
**Test conditions for wire electrical-
discharge machines (wire EDM) —
Testing of the accuracy**

*Conditions d'essai des machines d'électroérosion à fil (fil EDM) —
Contrôle de l'exactitude*

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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
Web www.iso.org

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Contents

	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
4 Terminology and designation of axes	2
4.1 Cross-slide table type.....	2
4.2 Double-column type.....	3
5 Preliminary remarks	4
5.1 Measurement units.....	4
5.2 Reference to ISO 230-1.....	4
5.3 Machine levelling.....	4
5.4 Testing sequence.....	4
5.5 Tests to be performed.....	4
5.6 Measuring instruments.....	5
5.7 Diagrams.....	5
5.8 Software compensation.....	5
5.9 Minimum tolerance.....	5
5.10 Positioning tests and reference to ISO 230-2.....	5
5.11 Machining test.....	5
5.12 Circular test and reference to ISO 230-4.....	5
6 Geometric tests	6
6.1 Linear axes of motion.....	6
6.2 Workholding frame.....	10
6.3 Motion of U- and V-axes.....	12
7 Checking of accuracy and repeatability of numerically controlled positioning axes	14
8 Machining test	19
9 Circular test	20
Bibliography	21

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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT), see the following URL: [Foreword — Supplementary information](#).

The committee responsible for this document is ISO/TC 39, *Machine tools*, Subcommittee SC 2, *Test conditions for metal cutting machine tools*.

This second edition cancels and replaces the first edition (ISO 14137:2000), which has been technically revised.

Introduction

The purpose of this International Standard is to standardize methods of testing normal accuracy and general-purpose wire electro-discharge machines (wire EDM).

In this International Standard, the tolerances for G1, G2, G3, G4, P1, P2, P3, P4, and P5 have been changed from those in ISO 14137.

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Test conditions for wire electrical-discharge machines (wire EDM) — Testing of the accuracy

1 Scope

This International Standard specifies, with reference to ISO 230-1, ISO 230-2, and ISO 230-4, geometric tests, tests of accuracy and repeatability of numerically controlled positioning axes, machining test and circular test for general purpose and normal-accuracy wire electro-discharge machines (wire EDM). It also specifies the applicable tolerances, corresponding to the above-mentioned tests.

This International Standard is applicable to cross-slide table type machines and double-column type machines.

This International Standard deals only with the verification of accuracy of the machine. It does not apply to the testing of the machine operation (vibrations, abnormal noises, stick-slip motion of components, etc.) nor to the checking of its characteristics (such as speeds, feeds, etc.), which should generally be checked before the testing of the accuracy.

This International Standard provides the terminology used for the principal components of the machine and the designation of the axes with reference to ISO 841.

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2 Normative references (standards.iteh.ai)

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. 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, *Test code for machine tools — Part 1: Geometric accuracy of machines operating under no-load or quasi-static conditions*

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

ISO 230-4, *Test code for machine tools — Part 4: Circular tests for numerically controlled machine tools*

ISO 841, *Industrial automation systems and integration — Numerical control of machines — Coordinate system and motion nomenclature*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1

electro-discharge machines

machine tools for the removal of material in dielectric fluid by electro-discharges, which are separated in time and randomly distributed in space, between two electrically conductive electrodes (the tool electrode and the workpiece electrode), and where the energy in the discharge is controlled

3.2

wire electro-discharge machines

machine tools for the removal of material by electro-discharge machining through the application of a wire electrode to produce prismatic and more complex shapes in a workpiece

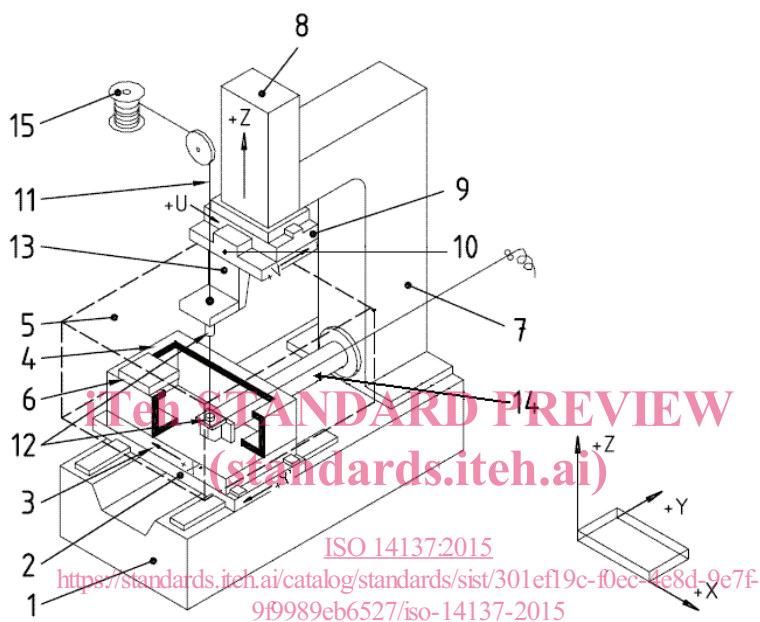
3.3 die sinking electro-discharge machines

machine tools for the removal of material by electro-discharge machining through the application of a tool electrode whose geometry matches (defines) the desired shape of the workpiece feature

4 Terminology and designation of axes

4.1 Cross-slide table type

See [Figure 1](#) and [Table 1](#).



NOTE Key: see [Table 1](#)

Figure 1 — Cross-slide table type machine

Table 1 — Nomenclature for cross-slide table type machine (see [Figure 1](#))

Key	English	French
1	bed	banc
2	saddle (Y-axis)	trainard (axe Y)
3	table (X-axis)	table (axe X)
4	workholding frame	cadre de bridage
5	work tank (cover)	bac de travail
6	workpiece	pièce à usiner
7	column	montant
8	head (Z-axis)	tête (axe Z)
9	U saddle (U-axis)	trainard U (axe U)
10	V saddle (V-axis)	trainard V (axe V)
11	wire electrode	fil électrode
12	wire guide	guide-fil
13	upper guide support	support guide-fil supérieur

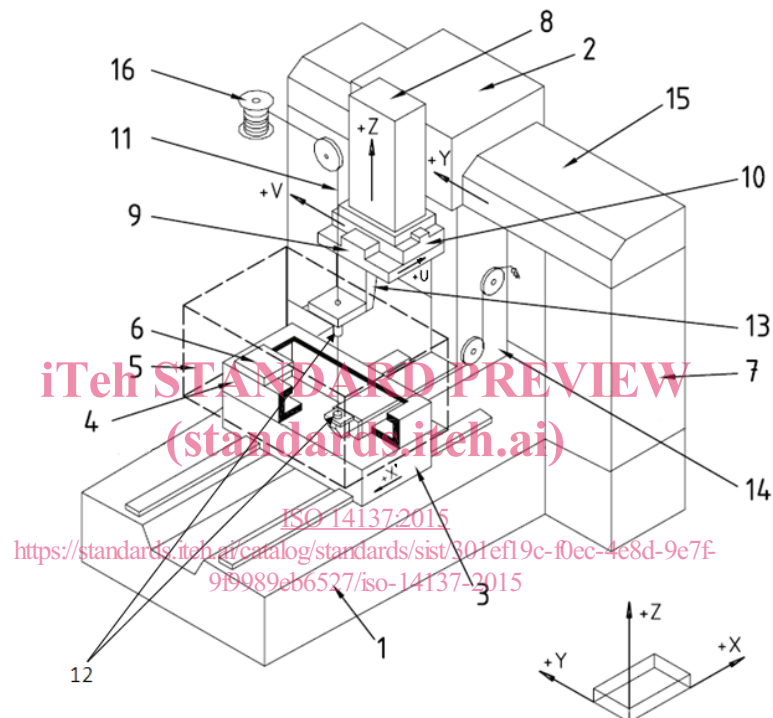
Table 1 (continued)

Key	English	French
14	lower guide support	support guide-fil inférieur
15	wire spool	enrouleur de fil

4.2 Double-column type

See [Figure 2](#) and [Table 2](#).

NOTE The machine axis designations in Figure 2 comply with ISO 841. However, X- and Y-axis designations may be interchanged to suit axes lengths and/or operator position.



NOTE Key: see [Table 2](#)

Figure 2 — Double-column type machine

Table 2 — Nomenclature for double-column type machine (see [Figure 2](#))

Key	English	French
1	bed	banc
2	saddle (Y-axis)	trainard (axe Y)
3	table (X-axis)	table (axe X)
4	workholding frame	cadre de bridage
5	work tank (cover)	bac de travail
6	workpiece	pièce à usiner
7	column	montant
8	head (Z-axis)	tête (axe Z)
9	U saddle (U-axis)	trainard U (axe U)
10	V saddle (V-axis)	trainard V (axe V)

Table 2 (continued)

Key	English	French
11	wire electrode	fil électrode
12	wire guide	guide-fil
13	upper guide support	support guide-fil supérieur
14	lower guide support	support guide-fil inférieur
15	cross beam	traverse
16	wire spool	enrouleur de fil

5 Preliminary remarks

5.1 Measurement units

In this International Standard, 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 primarily in ratios, but in some cases microradians or arcseconds may be used for clarification purposes. The following expression should be used for conversion of angular deviations or tolerances:

$$0,010/1\ 000 = 10 \times 10^{-6} = 10 \mu\text{rad} \cong 2'' \quad (1)$$

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5.2 Reference to ISO 230-1 (standards.iteh.ai)

For application of this International Standard, reference shall be made to ISO 230-1, especially for the installation of the machine before testing, warming up of the moving parts, the description of measuring methods and recommended accuracy of testing equipment.

In the "Observations" block of the tests described in [Clause 6](#), [Clause 7](#), [Clause 8](#), and [Clause 9](#), the instructions are preceded by a reference to the corresponding clause/subclause in ISO 230-1, in cases where the test concerned is in compliance with the specifications of ISO 230-1. Tolerances are given for each geometric test (see G1 to G8).

5.3 Machine levelling

Prior to conducting tests on a machine, the machine should be levelled according to the recommendations of the manufacturer/supplier (see ISO 230-1:2012, 6.1.2).

5.4 Testing sequence

The sequence in which the geometric tests are given 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.

5.5 Tests to be performed

When testing a machine, it is not always necessary or possible to carry out all the tests given in this standard. When the tests are required for acceptance purposes, the choice of tests relating to the components and/or the properties of the machine of interest is at the discretion of the user, in agreement with the manufacturer/supplier. The tests to be used are to be clearly stated when ordering a machine. A mere reference to this International Standard for the acceptance tests, without specifying the tests to be carried out and without agreement on the relevant expenses, cannot be considered as binding for any contracting parties.

5.6 Measuring instruments

The measuring instruments indicated in the tests described in the following clauses are examples only. Other instruments measuring the same quantities and having the same or smaller measurement uncertainty may be used. Linear displacement sensors shall have a resolution of 0,001 mm or better.

5.7 Diagrams

For reasons of simplification, the figures in [Clause 6](#), [Clause 7](#), [Clause 8](#), and [Clause 9](#) of this International Standard illustrate some types of machines.

5.8 Software compensation

When built-in software facilities are available for compensating geometric, positioning contouring and/or thermal deviations, their use during these tests shall be based on agreement between the manufacturer/supplier and user, with due consideration to the machine tool intended use.

When the software compensation is used, this shall be stated in the test reports.

It shall be noted that when software compensation is used, axes shall not be locked for test purposes.

5.9 Minimum tolerance

When the tolerance for a geometric test is established for a measuring length different from that given in this standard, the tolerance may be determined by means of the law of proportionality (see ISO 230-1:2012, 4.1.2). It shall be taken into consideration that the minimum value of tolerance is 0,005 mm.

5.10 Positioning tests and reference to ISO 230-2

Tests P1 to P5 are applied only to numerically controlled electro-discharge machines.

To apply these tests, reference shall be made to ISO 230-2, especially for the environmental conditions, warming up of the machine, measuring methods, evaluation and interpretation of the results.

When other numerically controlled axes exist, tests shall be agreed between the user and the manufacturer/supplier.

5.11 Machining test

Concerning the machining test, only simple machining of a cylindrical hole is proposed. Machining test of other suitable form is also possible under the agreement between the user and the manufacturer/supplier.

Machining test shall be made under finishing conditions.

The machining test may be substituted by circular test C1.

5.12 Circular test and reference to ISO 230-4

To apply this test, reference shall be made to ISO 230-4:2005, especially to Clauses 4 and 6 for the test conditions and presentation of results.

The circular test may be substituted by machining test M1.