
International Standard



2433

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

Acceptance conditions for external cylindrical grinding machines with a movable table — Testing of accuracy

Conditions de réception des machines à rectifier les surfaces de révolution extérieures à table mobile — Contrôle de la précision

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Descriptors : machine tools, grinding machines (tools), tests, testing conditions, dimensional measurement, accuracy.

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. Every 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.

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. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 2433 was prepared by Technical Committee ISO/TC 39, *Machine tools*.

ISO 2433 was first published in 1973. This second edition cancels and replaces the first, of which it constitutes a minor technical revision. standards.iteh.ai/catalog/standards/sist/4cec77a0-98ef-47a6-853a-deaf55a077a2/iso-2433-1984

Acceptance conditions for external cylindrical grinding machines with a movable table – Testing of accuracy

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1 SCOPE AND FIELD OF APPLICATION

This International Standard describes, with reference to ISO/R 230, both geometrical and practical tests on general purpose and normal accuracy external cylindrical grinding machines with a movable table¹⁾ of which the swing diameter does not exceed 800 mm (32 in) and the distance between centres, 4 000 mm (160 in), and also gives the corresponding permissible deviations which apply.

It deals only with the verification of accuracy of the machine. It does not apply to testing the running of the machine (vibrations, abnormal noises, stick-slip motion of components, etc.), or to its characteristics (speeds, feeds, etc.) which should generally be checked before testing accuracy.

2 PRELIMINARY REMARKS

2.1 In this International Standard, all the dimensions are expressed in millimetres and in inches.

2.2 To apply this International Standard, reference should be made to ISO/R 230, especially for the installation of the machine before testing, warming up of spindles and other moving parts, description of measuring methods and recommended accuracy of testing equipment.

2.3 The sequence in which the geometrical tests are given is related to the sub-assemblies of the machine, and this in no way defines the practical order of testing. In order to make the mounting of instruments or gauging easier, tests may be carried out in any order.

2.4 When inspecting a machine, it is not always necessary to carry out all the tests described in this International Standard. It is up to the user to choose, in agreement with the manufacturer, those relating to the properties which are of interest to him, but these tests are to be clearly stated when ordering a machine.

2.5 Practical tests shall be made with finishing cuts and not with roughing cuts which are liable to generate appreciable cutting forces.

2.6 When the tolerance is established for a measuring range different from that given in this International Standard (see 2.311 in ISO/R 230), it should be taken into consideration that the minimum value of tolerance is 0.001 mm (0.000 04 in).

3 REFERENCE

ISO/R 230, *Machine tool test code*.

1) This International Standard does not apply to machines having a fixed table and a movable wheelhead.

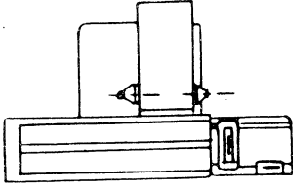
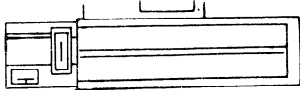
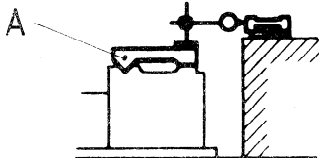
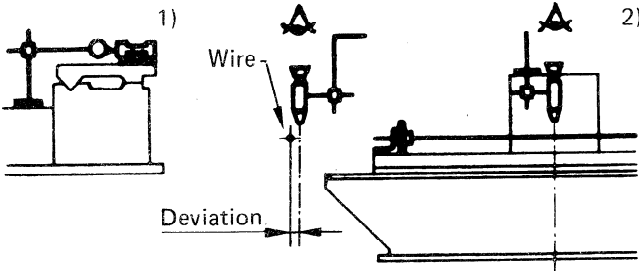
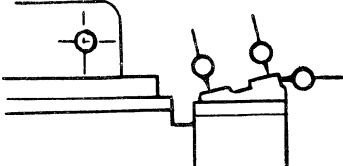
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4 ACCEPTANCE CONDITIONS AND PERMISSIBLE DEVIATIONS

4.1 Geometrical tests

No.	Diagram	Object	
G 1a		<p>A – BED</p> <p>Levelling of the slideways</p> <p>a) Longitudinal inspection :</p> <p>Straightness of the slideways in the vertical plane;</p>	<p>For each add</p> <p>Maximum</p> <p>Local to</p> <p>over any</p>
G 1b		<p>b) Transverse inspection :</p> <p>Parallelism of the slideways in the vertical plane.</p>	<p>Var</p> <p>DC</p> <p>DC</p>
G 2	<p style="text-align: center;">ISO 2433:1984 https://standards.iteh.ai/catalog/standards/sist/4cec77a0-98ef-47a6-853a-deaf55a077a2/iso-2433-1984</p> 	<p>Checking of straightness of the slideways in a horizontal plane.</p>	<p>For each add:</p> <p>Maximum</p> <p>Local to</p> <p>over any</p>
	<p style="text-align: center;">Alternatives</p> 	<p>(These alternatives are for small machines where the table is not to be dismantled.)</p> <p>Checking of straightness of the longitudinal movement of the table in the horizontal plane.</p>	<p>For each add:</p> <p>Maximum</p>
G 3		<p>Checking of parallelism of the location surfaces for the workhead and tailstock to the longitudinal movement of the table (in the case of movable tables).</p>	<p>For each add:</p> <p>Maximum</p> <p>Local to</p> <p>over any</p>

* DC = distance between centres.

Permissible deviation		Measuring instruments	Observations and references to the test code ISO/R 230
mm	in		
0,02 up to 1000 1000 increase in length, 0,015 n permissible deviation: 0,05 erance: 0,005 length of 250	0.0008 up to 40 For each 40 increase in length, add 0.0006 Maximum permissible deviation: 0.002 Local tolerance: 0.0002 over any length of 10	Precision level, optical or other methods	a) Clauses 3.11, 3.21, 5.212.21 and 5.212.22 Measurements shall be made at a number of positions equally spaced along the length of the bed. For machines standing on three support points or having a distance between centres less than 1 000 mm (40 in) the table need not be removed. In this case the level shall be placed suc- cessively on the exposed portions of the slideways and on the table. The table should be in its central posi- tion.
iation of level : * ≤ 500 : 0,02/1000 * > 500 : 0,04/1000	Variation of level : DC * ≤ 20 : 0.0008/40 DC * > 20 : 0.0016/40	Precision level	b) Clause 5.412.7 A level shall be placed transversely on the slideways, and measurements shall be taken at a number of positions equally spaced along the length of the bed. The variation of level measured at any posi- tion shall not exceed the permissible devi- ation.
0,02 up to 1000 1000 increase in length, 0,02 n permissible deviation: 0,05 erance 0,006 length of 300	0.0008 up to 40 For each 40 increase in length, add: 0.0008 Maximum permissible deviation: 0.002 Local tolerance 0.00024 over any length of 12	ISO 2433:1984 https://standards.iteh.ai/catalog/standards/sist/4cec77a0-98ef-47a6-853a-deaf55a077a2/iso-2433-1984	Clause 5.232.1 The dial gauge shall be fixed on a support A of a suitable form such that it can slide in the slideways with the stylus touching a straightedge laid parallel to the slide- ways.
0,01 up to 1000 1000 increase in length, 0,01 m permissible deviation: 0,025	0.0004 up to 40 For each 40 increase in length, add: 0.0004 Maximum permissible deviation: 0.001		Clauses 5.232.1 or 5.232.2 For Alternative 1) the dial gauge support shall be placed on a fixed part of the machine, the stylus shall touch a straight- edge laid parallel to the general direc- tion of the longitudinal movement of the table.
0,01 up to 1000 1000 increase in length, 0,01 m permissible deviation: 0,03 erance: 0,003 length of 300	0.0004 up to 40 For each 40 increase in length, add: 0.0004 Maximum permissible deviation: 0.0012 Local tolerance: 0.00012 over any length of 12	Dial gauge(s)	Clause 5.422.22 Place a dial gauge (s) on a fixed part of the machine and take measurements suc- cessively on the location surfaces for the workhead and the tailstock. The table setting carried out during this test shall not be modified for performing tests G 6, G 7 and G 8.

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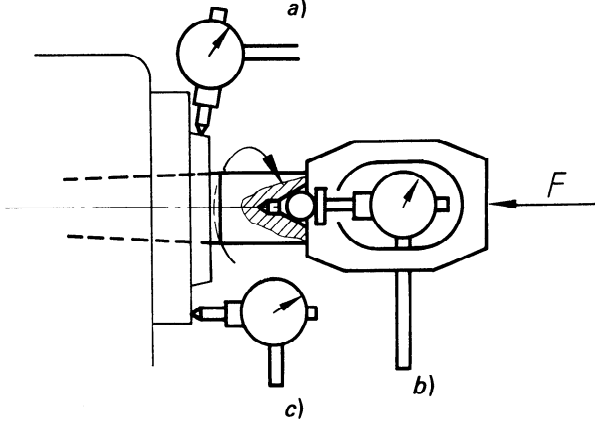
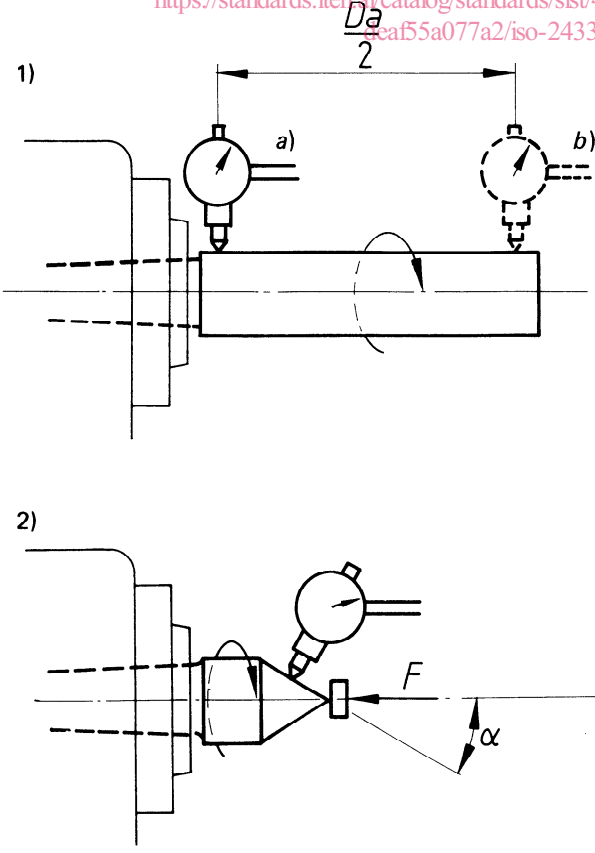
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No.	Diagram	Object	
G 4		<p align="center">B – WORKHEAD</p> <p>(Tests G 4 and G 5 apply only to machines having a rotating spindle.)</p> <p>a) Measurement of run-out of the external register diameter of the spindle;</p> <p>b) Measurement of periodic axial slip of the spindle;</p> <p>c) Measurement of camming of the register face of the spindle (including periodic axial slip).</p>	<p>a)</p> <p>b)</p> <p>c)</p>
G 5		<p>1) Measurement of run-out of the axis of the work spindle taper :</p> <p>a) at the outlet of the housing;</p> <p>b) at a distance from the outlet equal to $\frac{Da^*}{2}$ or not more than 300 mm (12 in).</p> <p>2) Measurement of run-out of the work spindle centre nose.</p>	<p>1)</p> <p>a)</p> <p>b)</p> <p>2)</p>

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* Da = Maximum diameter admissible for grinding.

Permissible deviation		Measuring instruments	Observations and references to the test code ISO/R 230
mm	in		
0,005	a) 0.0002	Dial gauge	a) Clause 5.612.2 In the case of a tapered spindle nose the stylus of the dial gauge shall be set normal to the surface which is to be checked.
0,005	b) 0.0002		b) and c) Clauses 5.62, 5.621.2, 5.622.1, 5.622.2 and 5.632 For the dial gauge position, see Figures 59 to 64 and 67, clauses 5.62, 5.622 and 5.632.
0,01	c) 0.0004		The value of force F to be applied for the tests a), b) and c) shall be specified by the manufacturer.
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0,005	1) a) 0.0002	Dial gauge and test mandrel	Clause 5.612.3
0,015 or a measuring length of 300	b) 0.0006 for a measuring length of 12		
0,005	2) 0.0002	Dial gauge	Clause 5.612.2 The dial gauge being set normal to the taper surface of the head centre, and tolerance being given in a plane perpendicular to the spindle axis, the readings observed shall therefore be divided by $\cos \alpha$, α being the semi-cone angle of the taper. The value of force F to be applied shall be specified by the manufacturer.

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