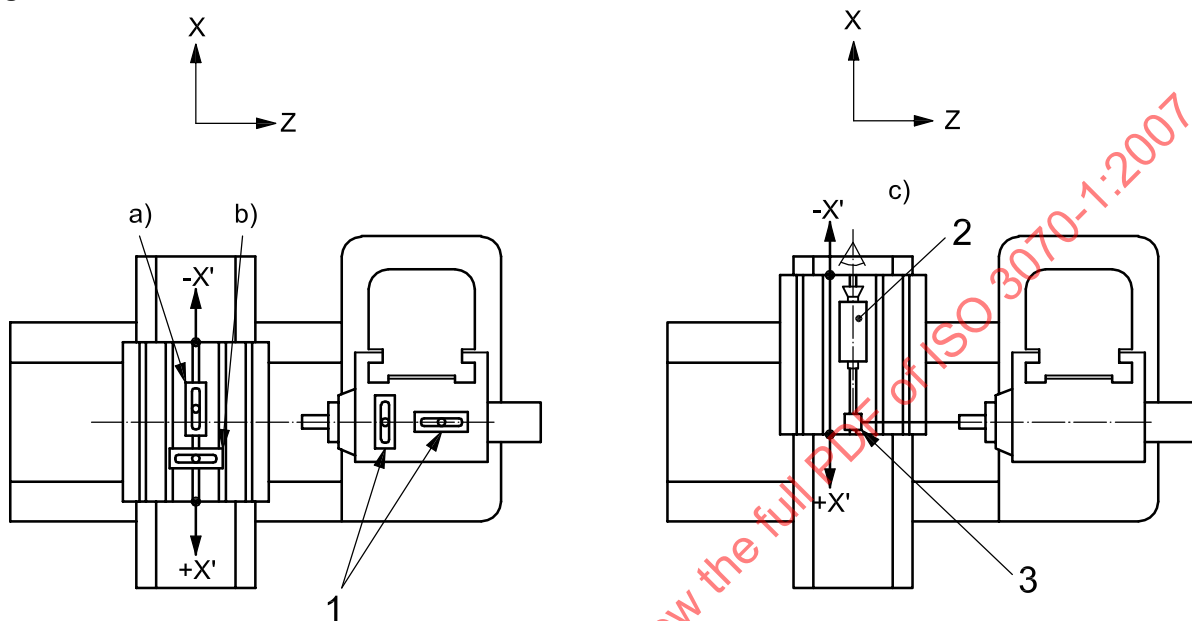
Measurements shall be carried out at a minimum of five positions equally spaced along the travel in both directions of the movement.

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                                |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | <b>G3</b>                                      |
| <p>Checking of the straightness of the table movement (X axis):</p> <p>a) in the XY plane (vertical plane) (EYX);</p> <p>b) in the ZX plane (horizontal plane) (EZX).</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                                |
| <b>Diagram</b> <div style="display: flex; justify-content: space-around; align-items: center;">   </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <span>a)</span> <span>b)</span> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                |
| <b>Tolerance</b> <p style="text-align: center;">a) and b)</p> <p style="text-align: center;">0,02 for measuring lengths up to 1 000</p> <p style="text-align: center;">Add 0,01 to the preceding tolerance for each 1 000 increase in length beyond 1 000</p> <p style="text-align: center;">Maximum tolerance: 0,05</p> <p style="text-align: center;">Local tolerance: 0,006 for any measuring length of 300</p>                                                                                                                                                                                                                                                                                                                                                                                                                                            | <b>Measured deviations</b> <p>a)</p> <p>b)</p> |
| <b>Measuring instruments</b> <p>Straightedge, linear displacement sensor/support and gauge blocks or optical methods</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                                |
| <b>Observations and references to ISO 230-1:1996</b> <p style="text-align: right;"><b>5.232.11 and 5.232.13</b></p> <p>Lock the saddle in mid-travel in the Z-axis direction and lock the spindle head in mid-travel.</p> <p>Set a straightedge at the middle position of the table, parallel to the table movement (X axis) for a) vertically and b) horizontally (<i>parallel</i> means that the reading of the linear displacement sensor touching the straightedge at both ends of the movement is the same value).</p> <p>If the spindle can be locked, mount the linear displacement sensor on it. If the spindle cannot be locked, mount the linear displacement sensor on the spindle head.</p> <p>The stylus shall be normal to the reference face of the straightedge.</p> <p>Traverse the table in the X-axis direction and note the readings.</p> |                                                |

**Object****G4**

Checking of the angular deviation of the table movement (X axis):

- a) in the XY plane (ECX: pitch);
- b) in the YZ plane (EAX: roll);
- c) in the ZX plane (EBX: yaw).

**Diagram****Key**

- 1 reference level
- 2 autocollimator
- 3 mirror

**Tolerance**

a), b) and c)  
0,04/1 000

Local tolerance: 0,02/1 000 for any measuring length of 300

**Measured deviations**

- a)
- b)
- c)

**Measuring instruments**

- a) Precision level, laser interferometer or other optical angular deviation measuring instruments
- b) Precision level
- c) Laser interferometer or other optical angular deviation measuring instruments

**Observations and references to ISO 230-1:1996****5.231.3 and 5.232.2**

The level or instrument shall be placed on the table:

- a) (ECX: pitch) in the X-axis direction (set vertically for an autocollimator);
- b) (EAX: roll) in the Z-axis direction
- c) (EBX: yaw) in the X-axis direction (set horizontally for an autocollimator).

The reference level shall be located on the spindle head, which shall be in mid-travel.

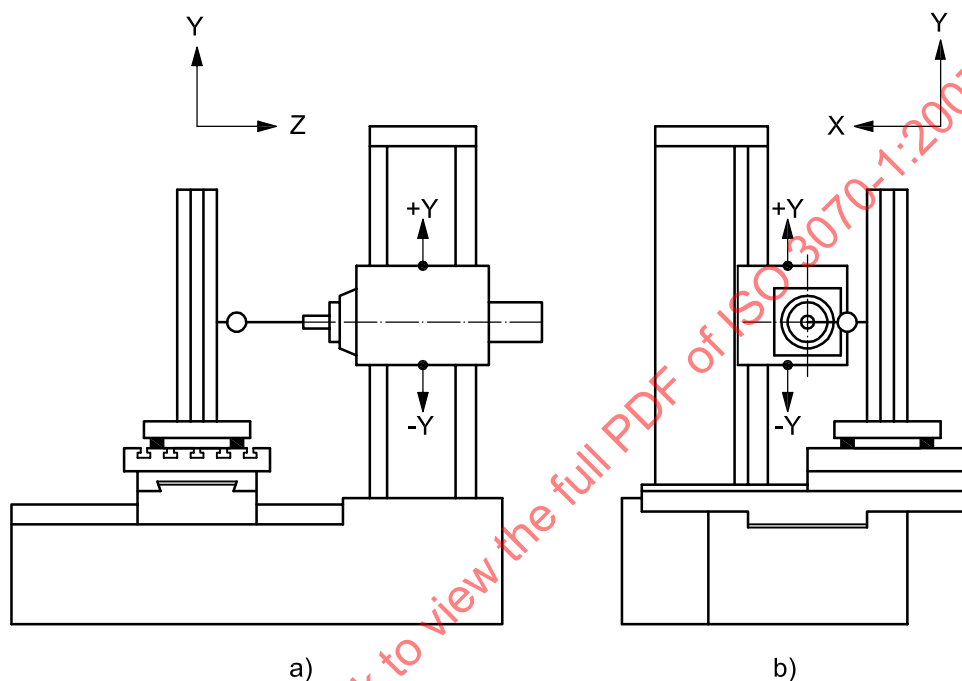
When X-axis motion causes an angular movement of both spindle head and work-holding table, differential measurements of the two angular movements shall be made and this shall be stated.

Measurements shall be carried out at a minimum of five positions equally spaced along the travel in both directions of the movement.

**Object****G5**

Checking of the straightness of the spindle head movement (Y axis):

- a) in the YZ plane (vertical plane parallel to spindle axis) (EZY);
- b) in the XY plane (vertical plane square to the spindle axis) (EXY).

**Diagram****Tolerance**

a) and b)

0,02 for any measuring length of 1 000

**Measured deviations**

a)

b)

**Measuring instruments**

Cylindrical square, surface plate, adjustable blocks and linear displacement sensor/support or optical methods

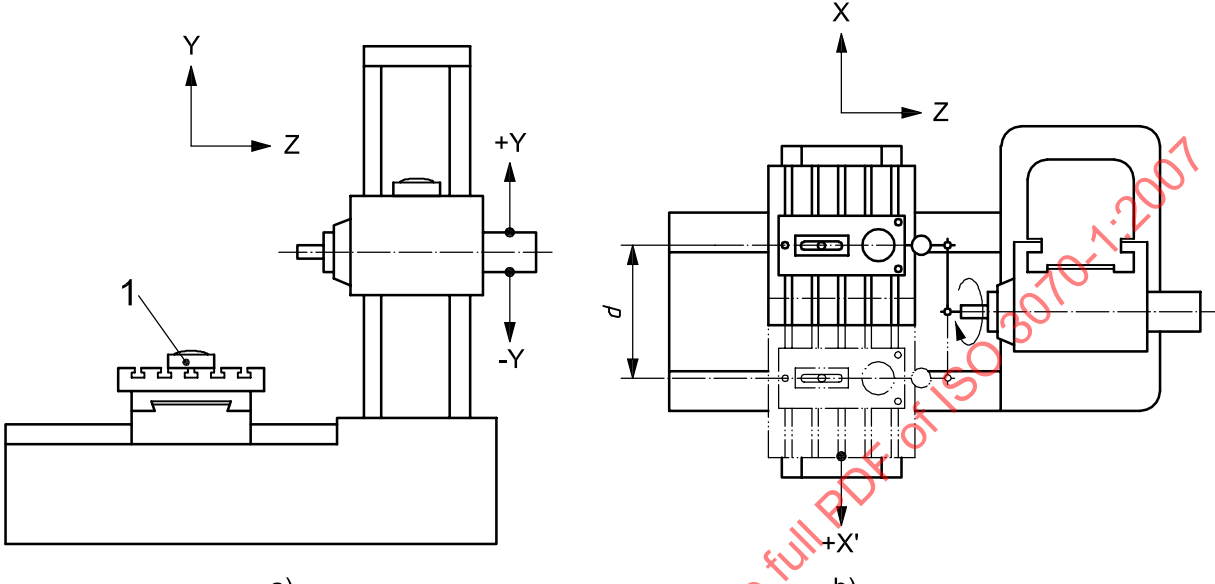
**Observations and references to ISO 230-1:1996****5.232.11**

Set a cylindrical square on the table so that the straightedge is parallel to the movement of the spindle head (Y axis) (*parallel* means that the reading of the linear displacement sensor touching the straightedge at both ends of the movement is the same value).

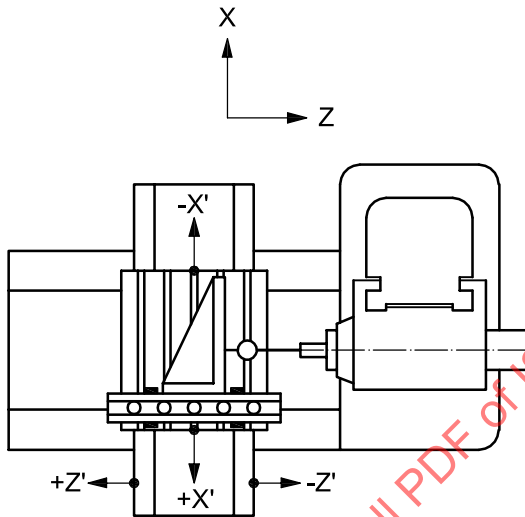
Lock the table and table saddle in mid-travel.

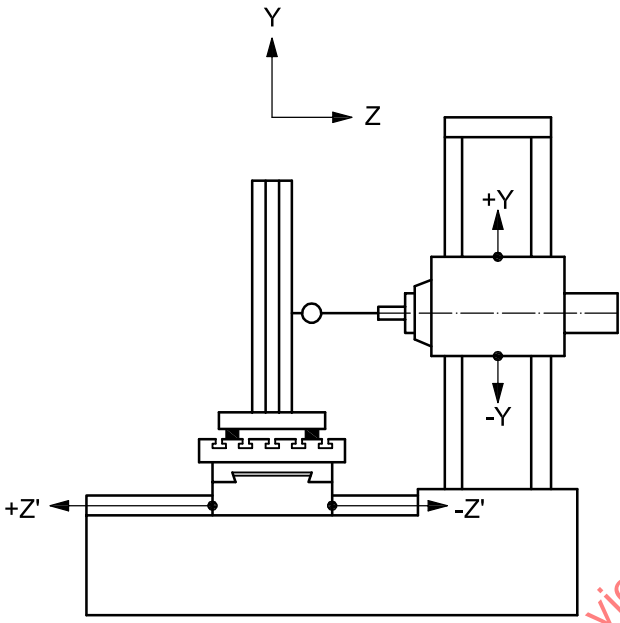
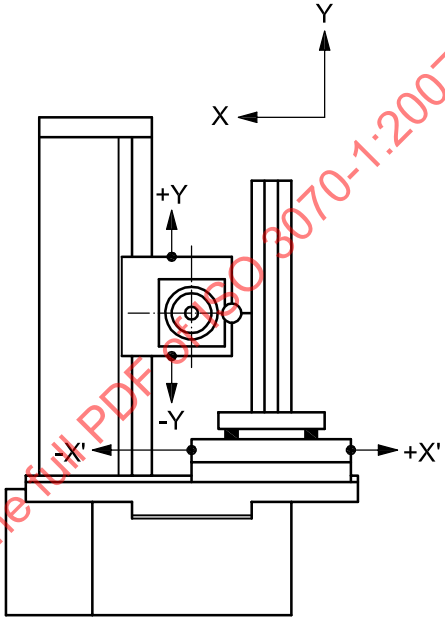
If the spindle can be locked, mount the linear displacement sensor on it. If the spindle cannot be locked, mount the linear displacement sensor on the spindle head.

- a) Apply the stylus of the linear displacement sensor to the cylindrical square in the Z-axis direction and move the head in the Y-axis direction through the measuring length.
- b) Apply the stylus of the linear displacement sensor to the cylindrical square in the X-axis direction and carry out the same procedure as specified above.

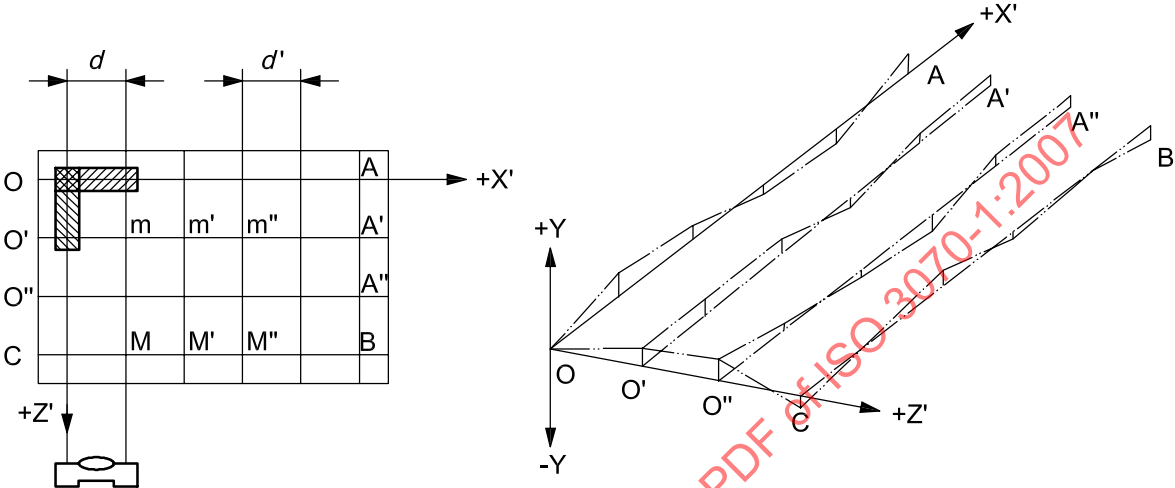
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                        |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | <b>G6</b>                              |
| Checking of the angular deviations of the spindle head movement(Y axis):<br>a) in the YZ plane (EAY);<br>b) in the ZX plane (EBY, roll).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                        |
| <b>Diagram</b><br> <p>a) b)</p> <p><b>Key</b><br/>1 reference level</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                        |
| <b>Tolerance</b><br>a) and b)<br>$Y \leq 4\,000$ : 0,04/1 000<br>$Y > 4\,000$ : 0,06/1 000                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>Measured deviations</b><br>a)<br>b) |
| <b>Measuring instruments</b><br>a) Precision level, laser interferometer or other optical angular deviation measuring instruments<br>b) Surface plate, cylindrical square, level and linear displacement sensors/support arm                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                        |
| <b>Observations and references to ISO 230-1:1996</b> <span style="float: right;"><b>5.231.3 and 5.232.2</b></span><br>a) Place a level on the spindle head in the Z-axis direction.<br>b) Mount a surface plate on the table and adjust it so that its face is levelled.<br>Place a cylindrical square on the surface plate so that it is touched by the stylus of the linear displacement sensor mounted on a special arm fixed to the spindle head.<br>Place a level also on the surface plate in the Z-axis direction.<br>Note the readings at the measuring positions of the spindle head travel (Y axis).<br>Move the table distance, $d$ , and reset the linear displacement sensor so that the stylus touches the cylindrical square.<br>When the level is shown as different because of roll in the table movement, adjust the level of the surface plate so that it is the same as that of the first position, then note readings at the same measuring positions.<br>For each measuring position, calculate the differences between two readings, then the difference between maximum and minimum divided by distance, $d$ , to give the angular deviation.<br>Measurements shall be carried out at a minimum of five positions equally spaced along the travel in both directions of up and down movements.<br><b>NOTE</b> The levelling difference between the two locations of the table directly influences the measurement results. |                                        |

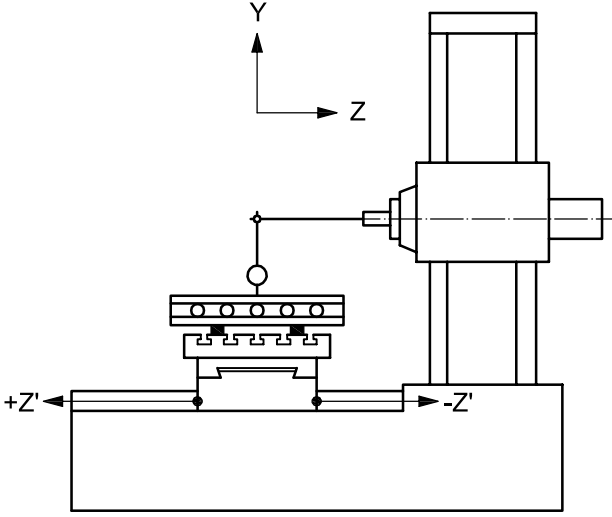
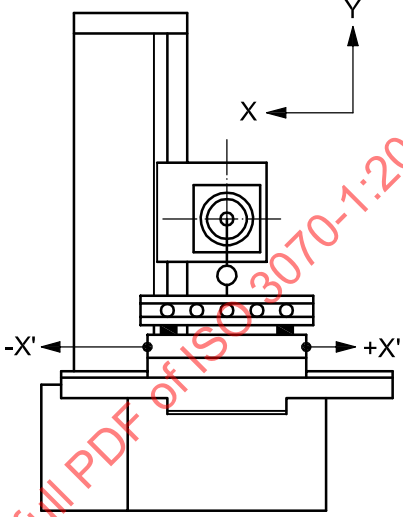
## 7.2 Squareness between linear axes

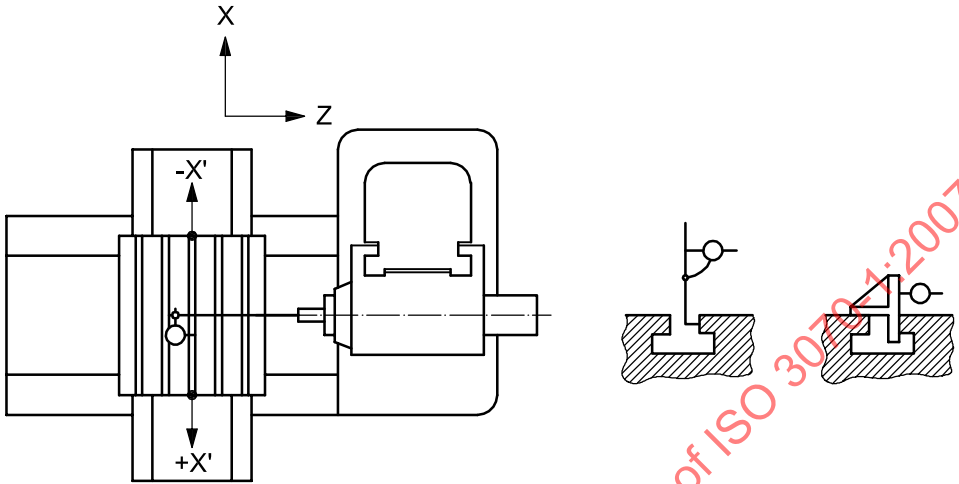
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                           |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | <b>G7</b>                 |
| Checking of the squareness between the table movement (X axis) and the table saddle movement (Z axis).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                           |
| <b>Tolerance</b><br><br>0,02 for any measuring length of 500                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | <b>Measured deviation</b> |
| <b>Measuring instruments</b><br><br>Straightedge, square and linear displacement sensor/support                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                           |
| <b>Observations and references to ISO 230-1:1996</b> <div style="float: right;"><b>5.522.4</b></div> <p>Lock the spindle head in mid-travel.</p> <p>Align the straightedge parallel to the table saddle movement (Z axis) and press the square against it (<i>parallel</i> means that the reading of the linear displacement sensor touching the straightedge at both ends of the movement is the same value). Lock the table saddle in mid-travel.</p> <p>If the spindle can be locked, mount the linear displacement sensor on it. If the spindle cannot be locked, mount the linear displacement sensor on the spindle head.</p> <p>Apply the stylus of the linear displacement sensor to the reference face of the square.</p> <p>Move the table in the X-axis direction and note the readings.</p> <p><b>NOTE</b> This test can be carried out without using a straightedge, by directly applying the stylus of the linear displacement sensor to the two faces of the square.</p> |                           |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | <b>G8</b>                                      |
| Checking of the squareness of the spindle head movement (Y axis) relative to<br>a) the table saddle movement (Z axis),<br>b) the table movement (X axis).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                |
| <b>Diagram</b> <div style="display: flex; justify-content: space-around; align-items: flex-end;">   </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <span>a)</span> <span>b)</span> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                |
| <b>Tolerance</b><br><br>a) and b)<br><br>0,02 for any measuring length of 500                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | <b>Measured deviations</b><br><br>a)<br><br>b) |
| <b>Measuring instruments</b><br><br>Cylindrical square, surface plate, adjustable blocks and linear displacement sensor/support                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                                |
| <b>Observations and references to ISO 230-1:1996</b> <div style="float: right;"><b>5.522.4</b></div> <p>Mount a surface plate on the table and adjust it so that its surface is parallel to both X- and Z-axis movements. Place the cylindrical square on the surface plate.</p> <p>Lock the table and table saddle in mid-travel.</p> <p>If the spindle can be locked, mount the linear displacement sensor on it. If the spindle cannot be locked, mount the linear displacement sensor on the spindle head.</p> <p>a) Apply the stylus of the linear displacement sensor to the cylindrical square in the Z-axis direction and move the head in the Y-axis direction through the measuring length, noting the maximum difference between the readings.</p> <p>b) Apply the stylus of the linear displacement sensor to the cylindrical square in the X-axis direction and carry out the same procedure as specified above.</p> |                                                |

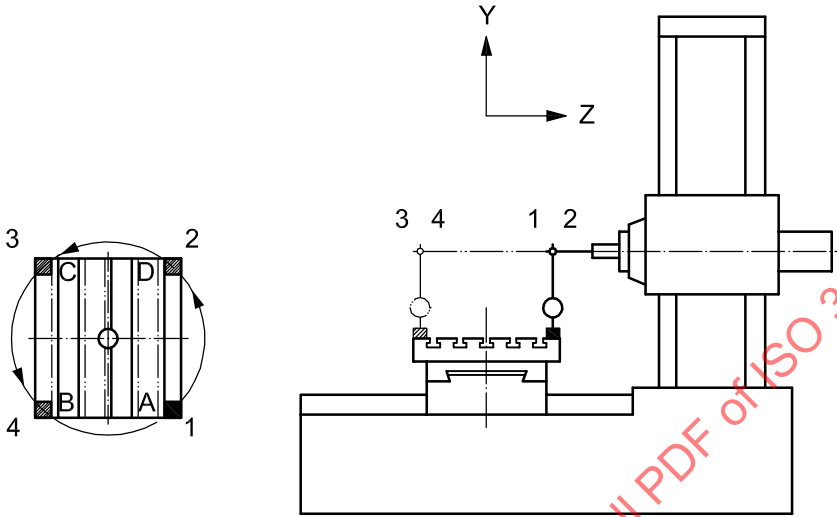
## 7.3 Table

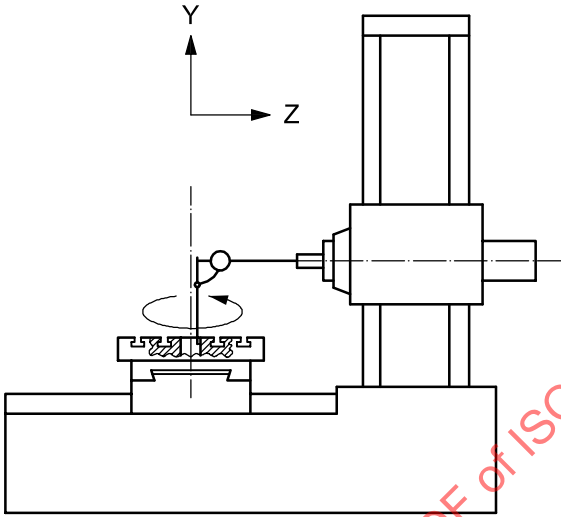
|                                                                                                                                                                                                                                                                                                                            |                           |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                              | <b>G9</b>                 |
| Checking of the flatness of the table surface.                                                                                                                                                                                                                                                                             |                           |
| <b>Diagram</b>                                                                                                                                                                                                                           |                           |
| <b>Tolerance</b> <p>For the longer side, a length of O-X or O-Z</p> <p>0,03 for measuring lengths up to 1 000 (flat to concave)</p> <p>Add 0,01 to the preceding tolerance for each 1 000 increase in length beyond 1 000</p> <p>Maximum tolerance: 0,05</p> <p>Local tolerance: 0,015 for any measuring length of 300</p> | <b>Measured deviation</b> |
| <b>Measuring instruments</b> <p>Precision level or straightedge, gauge blocks and linear displacement sensor or optical or other equipment</p>                                                                                                                                                                             |                           |
| <b>Observations and references to ISO 230-1:1996</b> <p>The table and table saddle may be locked in mid-travel.</p>                                                                                                                                                                                                        |                           |
| <b>5.322, 5.323 and 5.324</b>                                                                                                                                                                                                                                                                                              |                           |

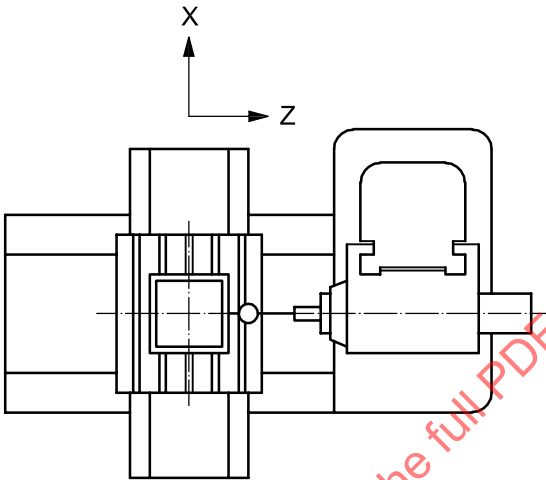
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                       |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | <b>G10</b>                            |
| Checking of the parallelism of the table surface relative to<br>a) the table saddle movement (Z axis);<br>b) the table movement (X axis).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                       |
| <b>Diagram</b> <div style="display: flex; justify-content: space-around; align-items: center;">   </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <span>a)</span> <span>b)</span> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                       |
| <b>Tolerance</b><br>a) 0,04 for measuring lengths up to 1 000<br>Add 0,01 to the preceding tolerance, for each 1 000 increase in length beyond 1 000.<br>Maximum tolerance: 0,06<br>Local tolerance: 0,015 for any measuring length of 300<br>b) 0,04 for any measuring length of 1 000                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <b>Measured deviation</b><br>a)<br>b) |
| <b>Measuring instruments</b><br>Linear displacement sensor, straightedge and gauge blocks                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                       |
| <b>Observations and references to ISO 230-1:1996</b> <div style="float: right; text-align: right;"> <b>5.422.21</b> </div> <p>If the spindle can be locked, mount the linear displacement sensor on it. If the spindle cannot be locked, mount the linear displacement sensor on the spindle head.</p> <p>Place the stylus of the linear displacement sensor in a vertical plane approximately coaxial with the spindle axis.</p> <p>Set the straightedge on the table parallel to the table surface and traverse the table or saddle through the measuring length, noting the variation in reading. If the traverse travel is longer than 1 600, carry out the inspection by successive movements of the straightedge.</p> <p>a) Carry out the test with the table locked in mid-travel.<br/>         b) Carry out the test with the table saddle locked.</p> <p>Direct measurement of the table surface without using a straightedge is also possible using a linear displacement sensor and gauge block.</p> <p>For rotary-type tables, the test shall be carried out at each of the following indexed positions of the rotary table: 0°, 90°, 180° and 270°.</p> |                                       |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                           |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>G11</b>                |
| Checking of the parallelism of the median or reference T-slot to the table movement (X axis).                                                                                                                                                                                                                                                                                                                                                   |                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                |                           |
| <b>Tolerance</b><br><br>0,03 for any measuring length of 1 000<br><br>Maximum tolerance : 0,04                                                                                                                                                                                                                                                                                                                                                  | <b>Measured deviation</b> |
| <b>Measuring instruments</b><br><br>Linear displacement sensor and cross-square                                                                                                                                                                                                                                                                                                                                                                 |                           |
| <b>Observations and references to ISO 230-1:1996</b> <span style="float: right;"><b>5.422.21</b></span><br><br>If the spindle can be locked, the linear displacement sensor may be mounted on it. If the spindle cannot be locked, mount the linear displacement sensor on the spindle head.<br><br>The stylus of the linear displacement sensor may be made to touch the reference face of the T-slot either directly or using a cross-square. |                           |

## 7.4 Indexing or rotary table

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                           |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | <b>G12</b>                |
| Checking of the face run-out of the table surface in its rotating movement.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                           |
| <b>Tolerance</b><br><br>0,02 for a measuring diameter of 1 000                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | <b>Measured deviation</b> |
| <b>Measuring instruments</b><br><br>Linear displacement sensor/support and gauge block                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                           |
| <b>Observations and references to ISO 230-1:1996</b> <div style="float: right;"><b>5.632</b></div> <p>With the linear displacement sensor in position 1, place a gauge block near corner A of the table and perform a measurement. Remove the gauge block and rotate the table until corner B comes to the measuring position and perform a measurement by inserting the same gauge block. Carry out the same operation at corners C and D by rotating the table.</p> <p>Repeat the same process, placing the linear displacement sensor in the successive positions of 2, 3 and 4 or at least in position 2.</p> <p>For each of those positions, record the difference between the maximum and minimum readings.</p> <p>Use the greatest of these differences as the value of face run-out.</p> <p>Lock the table each time before taking measurements, if applicable.</p> |                           |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                           |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | <b>G13</b>                |
| Checking of the run-out of the centring hole of the table in relation to its axis of rotation.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                           |
| <b>Tolerance</b><br><br>0,015                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | <b>Measured deviation</b> |
| <b>Measuring instruments</b><br><br>Linear displacement sensor/support and possibly test mandrel                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                           |
| <b>Observations and references to ISO 230-1:1996</b> <div style="float: right;"><b>5.612.3</b></div> <p>If the spindle can be locked, the linear displacement sensor may be mounted on it. If the spindle cannot be locked, mount the linear displacement sensor on the spindle head.</p> <p>Set the stylus of the linear displacement sensor coaxial with the axis of the centring hole and as near as possible to the table surface.</p> <p>Rotate the table and record the difference between the maximum and the minimum reading as the measured deviations.</p> <p>Checking may also be carried out using a test mandrel inserted into the centre hole.</p> |                           |

|                                                                                                                                                                                                                                                                                                                     |                               |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                       | <b>G14</b>                    |
| <p>Checking of the accuracy of the table angular positions at 0°, 90°, 180° and 270°</p> <p>a) for a rotary indexable table with only four fixed positions 90° apart;</p> <p>b) for a rotary indexable table with any number of fixed positions;</p> <p>c) for a rotary table capable of any angle positioning.</p> |                               |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                      |                               |
|                                                                                                                                                                                                                                  |                               |
| <b>Tolerance</b>                                                                                                                                                                                                                                                                                                    | <b>Measured deviation</b>     |
| <p>a) 0,03 for any measuring length of 500</p> <p>b) 0,05 for any measuring length of 500</p> <p>c) 0,075 for any measuring length of 500</p>                                                                                                                                                                       | <p>a)</p> <p>b)</p> <p>c)</p> |
| <b>Measuring instruments</b>                                                                                                                                                                                                                                                                                        |                               |
| Square and linear displacement sensor/support                                                                                                                                                                                                                                                                       |                               |
| <b>Observations and references to ISO 230-1:1996</b>                                                                                                                                                                                                                                                                |                               |
| <b>6.41, 6.42, 6.43 and Annex A.5</b>                                                                                                                                                                                                                                                                               |                               |
| Set a square on the table with one edge parallel to the table movement (X axis).                                                                                                                                                                                                                                    |                               |
| Index the table four times in one direction (90°, 180°, 270° and 360°) and check in every position the parallelism between the table movement and the corresponding edge of the square.                                                                                                                             |                               |
| Index the table four times in the opposite direction (270°, 180°, 90° and 0°) and check again the parallelism in every position. The maximum difference of the eight readings shall not exceed the tolerance.                                                                                                       |                               |
| NOTE Test P6 presents a test procedure for NC rotary tables.                                                                                                                                                                                                                                                        |                               |

## 7.5 Boring spindle

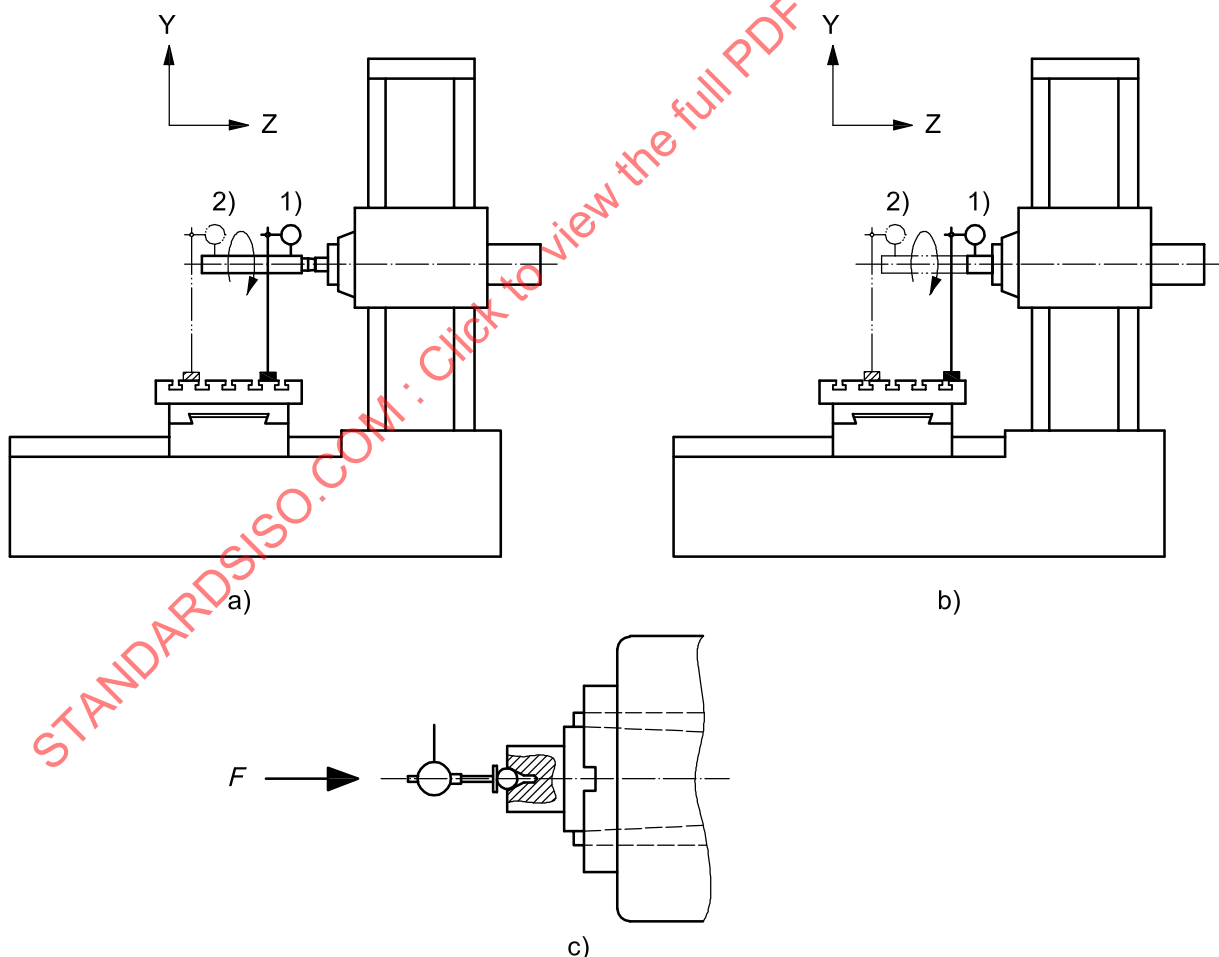
### Object

**G15**

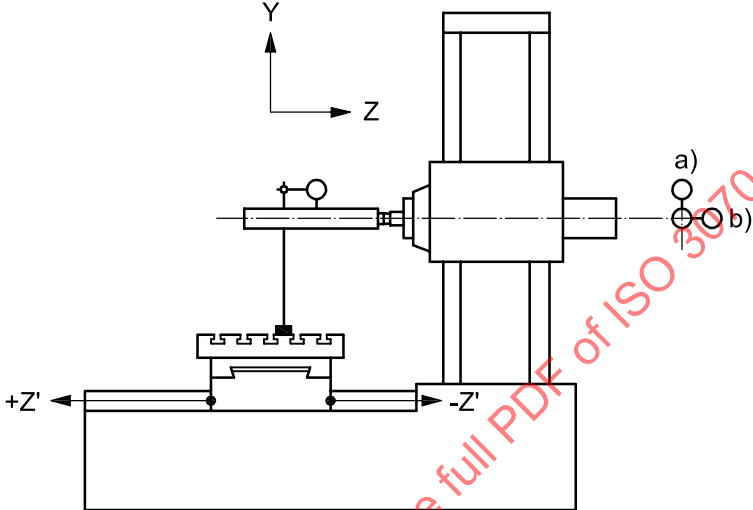
Checking of the boring spindle:

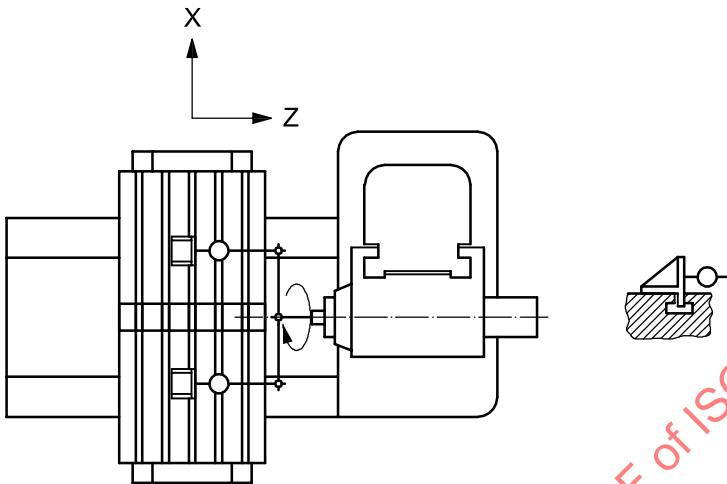
- a) run-out of the internal taper, with the spindle retracted
  - 1) at the mouth of the taper,
  - 2) at a distance of 300 mm from the spindle nose;
- b) run-out of the external diameter with
  - 1) the spindle retracted,
  - 2) the spindle extended 300 mm;
- c) periodic axial slip, with the spindle retracted.

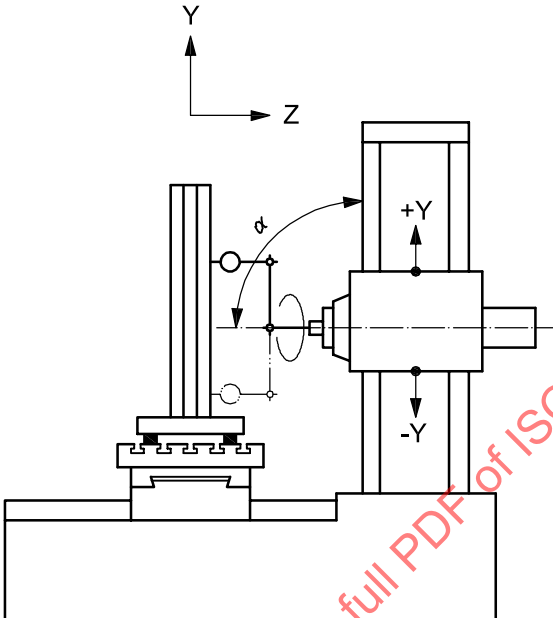
### Diagram

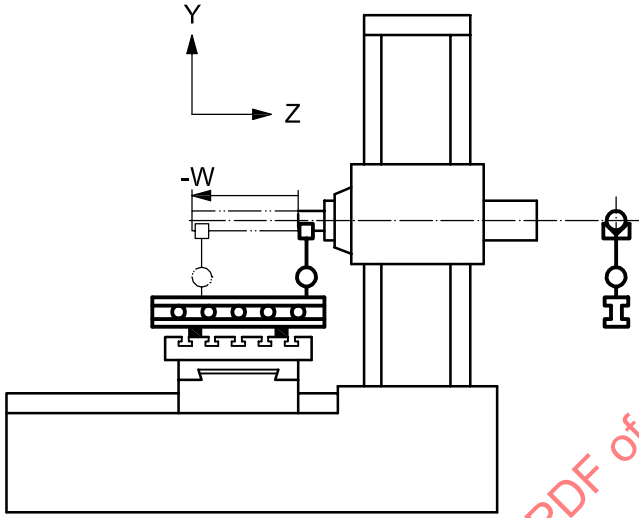


| Tolerance                                                                                                       |              |           | Measured deviation |
|-----------------------------------------------------------------------------------------------------------------|--------------|-----------|--------------------|
|                                                                                                                 | $D \leq 125$ | $D > 125$ | a)                 |
| a) and b)                                                                                                       | 1) 0,01      | 0,015     | b)                 |
|                                                                                                                 | 2) 0,02      | 0,03      | c)                 |
| c)                                                                                                              | 0,01         | 0,015     |                    |
| where $D$ is the diameter of the boring spindle.                                                                |              |           |                    |
| Measuring instruments                                                                                           |              |           |                    |
| Test mandrel and linear displacement sensor                                                                     |              |           |                    |
| Observations and references to ISO 230-1:1996                                                                   |              |           |                    |
| a) 5.612.3                                                                                                      |              |           |                    |
| b) 5.612.2                                                                                                      |              |           |                    |
| c) 5.622.1 and 5.622.2                                                                                          |              |           |                    |
| The value and the direction of application of the force, $F$ , shall be specified by the supplier/manufacturer. |              |           |                    |
| When preloaded bearings are used, no force need be applied.                                                     |              |           |                    |
| NOTE Test R1 is a spindle test for evaluating error motions of the spindle.                                     |              |           |                    |

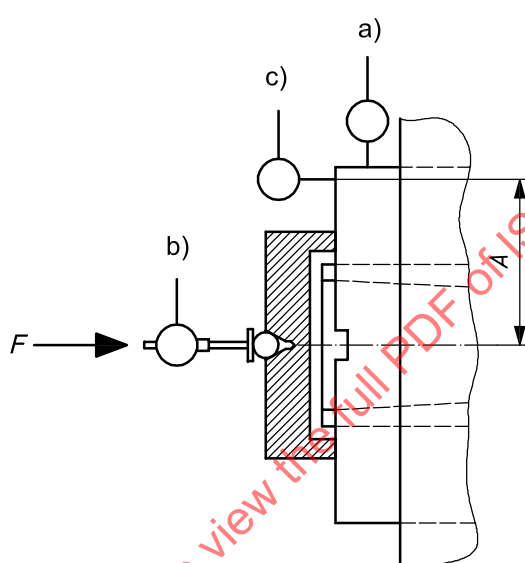
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                               |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | <b>G16</b>                                    |
| <p>Checking of the parallelism of the boring spindle axis to the table saddle movement (Z axis)</p> <p>a) in the YZ plane (vertical);</p> <p>b) in the ZX plane (horizontal).</p>                                                                                                                                                                                                                                                                                                                                                                                        |                                               |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                               |
| <b>Tolerance</b> <p>a) and b)</p> <p>0,02 for any measuring length of 300</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | <b>Measured deviation</b> <p>a)</p> <p>b)</p> |
| <b>Measuring instruments</b> <p>Linear displacement sensor and test mandrel</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                               |
| <b>Observations and references to ISO 230-1:1996</b> <p style="text-align: right;"><b>5.412.1 and 5.422.3</b></p> <p>The spindle head shall be locked in mid-travel and the spindle shall be retracted.</p> <p>The table may be locked in the central position.</p> <p>Measurement shall be carried out with the aid of the test mandrel mounted on the spindle nose.</p> <p>Carry out the measurement at the mean position of run-out of the spindle rotation or evaluate the mean value of measurements taken at two positions of the spindle rotation 180° apart.</p> |                                               |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                           |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | <b>G17</b>                |
| Checking of the squareness of the boring spindle axis relative to the table movement (X axis).                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                           |
| <b>Tolerance</b><br><br>$0,02/500$<br><br>(500 is the distance between the two measuring points touched.)                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>Measured deviation</b> |
| <b>Measuring instruments</b><br><br>Linear displacement sensor/support and square block                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                           |
| <b>Observations and references to ISO 230-1:1996</b> <span style="float: right;"><b>5.512.1 and 5.512.32</b></span><br><br>The spindle head shall be locked in mid-travel (Y axis).<br><br>Table saddle (Z axis) shall be locked.<br><br>Place the stylus of the linear displacement sensor against the square block on the table.<br><br>Turn the boring spindle and move the table to touch the square block at the same point.<br><br>The difference between the two readings divided by the distance between the two measuring points defines the squareness deviation. |                           |

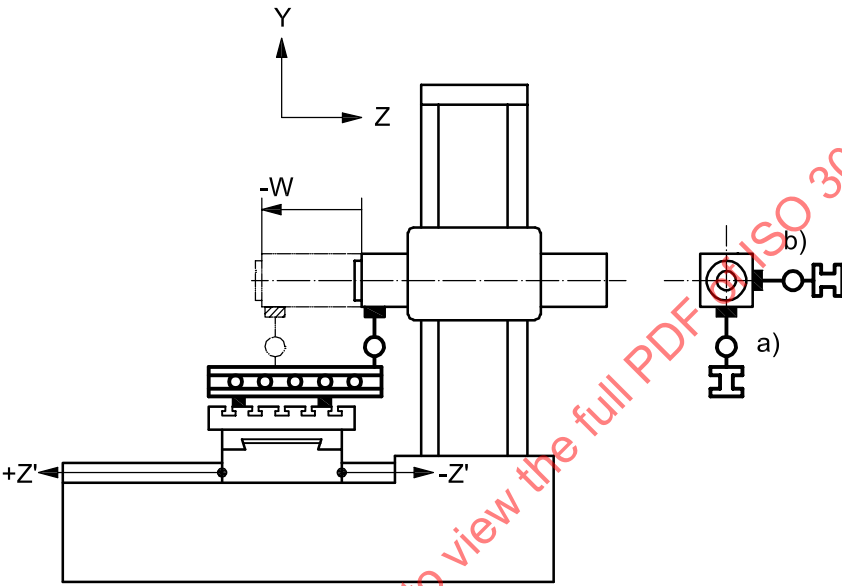
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                           |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | <b>G18</b>                |
| Checking of the squareness of the boring spindle axis relative to the spindle head movement (Y axis).                                                                                                                                                                                                                                                                                                                                                                                                                            |                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                                                |                           |
| <b>Tolerance</b><br><br>$0,02/500$ with $\alpha \leq 90^\circ$<br><br>(500 is the distance between the two measuring points touched.)                                                                                                                                                                                                                                                                                                                                                                                            | <b>Measured deviation</b> |
| <b>Measuring instruments</b><br><br>Cylindrical square, adjustable blocks, linear displacement sensor/support and surface plate                                                                                                                                                                                                                                                                                                                                                                                                  |                           |
| <b>Observations and references to ISO 230-1:1996</b> <div style="float: right;"><b>5.512.1 and 5.512.32</b></div> <p>The spindle head shall be locked in mid-travel, and the spindle and, possibly, the ram shall be retracted (sliding spindle).</p> <p>The table and table saddle shall be locked.</p> <p>The cylindrical square shall be set on the table parallel to the spindle head movement (Y axis).</p> <p>Turn the spindle with the linear displacement sensor attached so that it touches the cylindrical square.</p> |                           |

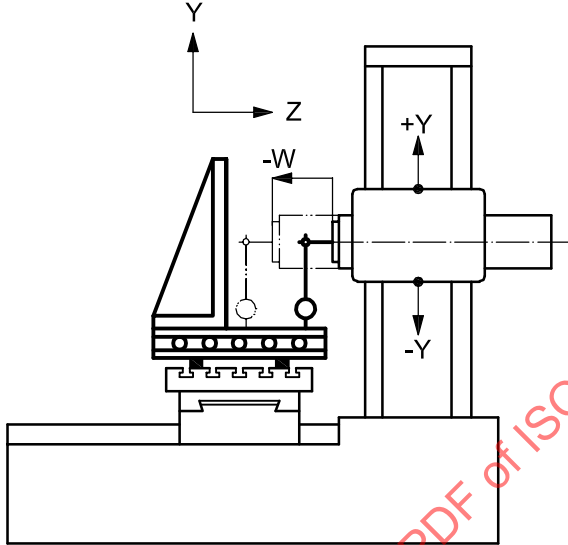
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                           |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | <b>G19</b>                |
| Checking of the parallelism of the boring spindle movement (W axis) relative to the table saddle movement (Z axis) in the vertical plane.                                                                                                                                                                                                                                                                                                                                                                                                         |                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                           |
| <b>Tolerance</b> <p>For an extension of the spindle equal to</p> <p>2D: + 0,015 (upwards)</p> <p>4D: ± 0,02</p> <p>6D: – 0,06 (downwards)</p> <p>where <i>D</i> is the diameter of the boring spindle.</p> <p>The extension of the spindle is limited to six times the spindle diameter and shall not exceed 900.</p> <p>The tolerance is limited to spindle diameter of 150; when the spindle diameter is over 150, the tolerance shall be agreed upon between the user and supplier/manufacturer.</p>                                           | <b>Measured deviation</b> |
| <b>Measuring instruments</b> <p>Straightedge, gauge block and linear displacement sensor</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                           |
| <b>Observations and references to ISO 230-1:1996</b> <p>5.232.1 and 5.422.22</p> <p>Place the straightedge on the table vertically in a plane containing the spindle axis and adjust it parallel to the table saddle movement (Z axis).</p> <p>The spindle rotation shall be locked.</p> <p>Touch the functional surface of the straightedge with the linear displacement sensor fixed on the spindle nose.</p> <p>Extend the spindle to the required length and record the linear displacement sensor readings for each successive position.</p> |                           |

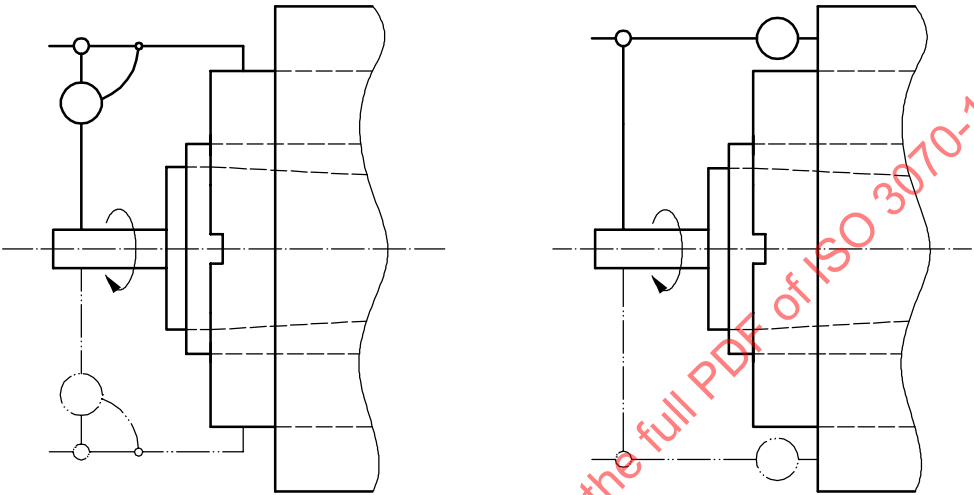
## 7.6 Milling spindle

|                                                                                                                                                                                                                                               |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------|--------------------|--------------|-----------|----|------|-------|----|------|-------|----|------|------|----------------|
| Object                                                                                                                                                                                                                                        |                                                                        | G20                |              |           |    |      |       |    |      |       |    |      |      |                |
| Checking of the milling spindle:                                                                                                                                                                                                              |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| a) run-out;                                                                                                                                                                                                                                   |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| b) periodic axial slip;                                                                                                                                                                                                                       |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| c) face run-out of the spindle nose (including periodic axial slip).                                                                                                                                                                          |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| Diagram                                                                                                                                                                                                                                       |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
|                                                                                                                                                            |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| Tolerance                                                                                                                                                                                                                                     |                                                                        | Measured deviation |              |           |    |      |       |    |      |       |    |      |      |                |
| <table><tr><td></td><td><math>D \leq 125</math></td><td><math>D &gt; 125</math></td></tr><tr><td>a)</td><td>0,01</td><td>0,015</td></tr><tr><td>b)</td><td>0,01</td><td>0,015</td></tr><tr><td>c)</td><td>0,02</td><td>0,03</td></tr></table> |                                                                        |                    | $D \leq 125$ | $D > 125$ | a) | 0,01 | 0,015 | b) | 0,01 | 0,015 | c) | 0,02 | 0,03 | a)<br>b)<br>c) |
|                                                                                                                                                                                                                                               | $D \leq 125$                                                           | $D > 125$          |              |           |    |      |       |    |      |       |    |      |      |                |
| a)                                                                                                                                                                                                                                            | 0,01                                                                   | 0,015              |              |           |    |      |       |    |      |       |    |      |      |                |
| b)                                                                                                                                                                                                                                            | 0,01                                                                   | 0,015              |              |           |    |      |       |    |      |       |    |      |      |                |
| c)                                                                                                                                                                                                                                            | 0,02                                                                   | 0,03               |              |           |    |      |       |    |      |       |    |      |      |                |
| where $D$ is the diameter of the milling spindle.                                                                                                                                                                                             |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| Measuring instruments                                                                                                                                                                                                                         |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| Linear displacement sensor                                                                                                                                                                                                                    |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| Observations and references to ISO 230-1:1996                                                                                                                                                                                                 |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| a) 5.612.2                                                                                                                                                                                                                                    |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| b) 5.622.1 and 5.622.2                                                                                                                                                                                                                        |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| The value and direction of application of the force, $F$ , shall be specified by the supplier/manufacturer.                                                                                                                                   |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| When an axially preloaded bearing is used for spindle, no force $F$ is needed.                                                                                                                                                                |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| c) 5.632                                                                                                                                                                                                                                      |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| The distance, $A$ , of the linear displacement sensor c) from the spindle axis shall be as large as possible.                                                                                                                                 |                                                                        |                    |              |           |    |      |       |    |      |       |    |      |      |                |
| NOTE                                                                                                                                                                                                                                          | Test R1 is a spindle test for evaluating error motions of the spindle. |                    |              |           |    |      |       |    |      |       |    |      |      |                |

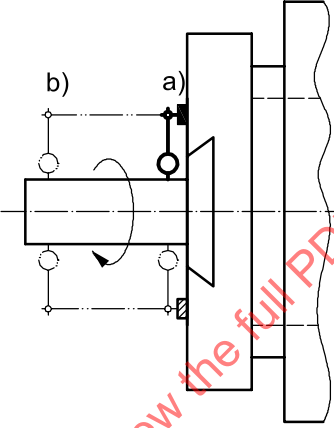
## 7.7 Ram

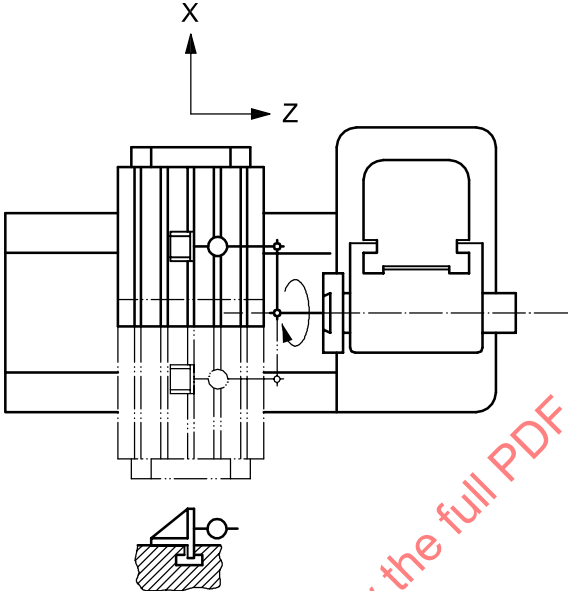
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                           |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>G21</b>                                |
| Checking of the parallelism of the ram movement (W axis) relative to the table saddle movement (Z axis):<br>a) in the YZ plane (vertical plane);<br>b) in the ZX plane (horizontal plane).                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                                           |
| <b>Tolerance</b><br><br>a) and b)<br><br>0,03 for a measuring length of 500                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | <b>Measured deviation</b><br><br>a)<br>b) |
| <b>Measuring instruments</b><br><br>Straightedge, linear displacement sensor and adjustable blocks                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                           |
| <b>Observations and references to ISO 230-1:1996</b> <div style="float: right;"> <b>5.422.22</b> </div> <p>Set a straightedge on the table parallel to the table saddle movement (Z axis) for a) a vertical measurement and b) a horizontal measurement (parallel means that the readings of the linear displacement sensor touching the straightedge at both ends of the movement are the same value).</p> <p>The table saddle shall be locked in mid-travel. The spindle head shall be locked.</p> <p>The ram movement shall be checked with respect to the straightedge using a linear displacement sensor fixed on the ram.</p> |                                           |

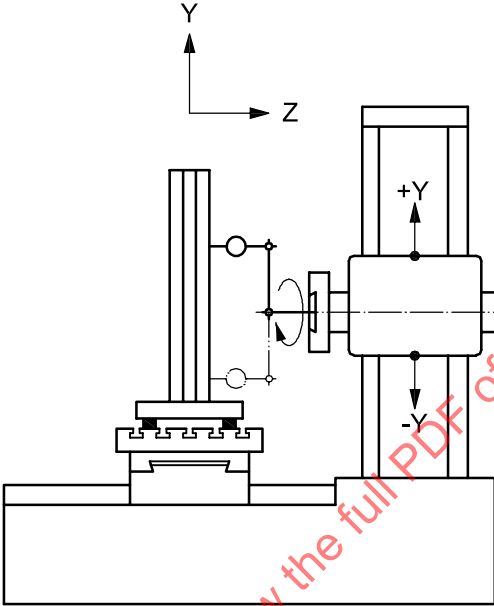
|                                                                                                                                                                                                                                                                                                                                                                  |                           |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                    | <b>G22</b>                |
| Checking of the squareness of the ram movement (W axis) relative to the spindle head movement (Y axis).                                                                                                                                                                                                                                                          |                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                 |                           |
| <b>Tolerance</b><br><br>0,03 for a measuring length of 500                                                                                                                                                                                                                                                                                                       | <b>Measured deviation</b> |
| <b>Measuring instruments</b><br>Straightedge, square, adjustable blocks and linear displacement sensor/support                                                                                                                                                                                                                                                   |                           |
| <b>Observations and references to ISO 230-1:1996</b> <span style="float: right;"><b>5.522.4</b></span><br><br>Set a straightedge on the table parallel to the ram movement (W axis) using adjustable blocks and then place a square on the straightedge.<br><br>Check the parallelism between the free arm of the square and the spindle head movement (Y axis). |                           |

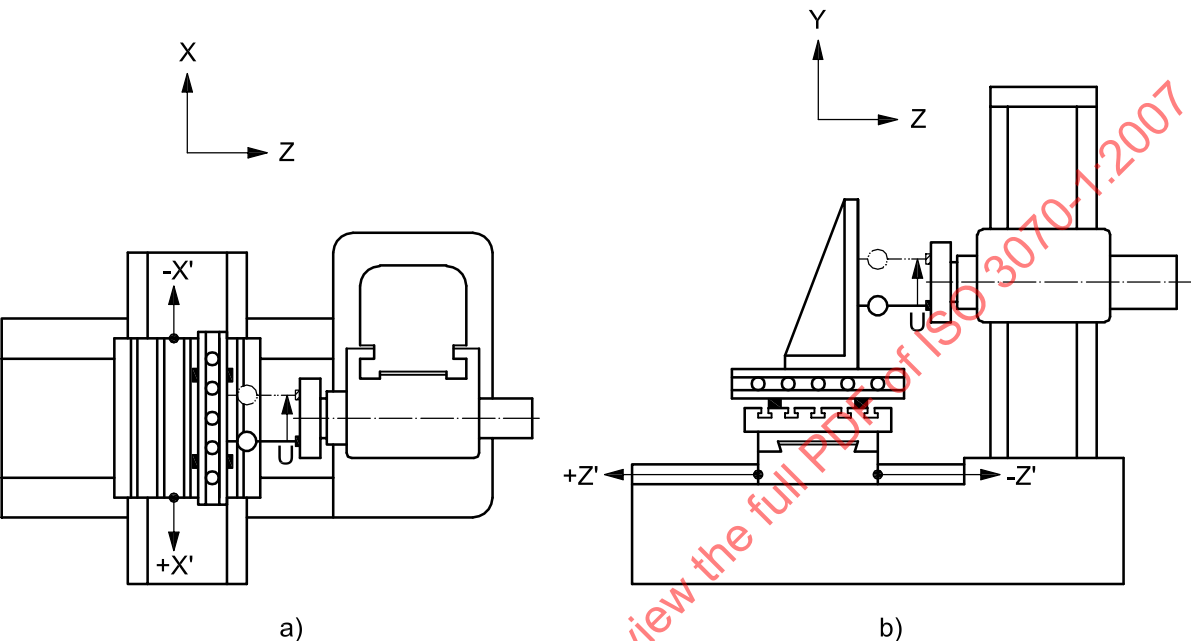
|                                                                                                                                                                                                                                                                                                                                                                                   |                                                      |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                     | <b>G23</b>                                           |
| <p>a) Checking of the concentricity of the milling spindle relative to the front centring of tools or accessories on the ram.</p> <p>b) Checking of the squareness of the support face of tools or accessories on the ram relative to the rotational axis of the milling spindle.</p> <p>NOTE These checks are valid only if there is a circular locating surface on the ram.</p> |                                                      |
| <p><b>Diagram</b></p>  <p>a) b)</p>                                                                                                                                                                                                                                                            |                                                      |
| <p><b>Tolerance</b></p> <p>a) 0,02</p> <p>b) 0,02/500</p> <p>(500 is the distance between the two measuring points touched.)</p>                                                                                                                                                                                                                                                  | <p><b>Measured deviation</b></p> <p>a)</p> <p>b)</p> |
| <p><b>Measuring instruments</b></p> <p>Linear displacement sensor and test mandrel</p>                                                                                                                                                                                                                                                                                            |                                                      |
| <p><b>Observations and references to ISO 230-1:1996</b></p> <p>a) <b>5.442</b></p> <p>The concentricity deviation is half of the maximum difference of the readings.</p> <p>b) <b>5.512.42</b></p>                                                                                                                                                                                |                                                      |

## 7.8 Integral facing head

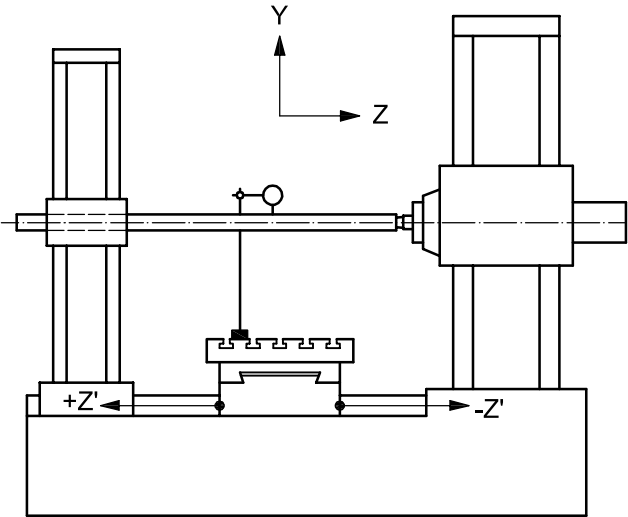
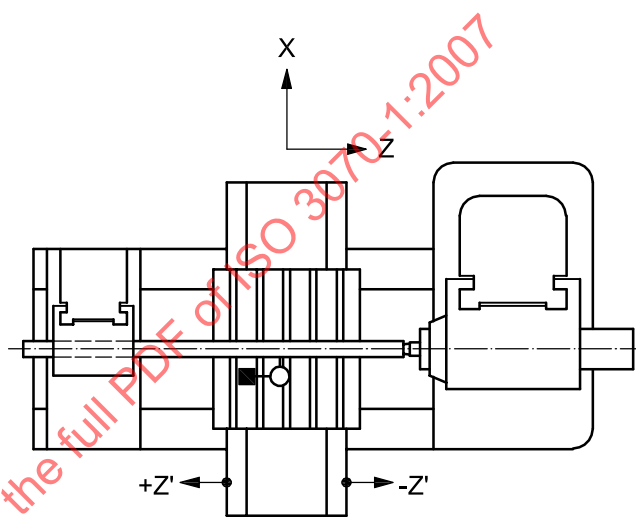
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |              |           |         |      |         |      |                                               |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|-----------|---------|------|---------|------|-----------------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | <b>G24</b>   |           |         |      |         |      |                                               |
| <p>Checking of the coaxiality of the boring spindle rotating axis and of the facing head axis:</p> <p>a) at the mouth of the spindle housing;</p> <p>b) at a distance of 300 mm from the spindle housing face.</p> <p>NOTE These checks are valid only when the facing head is mounted on bearings independent of those of the boring spindle.</p>                                                                                                                                                |              |           |         |      |         |      |                                               |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                 |              |           |         |      |         |      |                                               |
| <b>Tolerance</b> <table border="0" style="margin-left: auto; margin-right: auto;"> <tr> <td style="text-align: center;"><math>D \leq 125</math></td><td style="text-align: center;"><math>D &gt; 125</math></td></tr> <tr> <td style="text-align: center;">a) 0,02</td><td style="text-align: center;">0,03</td></tr> <tr> <td style="text-align: center;">b) 0,03</td><td style="text-align: center;">0,04</td></tr> </table> <p>where <math>D</math> is the diameter of the boring spindle.</p> | $D \leq 125$ | $D > 125$ | a) 0,02 | 0,03 | b) 0,03 | 0,04 | <b>Measured deviation</b> <p>a)</p> <p>b)</p> |
| $D \leq 125$                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | $D > 125$    |           |         |      |         |      |                                               |
| a) 0,02                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 0,03         |           |         |      |         |      |                                               |
| b) 0,03                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 0,04         |           |         |      |         |      |                                               |
| <b>Measuring instruments</b> <p>Linear displacement sensor and test mandrel</p>                                                                                                                                                                                                                                                                                                                                                                                                                   |              |           |         |      |         |      |                                               |
| <p><b>Observations and references to ISO 230-1:1996</b> <span style="float: right;"><b>5.442</b></span></p> <p>A linear displacement sensor fixed on the facing head shall touch the boring spindle at the mouth and at 300.</p> <p>For each operation, determine half the difference of the extreme readings to obtain the coaxiality deviation.</p>                                                                                                                                             |              |           |         |      |         |      |                                               |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                           |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | <b>G25</b>                |
| Checking of the squareness of the facing head rotation axis relative to the table movement (X axis).                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                           |
| NOTE This check is valid only when the facing head is mounted on bearings independent of those of the boring spindle.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                           |
| <b>Diagram</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                           |
| <b>Tolerance</b><br><br>0,02/500<br>(500 is the distance between the two measuring points touched.)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | <b>Measured deviation</b> |
| <b>Measuring instruments</b><br>Linear displacement sensor/rigid support and square block                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                           |
| <b>Observations and references to ISO 230-1:1996</b> <span style="float: right;"><b>5.512.1 and 5.512.32</b></span><br><p>The spindle head shall be locked in mid-travel (Y axis) and the spindle shall be retracted.</p> <p>The table saddle (Z axis) shall be locked.</p> <p>Place the stylus of the linear displacement sensor on the facing head against the square block on the table.</p> <p>Turn the facing head with the linear displacement sensor and move the table so as to touch the square block with the stylus at the same point.</p> <p>The difference between the two readings divided by the distance between the two measuring points defines the squareness deviation.</p> |                           |

|                                                                                                                                    |                           |
|------------------------------------------------------------------------------------------------------------------------------------|---------------------------|
| <b>Object</b>                                                                                                                      | <b>G26</b>                |
| Checking of the squareness of the facing head rotation axis relative to the spindle head movement (Y axis).                        |                           |
| NOTE This check is valid only when the facing head is mounted on bearings independent of those of the boring spindle.              |                           |
| <b>Diagram</b>                                  |                           |
| <b>Tolerance</b><br><br>0,02/500<br>(500 is the distance between the two measuring points touched.)                                | <b>Measured deviation</b> |
| <b>Measuring instruments</b>                                                                                                       |                           |
| Linear displacement sensor/rigid support, surface plate, gauge blocks and cylindrical square                                       |                           |
| <b>Observations and references to ISO 230-1:1996</b>                                                                               |                           |
| <b>5.512.1 and 5.512.32</b>                                                                                                        |                           |
| The spindle head shall be locked in mid-travel and the spindle shall be retracted.                                                 |                           |
| Set a cylindrical square on the table parallel to the spindle head movement (Y axis).                                              |                           |
| Fix a linear displacement sensor to the facing head and place its stylus such that it can touch the cylindrical square.            |                           |
| Turn the facing head with the linear displacement sensor so that it touches the cylindrical square.                                |                           |
| The difference between the two readings divided by the distance between the two measuring points defines the squareness deviation. |                           |

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                      |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | <b>G27</b>                                           |
| <p>a) Checking of the parallelism of the radial facing slide movement (U axis) in the horizontal plane relative to the table movement (X axis).</p> <p>b) Checking of the squareness of the radial facing slide movement (U axis) in the vertical plane relative to the table saddle movement (Z axis).</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                                      |
| <p><b>Diagram</b></p>  <p>a) b)</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                      |
| <p><b>Tolerance</b></p> <p>a) and b)</p> <p>0,025 for a measuring length of 300</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | <p><b>Measured deviation</b></p> <p>a)</p> <p>b)</p> |
| <p><b>Measuring instruments</b></p> <p>a) Straightedge, linear displacement sensor/support and gauge blocks</p> <p>b) Straightedge, square, linear displacement sensor/support and gauge blocks</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                                      |
| <p><b>Observations and references to ISO 230-1:1996</b></p> <p>a) <b>5.422.2 and 5.422.5</b></p> <p>Set a straightedge horizontally on the table parallel to the table movement (X axis), using a linear displacement sensor fixed on the radial facing slide of the facing head.</p> <p>Move the radial facing slide (U axis), and record the difference of the readings.</p> <p>Repeat the test after turning the facing head by 180°.</p> <p>b) <b>5.522.4</b></p> <p>Set a straightedge vertically on the table parallel to the table saddle movement (Z axis), using a linear displacement sensor fixed on the radial facing slide of the facing head and place a square on it.</p> <p>The stylus of linear displacement sensor fixed on the radial facing slide touches the square.</p> <p>Move the radial facing slide vertically and record the difference between the readings.</p> <p>Repeat the same operation after turning the plate by 180°.</p> |                                                      |

## 7.9 Steady block

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                               |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------|
| <b>Object</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>G28</b>                                    |
| <p>Checking of the coincidence of the steady block bore with the boring spindle axis:</p> <p>a) in the vertical plane (YZ plane) (for machines having synchronized movements of the steady block and spindle head);</p> <p>b) in the horizontal plane (ZX plane).</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                               |
| <b>Diagram</b> <div style="display: flex; justify-content: space-around; align-items: flex-end;">   </div> <div style="display: flex; justify-content: space-around; margin-top: 10px;"> <span>a)</span> <span>b)</span> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                               |
| <b>Tolerance</b> <p>a) 0,04 for a measuring length of 1 000</p> <p>b) 0,03 for a measuring length of 1 000</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | <b>Measured deviation</b> <p>a)</p> <p>b)</p> |
| <b>Measuring instruments</b> <p>Linear displacement sensor and boring bar or test mandrel</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                               |
| <b>Observations and references to ISO 230-1:1996</b> <p>Due to the great distance between supports, a cylindrical bar or a test mandrel shall be used having sufficient length to pass completely through the steady block while mounted in the boring spindle when in its retracted position.</p> <p>A linear displacement sensor shall be set on the table with the stylus touching the test mandrel and the table moved over its entire traverse.</p> <p>The measurement is made at the two extremities: spindle end and steady block end.</p> <p>Repeat the same operations with the spindle extended.</p> <p>Test a) shall be carried out setting the spindle head and steady block first in the high position, then in the low position, or vice versa.</p> <p>Test b) shall be carried out setting the spindle head and steady block locked in mid-travel and with the table and possibly the table base locked in the central position.</p> <p>In the case of large machines, it may be desirable to use two short test mandrels, placed on the spindle nose and on the steady block bore, instead of a single mandrel.</p> |                                               |

## 8 Machining tests

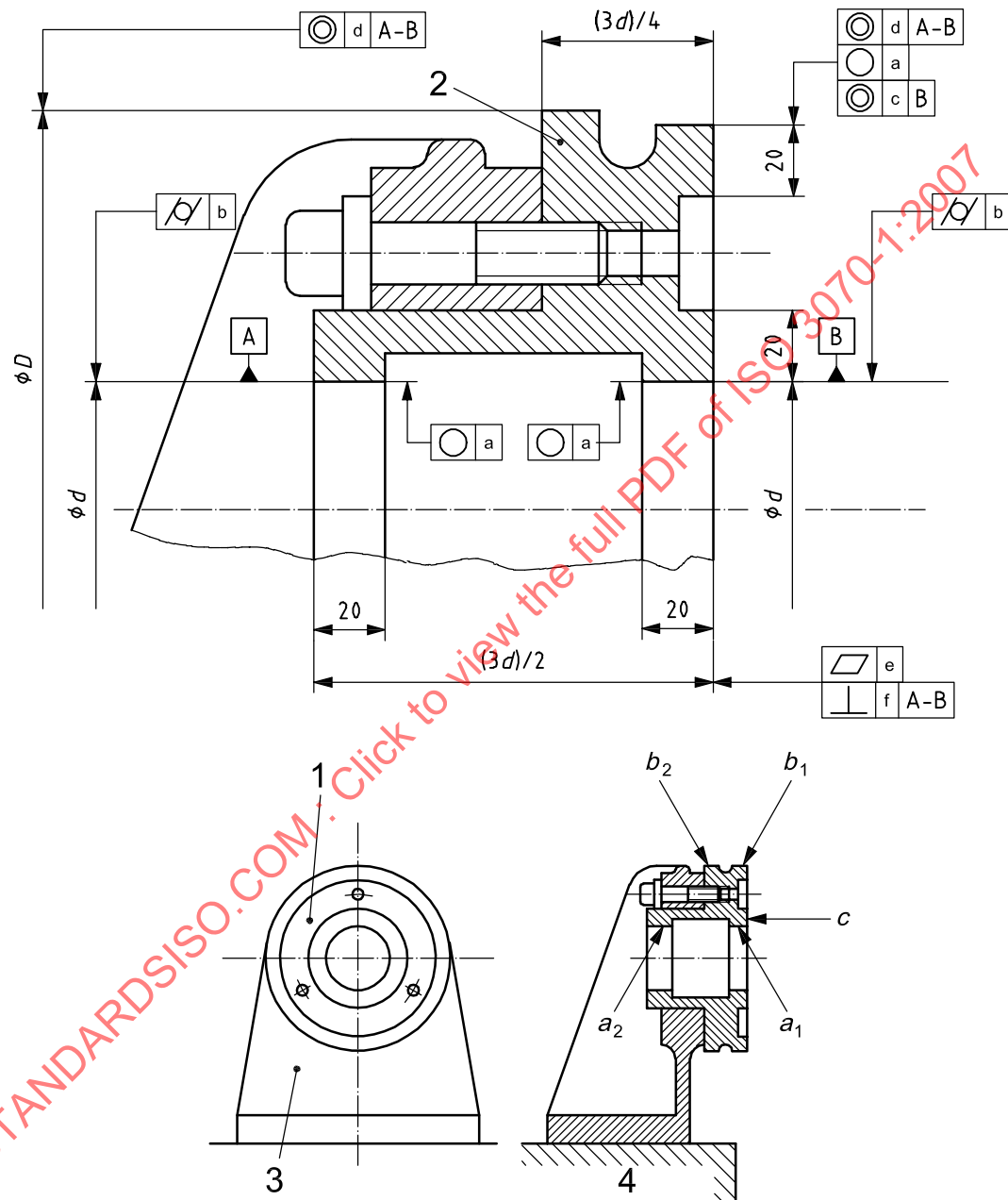
| Nature of test                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | M1 |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----|
| <p>Machining of a single test piece including:</p> <ul style="list-style-type: none"> <li>a) boring of the internal cylindrical holes, <math>a_1</math> and <math>a_2</math>;</li> <li>b) turning of the external cylindrical surfaces, <math>b_1</math> and <math>b_2</math>;</li> <li>c) facing of the surface, <math>c</math>.</li> </ul> <p>NOTE Facing testing only applies to machines having both a sliding boring spindle and either an integral or a detachable facing head, or an independent milling spindle.</p> |    |

STANDARDSISO.COM : Click to view the full PDF of ISO 3070-1:2007

**Diagram, sizes and mounting of the test piece** (given only as an example)

The boring diameter,  $d$ , shall be equal to, or slightly greater than, the boring spindle diameter.

The turning diameter,  $D$ , shall be determined so that the value  $[(D - d)/2]$  is equal to, or slightly less than, the maximum travel of the radial facing slide.



**NOTE** Test piece material: cast iron.

## Key

- 1 test piece
- 2 test piece detail
- 3 mounting fixture
- 4 table

- |   |                   |   |                   |
|---|-------------------|---|-------------------|
| a | See No. 1, p. 38. | d | See No. 4, p. 38. |
| b | See No. 2, p. 38. | e | See No. 5, p. 38. |
| c | See No. 3, p. 38. | f | See No. 6, p. 38. |

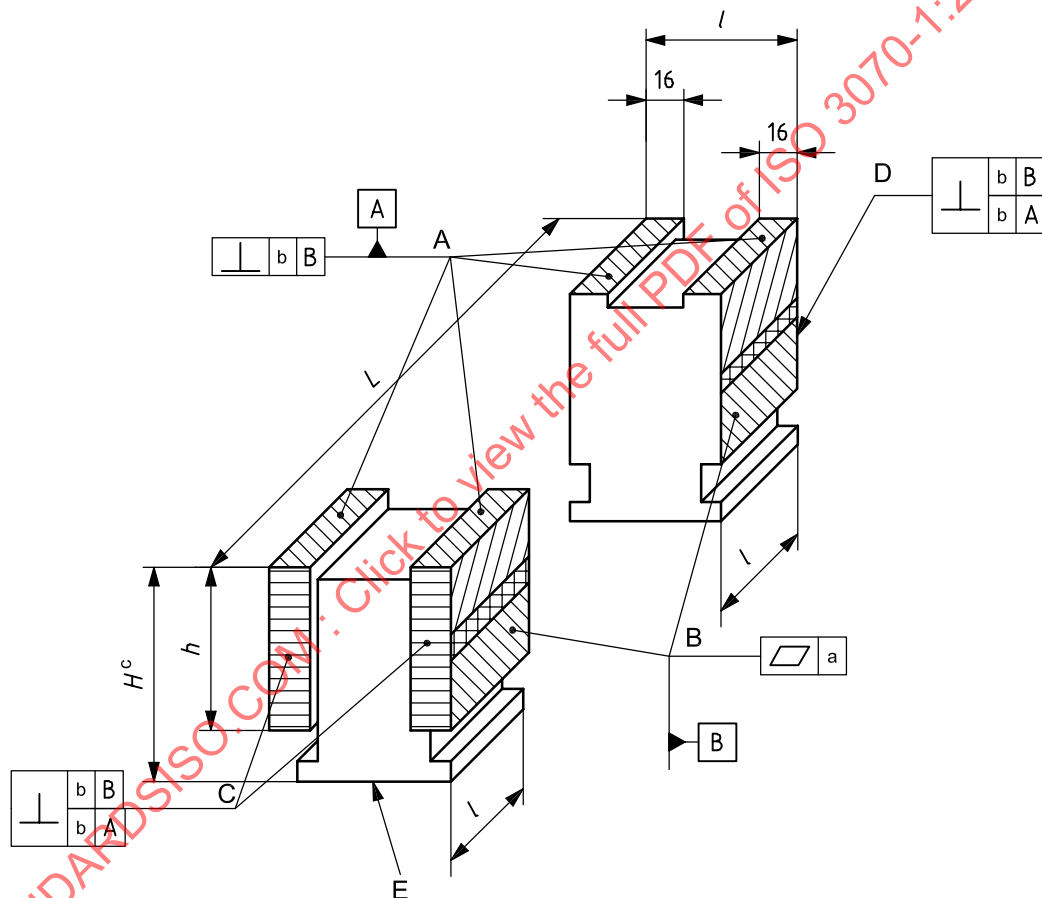
| No.                                                                                        | Check to be made                                                                                                                                                                                                                   | Tolerance                                                                                                                                                                           | Measured deviation | Measuring instruments                                                                             | Observations and references to ISO 230-1:1996                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |
|--------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------|---------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1                                                                                          | CIRCULARITY <sup>a</sup><br>of the internal cylindrical holes, $a_1$ and $a_2$ , and of the external cylindrical surface, $b_1$ (ISO 1101:2004, 18.3):<br>— machined from the sliding spindle;<br>— machined from column movement. | $a_1$ and $a_2$ :<br>$d \leq 125$ : 0,007 5<br>$d > 125$ : 0,01<br>$b_1$ :<br>$D \leq 300$ : 0,01<br>$300 < D \leq 600$ : 0,015<br>For each 300 mm increase in diameter, add 0,005. |                    | Bore gauge and micrometer or measuring instruments having the appropriate measurement uncertainty | 3.1, 3.22, 4.1, 4.2, 5.442, 5.512.42 and 5.6.11.3<br><br>Before commencing the test, ensure that the mounting surface which bears on the table is flat and that the test piece surface which bears on the mounting is square to the axis of its housing.                                                                                                                                                                                                                                                                                                                                                                                                                        |
| 2                                                                                          | CYLINDRICITY <sup>a</sup><br>of the internal cylindrical holes, $a_1$ and $a_2$ (ISO 1101:2004, 18.4)                                                                                                                              | $d \leq 125$ : 0,01<br>$d > 125$ : 0,015                                                                                                                                            |                    |                                                                                                   | <b>DIRECTIONS FOR MACHINING</b><br><br>1) Boring and finishing of the two internal cylindrical holes, $a_1$ and $a_2$ . The table is locked and machining is by axial movement of the sliding boring spindle.<br><br>2) Turning of external cylindrical surface $b_1$ . Short tool mounted on the facing head with movement of the table saddle (Z axis).<br><br>3) Movement of the table saddle (Z axis) of 300 mm and turning of external cylindrical surface $b_2$ . Tool mounted on the facing head with the aid of a support or a tool holder having a suitable length.<br><br>4) Machining of surface $c$ by automatic movement of the radial facing slide or by milling. |
| 3                                                                                          | CONCENTRICITY<br>of the internal cylindrical hole $a_1$ and of the external cylindrical surface $b_1$ (ISO 1101:2004, 18.13).                                                                                                      | 0,025                                                                                                                                                                               |                    | Mandrel and linear displacement sensor                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
| 4                                                                                          | COAXIALITY<br>of the external cylindrical surfaces, $b_1$ and $b_2$ , with the reference axis of the internal cylindrical holes, $a_1$ and $a_2$ (ISO 1101:2004, 18.13)                                                            | 0,04 for a longitudinal movement of the table saddle of 300 mm                                                                                                                      |                    | Mandrel and linear displacement sensor                                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
| 5                                                                                          | FLATNESS<br>of the machined surface (ISO 1101:2004, 18.2)                                                                                                                                                                          | 0,015 for a diameter, $D$ , of 300 mm                                                                                                                                               |                    | Straightedge and gauge blocks                                                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
| 6                                                                                          | SQUARENESS<br>of the machined surface, $c$ , with the reference axis of the internal cylindrical holes, $a_1$ and $a_2$ (ISO 1101:2004, 18.10)                                                                                     | 0,025 for a diameter of 300 mm                                                                                                                                                      |                    | Mandrel and linear displacement sensor or level and special support                               |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |
| <sup>a</sup> Definitions of circularity and cylindricity tolerances are given in ISO 1101. |                                                                                                                                                                                                                                    |                                                                                                                                                                                     |                    |                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |

### Nature of test

## M2

- Milling of strips of surfaces A, C and D by automatic X-axis movement of the table, automatic vertical movement of the spindle head and manual Z-axis movement of the table saddle.
- Milling of surface B by automatic X-axis movement of the table and manual vertical movement of the spindle head at least in two cuts overlapping by about 5 mm to 10 mm.

### Diagram and dimensions of test pieces

$$l = h = 150 \text{ mm for } L \leq 1\,000 \text{ mm}$$
$$l = 200 \text{ mm for } L > 1\,000 \text{ mm}$$


(Length of the test piece or distance between the opposite faces of two test pieces)  $L = \frac{1}{2}$  X-axis travel of the table

Material: cast iron

- a See No. 1, p. 40.  
b See No. 2, p. 40.  
c See No. 3, p. 40.

| No. | Check to be applied                                                                                            | Tolerance                        | Measured deviation | Measuring instruments                                                   | Observations and references to ISO 230-1:1996 |
|-----|----------------------------------------------------------------------------------------------------------------|----------------------------------|--------------------|-------------------------------------------------------------------------|-----------------------------------------------|
| 1   | Surface B on each block shall be flat.                                                                         | 0,02                             |                    | Surface plate, linear displacement sensor, coordinate measuring machine | 3.1, 3.22, 4.1, 4.2, 5.321 and 5.325          |
| 2   | The planes containing the strips of surface A, C, and D shall be perpendicular to each other and to surface B. | 0,02 for measuring length of 100 |                    | Square and gauge blocks, CMM                                            |                                               |
| 3   | The height, $H$ , of the block (or blocks) shall be constant.                                                  | 0,03                             |                    | Height gauge, CMM                                                       |                                               |

### Cutting conditions and cutters

For a), with a shell end mill, mounted at the end of the spindle on a mandrel of a suitable length.

For b), face milling with the same cutter.

The cutter shall be sharpened on its arbor and, when mounted, shall conform to the following tolerances:

- 1) out of round (see ISO 1101)  $\leq 0,01$ ;
- 2) run-out  $\leq 0,02$ ;
- 3) camming  $\leq 0,03$ .

### Procedure

Before beginning the test, make sure that surface E is flat.

Test pieces shall be aligned parallel to the direction of the X-axis movement of the table so that the length,  $L$ , is equally distributed on either side of the table centre.

All non-operating slides shall be locked during cutting.