
INTERNATIONAL STANDARD



2891

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

**Modular units for machine tool construction – Centre bases
and columns**

First edition – 1973-12-01

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 2891 was drawn up by Technical Committee ISO/TC 39, *Machine tools*, and circulated to the Member Bodies in August 1972.

It has been approved by the Member Bodies of the following countries :

Austria	India	Switzerland
Belgium	Ireland	Thailand
Czechoslovakia	New Zealand	Turkey
Egypt, Arab Rep. of	Poland	United Kingdom
France	Romania	U.S.A.
Germany	South Africa, Rep. of	U.S.S.R.
Hungary	Sweden	

The Member Body of the following country expressed disapproval of the document on technical grounds :

Japan

Modular units for machine tool construction – Centre bases and columns

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies certain dimensions relating to the interchangeability of centre bases and columns used in special purpose machines constructed from modular units.

2 DIMENSIONS

2.1 Dimensions for centre bases shall be in accordance with Table 1.

2.2 Dimensions for columns shall be in accordance with Table 2.

3 LOCATION OF CENTRE BASES

As an alternative to the location by means of a tenon and slot, given in this International Standard, location by dowels may be used.

4 CENTRE BASES

Dimensions in millimetres

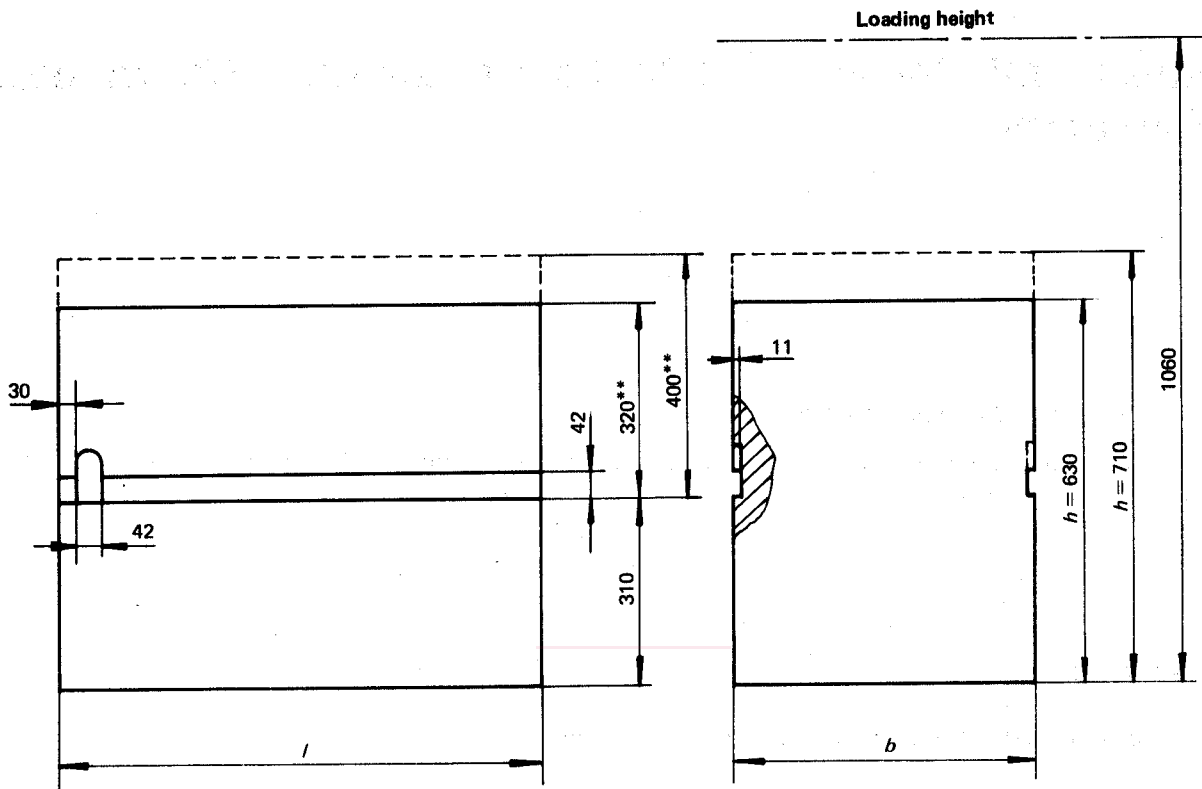


FIGURE 1 – Sketch of a centre base

TABLE 1 – Dimensions of centre bases

Dimensions in millimetres

Length l^*	Breadth b							Height h
	500	560	630	710	800	900	—	
800	—	—	630	710	800	900	—	630 or 710 (alternative)
1 000	—	—	630	710	800	900	1 000	
1 250	—	—	—	710	800	900	1 000	
$l > 1 250$	—	—	—	710	800	900	1 000	

* Where lengths over 1 250 mm are required they shall be chosen from the R 20 series of preferred numbers.

** Alternative values dependent upon overall height.