
**Metallic materials — Brinell
hardness test —**

**Part 2:
Verification and calibration of testing
machines**

Matériaux métalliques — Essai de dureté Brinell —

Partie 2: Vérification et étalonnage des machines d'essai

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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 voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 164, *Mechanical testing of metals*, Subcommittee SC 3, *Hardness testing*.

This fourth edition cancels and replaces the third edition (ISO 6506-2:2014), which has been technically revised.

The main changes compared to the previous edition are as follows:

- [Clause 3](#) has been added;
- [Table 3](#) has been modified.

A list of all parts in the ISO 6506 series can be found on the ISO website.

Metallic materials — Brinell hardness test —

Part 2: Verification and calibration of testing machines

1 Scope

This document specifies methods of direct and indirect verification of testing machines used for determining Brinell hardness in accordance with ISO 6506-1 and also specifies when these two types of verification have to be performed.

The direct verification involves checking that individual machine performance parameters fall within specified limits whereas the indirect verification utilizes hardness measurements of reference blocks, calibrated in accordance with ISO 6506-3, to check the machine's overall performance.

If a testing machine is also to be used for other methods of hardness testing, it has to be verified independently for each method.

This document is applicable to both fixed location and portable hardness testing machines. For machines that are incapable of satisfying the specified force-time profile, the direct verification of force and testing cycle can be modified by the use of [Annex B](#).

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 376, *Metallic materials — Calibration of force-proving instruments used for the verification of uniaxial testing machines*

ISO 6506-1:2014, *Metallic materials — Brinell hardness test — Part 1: Test method*

ISO 6506-3, *Metallic materials — Brinell hardness test — Part 3: Calibration of reference blocks*

ISO 6507-1, *Metallic materials — Vickers hardness test — Part 1: Test method*

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <https://www.iso.org/obp>

4 General conditions

Before a Brinell hardness testing machine is verified, the machine shall be checked to ensure that it is properly set up in accordance with the manufacturer's instructions.

Especially, it should be checked that:

- a) the mount holding the ball-holder slides correctly in its guide;
- b) every ball-holder with a ball used during the calibration is firmly held in the mount;
- c) the test force is applied and removed without shock, vibration, or overrun and in such a manner that the readings are not influenced; and
- d) if the indentation diameter measuring system is integrated into the machine,
 - the change from removing the test force to measuring mode does not influence the diameter measurements,
 - the illumination does not affect the diameter measurements, and
 - the centre of the indentation is in the centre of the field of view, if necessary.

5 Direct verification

5.1 General

5.1.1 Direct verification should be carried out at a temperature of (23 ± 5) °C. If the verification is made outside this temperature range, this shall be reported in the verification report.

5.1.2 The instruments used for verification shall be traceable to the SI.

5.1.3 Direct verification involves:

- a) measurement of the test forces;
- b) measurement of the diameter, hardness, and density of the indenter ball;
- c) calibration of the indentation diameter measuring system; and
- d) measurement of the testing cycle.

For each of the above items, direct verification also includes assessment of the results against the specified tolerances.

5.2 Measurement of the test forces

5.2.1 Each test force shall be measured within the working range of the testing machine. When the force is applied in open-loop mode by a lever or other system employing a mechanical advantage, this shall be done at no fewer than three positions of the indenter uniformly spaced throughout its range of movement during testing.

5.2.2 Three measurements shall be made for each force at each position of the indenter. Immediately before each measurement is taken, the indenter shall be moved in the same direction as during testing.

5.2.3 The force shall be measured by one of the following two methods:

- by means of a force-proving instrument in accordance with ISO 376 Class 1 or better;
- by balancing against a force, accurate to $\pm 0,2$ %, applied by means of calibrated masses or another method with the same accuracy.

5.2.4 Each measurement of a force shall be within $\pm 1,0$ % of the nominal test force [see [Formula \(A.2\)](#)], as defined in ISO 6506-1.

5.3 Measurement of the properties of the indenter ball

5.3.1 The indenter consists of a ball and an indenter holder. The verification applies only to the ball.

5.3.2 For the purpose of verifying the size and the hardness of the balls, a minimum of two balls, selected at random from a batch, shall be tested. Each sampled ball shall be verified for size and hardness and then discarded.

5.3.3 The balls shall be polished and free from surface defects.

5.3.4 The user shall either measure the balls to ensure that they meet the following requirements or shall obtain balls from a supplier certifying that the following conditions are met.

5.3.4.1 The diameter shall be determined by taking the mean value of not less than three single values of diameter measured at different positions on the ball. No single value shall differ from the nominal diameter by more than the tolerance given in [Table 1](#).

Table 1 — Tolerances for the different ball diameters

Ball diameter mm	Tolerance mm
10	$\pm 0,005$
5	$\pm 0,004$
2,5	$\pm 0,003$
1	$\pm 0,003$

5.3.4.2 The characteristics of the tungsten carbide composite balls shall be as follows.

- Hardness: The hardness shall be not less than 1 500 HV, when determined in accordance with ISO 6507-1. The tungsten carbide composite ball can be tested directly on its spherical surface or by sectioning the ball and testing on the ball interior.
- Density: $\rho = (14,8 \pm 0,2) \text{ g/cm}^3$.

The density can be determined from the sampled balls, prior to hardness testing, or from the whole batch. The following chemical composition is recommended:

- tungsten carbide (WC): balance;
- total other carbides: 2,0 %;
- cobalt (Co): 5,0 % to 7,0 %.

5.4 Calibration of the indentation diameter measuring system

5.4.1 For systems where the indentation diameter is measured directly, the scale of the system shall be graduated to permit estimation of the diameter to within $\pm 0,5$ %. The indentation diameter measuring system shall be calibrated for every objective lens and for each incorporated line scale, in two perpendicular measurement axes (if applicable), by measurements made on a standard scale at a minimum of four intervals, arranged centrally in the field of view, for each working range. For each measurement, the magnitude of the difference between the measured and reference values shall not be greater than 0,5 % [see [Formula \(A.4\)](#)].

5.4.2 For systems where the indentation diameter is calculated from a measurement of projected area, the system shall be calibrated for every objective lens by measurements of a range of at least four standard circular reference images covering the range of areas measured. The maximum error shall not exceed 1 % of the area.

5.4.3 All systems shall also be verified by making measurements of certified reference indentations, such as those on hardness reference blocks calibrated in accordance with ISO 6506-3. For each ball size, at least four indentations, covering the working range of diameters, shall be measured by each objective lens. During these measurements, the type of illumination shall remain unchanged. No mean measured diameter shall differ from the certified mean diameter of the reference indentation by more than 0,5 %.

5.5 Verification of the testing cycle

5.5.1 The testing cycle is to be verified by the testing machine manufacturer at the time of manufacture and when the testing machine undergoes repair which might have affected the testing cycle. Verification of the testing cycle at other times is as specified in [Table 4](#).

5.5.2 The testing cycle shall be verified to conform with the testing cycle defined in ISO 6506-1, taking into account any uncertainty associated with the timing measurements.

6 Indirect verification

6.1 Indirect verification should be carried out at a temperature of $(23 \pm 5) ^\circ\text{C}$ by means of reference blocks calibrated in accordance with ISO 6506-3. If the verification is made outside of this temperature range, this shall be reported in the verification report.

The test and bottom surfaces of the reference blocks and the surfaces of indenters shall not contain any additives or corrosion products.

6.2 The testing machine shall be verified for each test force and for each size of ball used. For each test force, at least two reference blocks shall be selected from the hardness ranges specified in [Table 2](#) (for $0,102 \times F/D^2 = 30$) and [Table 3](#) (for other force-diameter indices).

The two reference blocks shall be taken from different hardness ranges, if possible.

6.3 If this indirect verification is not the one immediately following a direct verification, the reference indentation on each reference block shall be measured, with the same type of illumination that was used during the machine's previous direct verification. For each indentation, the difference between the mean measured value and the certified mean diameter shall not exceed 0,5 %. If preferred, this check can instead be made on a similarly sized indentation in a separate reference block.

6.4 On each reference block, five indentations shall be uniformly distributed over the test surface and measured. The test shall be made in accordance with ISO 6506-1.

6.5 For each reference block, let d_1, d_2, d_3, d_4 , and d_5 be the mean values of the measured diameters of the indentations, arranged in increasing order of magnitude, and \bar{d} is calculated using [Formula \(1\)](#):

$$\bar{d} = \frac{d_1 + d_2 + d_3 + d_4 + d_5}{5} \quad (1)$$

6.6 The repeatability, r , of the testing machine under the particular verification conditions is calculated as shown in [Formula \(2\)](#):

$$r = d_5 - d_1 \quad (2)$$

The repeatability, r_{rel} , expressed as a percentage of \bar{d} , is calculated as shown in [Formula \(3\)](#):

$$r_{\text{rel}} = 100 \times \frac{d_5 - d_1}{\bar{d}} \quad (3)$$

6.7 The repeatability of the testing machine is satisfactory when r_{rel} does not exceed the values specified in [Table 2](#) or [Table 3](#).

6.8 For each reference block, let H_1, H_2, H_3, H_4 , and H_5 be the hardness values corresponding to the five indentations, with the mean hardness, \bar{H} , being given by [Formula \(4\)](#):

$$\bar{H} = \frac{H_1 + H_2 + H_3 + H_4 + H_5}{5} \quad (4)$$

6.9 The error, E , of the testing machine under the particular verification conditions is calculated using [Formula \(5\)](#):

$$E = \bar{H} - H_C \quad (5)$$

where

H_C is the certified hardness of the reference block.

The relative error, E_{rel} , is calculated, as a percentage of H_C , using [Formula \(6\)](#):

$$E_{\text{rel}} = 100 \times \frac{\bar{H} - H_C}{H_C} \quad (6)$$

The error of the testing machine, expressed as a percentage of the certified hardness of the reference block, shall not exceed the values given in [Table 2](#) and [Table 3](#).

Table 2 — Repeatability and error of the testing machine for force-diameter index = 30

Hardness range	Hardness	Permissible repeatability, r_{rel} , of the testing machine %	Permissible error, E_{rel} , of the testing machine %
1	$H_C < 250$ HBW	3,0	$\pm 3,0$
2	H_C from 250 HBW to 450 HBW	2,5	$\pm 2,5$
3	$H_C > 450$ HBW	2,0	$\pm 2,0$

Table 3 — Repeatability and error of the testing machine for other force-diameter indices

Hardness range	$0,102 \times F/D^2$				Permissible repeatability, r_{rel} , of the testing machine %	Permissible error, E_{rel} , of the testing machine %
	15	10	5	$\leq 2,5$		
1	$H_C < 100$ HBW	$H_C < 100$ HBW	$H_C < 70$ HBW	$H_C < 70$ HBW	3,0	$\pm 3,0$
2	H_C from 100 HBW to 250 HBW	H_C from 100 HBW to 200 HBW	H_C from 70 HBW to 100 HBW	N/A	3,0	$\pm 3,0$
3	$H_C > 250$ HBW	$H_C > 200$ HBW	$H_C > 100$ HBW	N/A	3,0	$\pm 3,0$

6.10 The determination of the uncertainty of measurement of the calibration results of the hardness testing machine is given in [Annex A](#).

7 Intervals between verifications

The specifications for the direct verifications are given in [Table 4](#).

Indirect verification shall be performed at least once every 12 months and after a direct verification has been performed.

Table 4 — Direct verifications of hardness testing machines

Requirements of verification	Force	Indentation diameter measuring system	Test cycle	Indenter ^a
Before setting to work first time	x	x	x	x
After dismantling and reassembling, if force, indentation diameter measuring system or test cycle is affected	x	x	x	
Failure of indirect verification ^b	x	x	x	
Indirect verification > 13 months ago	x	x	x	

^a In addition, it is recommended that the indenter be directly verified or replaced after 2 years of use.

^b Direct verification of these parameters can be carried out sequentially (until the machine passes indirect verification) and is not required if it can be demonstrated (e.g. by tests with a replacement indenter) that the indenter was the cause of the failure.

8 Verification report/calibration certificate

The verification report/calibration certificate shall include the following information:

- a reference to this document, i.e. ISO 6506-2;
- the method of verification (direct and/or indirect);
- the identification data for the hardness testing machine;
- the means of verification (reference blocks, elastic proving devices, etc.);
- the diameter of the ball indenter and test force;
- the verification temperature;
- the result obtained;