
Test conditions for horizontal internal type broaching machines — Testing of accuracy

*Conditions de réception des machines horizontales à brocher les
intérieurs — Contrôle de l'exactitude*

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Foreword

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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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This document was prepared by Technical Committee ISO/TC 39, *Machine tools*, Subcommittee SC 2, *Test conditions for metal cutting machine tools*.

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.

This third edition cancels and replaces the second edition (ISO 6480:1983), which has been technically revised. The main changes compared to the previous edition are as follows:

- the title has been changed;
- the document's format has been aligned with new published ISO/TC 39/SC 2 documents;
- some terms have been changed and equivalent non-formal terms in more languages have been added to [Annex A](#);
- terms and definitions related to this machine and its process have been added in [Clause 3](#);
- all diagrams have been regenerated;
- old references to ISO/R 230:1961 have been changed to ISO 230-1:2012;
- levelling test, G01, has been deleted and relevant explanations have been added to [Clause 5](#);
- sections a) and b) of test items G1 have been merged; consequently, only single tolerance is applied;
- as the term “coincidence” is no longer existing in ISO 230-1:2012, the term “radial offset of coaxiality deviation” has been used for test item G5;
- [Clause 7](#) has been created to provide considerations machining tests to be agreed between manufacturer/supplier and user;
- imperial units of measurements have been deleted and only metric units are now used.