
**Hand-held portable power tools —
Test methods for evaluation of
vibration emission —**

**Part 1:
Angle and vertical grinders**

*Machines à moteur portatives — Méthodes d'essai pour l'évaluation
de l'émission de vibrations —*

Partie 1: Meuleuses verticales et meuleuses d'angles

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Contents

Page

Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	1
3.1 Terms and definitions	2
3.2 Symbols	2
4 Basic standards and vibration test codes	2
5 Description of the family of machines	3
6 Characterization of vibration	5
6.1 Direction of measurement	5
6.2 Location of measurements	5
6.3 Magnitude of vibration	8
6.4 Combination of vibration directions	8
7 Instrumentation requirements	8
7.1 General	8
7.2 Mounting of transducers	8
7.2.1 Specification of transducer	8
7.2.2 Fastening of transducers	8
7.3 Frequency weighting filter	9
7.4 Integration time	9
7.5 Auxiliary equipment	9
7.6 Calibration	9
8 Testing and operating conditions of the machinery	9
8.1 General	9
8.2 Operating conditions	10
8.2.1 Pneumatic machines	10
8.2.2 Hydraulic machines	10
8.2.3 Electrical machines	10
8.3 Other quantities to be specified	10
8.4 Attached equipment, work piece and task	10
8.4.1 Test wheel	10
8.4.2 Feed force	11
8.4.3 Test procedure	13
8.5 Operators	13
9 Measurement procedure and validity	13
9.1 Reported vibration values	13
9.2 Declaration and verification of the vibration emission value	14
9.3 Correction factor	14
10 Measurement report	15
Annex A (informative) Model test report for vibration emission of angle and vertical grinders	16
Annex B (normative) Determination of uncertainty	18
Annex C (normative) Design of test wheel	20
Bibliography	28

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).

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For an explanation of 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 www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 118, *Compressors and pneumatic tools, machines and equipment*, Subcommittee SC 3, *Pneumatic tools and machines*.

This second edition cancels and replaces the first edition (ISO 28927-1:2009) and (ISO 28927-1:2009/Amd.1:2017), of which it constitutes a minor revision. The changes compared to the previous edition are as follows:

- [Table C.4](#), in "Radius to centre of hole", change rh to r_h ;
- [Table C.4](#), in "Radius to centre of threaded hole", change rt to r_t ;
- [Figure C.4](#), change r_s to r_t ;
- [Figure C.4](#), change r_t to r_h ;
- [Figure C.4](#), in the key, change r_s to r_h .

A list of all parts in the ISO 28927 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at www.iso.org/members.html.

Introduction

This document is a type-C standard as stated in ISO 12100.

When requirements of this type-C standard are different from those which are stated in type-A or -B standards, the requirements of this type-C standard take precedence over the requirements of the other standards for machines that have been designed and built according to the requirements of this type-C standard.

The vibration test codes for portable hand-held machines given in ISO 28927 are based on ISO 20643, which gives general specifications for the measurement of the vibration emission of hand-held and hand-guided machinery. ISO 28927 specifies the operation of the machines under type-test conditions and other requirements for the performance of type tests. The structure/numbering of its clauses follows that of ISO 20643.

The basic principle for transducer positioning first introduced in the EN 60745 series of European standards is followed, representing a deviation from ISO 20643 for reasons of consistency. The transducers are primarily positioned next to the hand in the area between the thumb and the index finger, where they give the least disturbance to the operator gripping the machine.

It has been found that vibrations generated by grinders vary considerably in typical use. This is largely due to the variances in the unbalance of the machine with the grinding wheel mounted. The unbalance also changes when the wheel is worn through operation.

In order to provide a method that gives good measurement reproducibility, the procedure adopted in this document uses a test wheel of known unbalance mounted on a machine and run under no-load conditions. The unbalance for the different types of test wheel are chosen to give vibration values that are as far as possible in accordance with ISO 20643. The procedures of ISO 5349 are required whenever exposure at the workplace is to be assessed.

Underestimation of the vibration for machines equipped with technical means to automatically reduce unbalances is taken into account by multiplying the vibration values of such machines with a correction factor of 1,3.

For grinders that are intended to be used with cupped wire brushes, the vibration value is obtained by using a correction factor of 1,6.

The values obtained are type-test values intended to be representative of the average of the upper quartile of typical vibration magnitudes in real-world use of the machines. However, the actual magnitudes will vary considerably from time to time and depend on many factors, including the operator, the task and the inserted tool or consumable. The state of maintenance of the machine itself might also be of importance. Under real working conditions the influences of the operator and process can be particularly important at low magnitudes. It is therefore not recommended that emission values below $2,5 \text{ m/s}^2$ be used for estimating the vibration magnitude under real working conditions. In such cases, $2,5 \text{ m/s}^2$ is the recommended vibration magnitude for estimating the machine vibration.

If accurate values for a specific work place are required, then measurements (according to ISO 5349) in that work situation could be necessary. Vibration values measured in real working conditions can be either higher or lower than the values obtained using this document.

Higher vibration magnitudes can easily occur in real work situations, caused by the use of excessively unbalanced grinding wheels, worn flanges or bent spindles.

The vibration test codes given in ISO 28927 supersede those given in ISO 8662, whose parts have been replaced by the corresponding parts of ISO 28927 (see Foreword).

NOTE ISO 8662-11, *Hand-held portable power tools — Measurement of vibrations at the handle — Part 11: Fastener driving tools* could be replaced by a future part of ISO 28927.