
International Standard



6442

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Door leaves — Measurement of defects of general flatness

Vantaux de portes — Mesurage des défauts de planéité générale

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Descriptors : doors, measurement, defects, flatness.

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

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

International Standard ISO 6442 was developed by Technical Committee ISO/TC 162, *Doors and windows*, and was circulated to the member bodies in October 1978.

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It has been approved by the member bodies of the following countries :

<u>ISO 6442:1981</u>		
Australia	Germany, F.R.	Norway
Austria	India	Poland
Belgium	Ireland	Portugal
Canada	Italy	Romania
Czechoslovakia	Japan	South Africa, Rep. of
Denmark	Korea, Rep. of	Spain
Finland	Mexico	Sweden
France	Netherlands	United Kingdom

The member body of the following country expressed disapproval of the document on technical grounds :

USA

Door leaves — Measurement of defects of general flatness

1 Scope

This International Standard specifies a method for measuring the defects of general flatness of door leaves.

2 Field of application

This International Standard applies to all doors which are nominally flat and rigid.

3 Definition

For the purpose of the present International Standard, the following definition is applicable.

general flatness : Flatness limited to that of the coincidence of the edges of a face of a door leaf with a reference plane.

4 Principle

The measurement of the defects of general flatness of a door leaf consists in measuring on one face the degree of twist as well as the longitudinal and transversal bending close to the edges.

5 Procedure

The door leaf is mounted vertically so that there is no external restraint.

5.1 Measurement of twist¹⁾

The measurement of twist is carried out on one face of the leaf. Any three corners of this face determine a plane of reference.

Measure the deviation of the fourth corner with respect to this plane (see figure 1).

The measuring points shall not be more than 20 mm from the edges.

5.2 Measurement of bending¹⁾

Carry out the measurement(s) of bending on one of the faces of the door leaf with respect to straight lines parallel to each edge and located 20 mm or less from the edge. Measure the distance of the face to these straight lines (see figure 2).

6 Accuracy of measurement

The twist and bending shall be measured with a maximum uncertainty of $\pm 0,5$ mm.

7 Calculation and expression of results

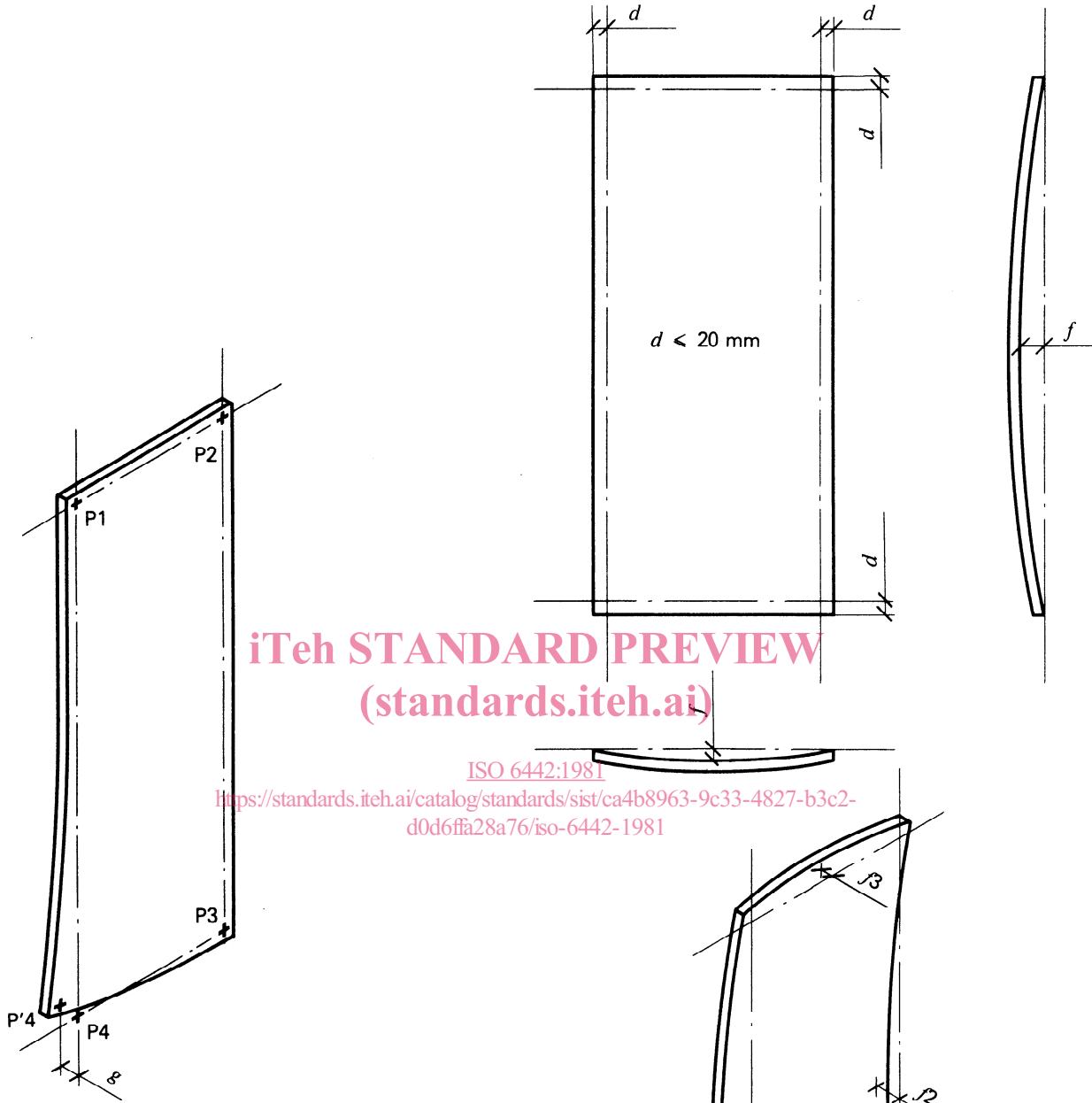
The results shall be expressed to the nearest millimetre, 0,5 mm being rounded down.

8 Test report

The following information and results shall be recorded in the test report :

- relevant details of type, dimensions, form, construction and finish of door leaf, machinings and accessories if they exist;
- measurement of twist;
- measurement of bending;
- all other necessary details.

1) National standards should be consulted as concerns measuring instruments.



The reference plane is defined by the three points P1, P2 and P3. P4 is also situated on this plane. The measurement of the distance P4 — P'4 (g) gives the value of twist.

Figure 1 — Measurement of twist

f_1 , f_2 , f_3 and f_4 are the different measurements of bending.

Figure 2 — Measurement of bending