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(JMTBA/JSA)

**Machine tools—Test conditions for
surface grinding machines with vertical
grinding wheel spindle and reciprocating
table—Testing of the accuracy**

Foreword

This translation has been made based on the original Japanese Industrial Standard established by the Minister of Economy, Trade and Industry through deliberations at the Japanese Industrial Standards Committee, according to the proposal of establishing a Japanese Industrial Standard from Japan Machine Tool Builders' Association (JMTBA)/Japanese Standards Association (JSA), with the draft of Industrial Standard based on the provision of Article 12 Clause 1 of the Industrial Standardization Law.

This Standard has been made based on ISO 1985:1998 *Machine tools—Test conditions for surface grinding machines with vertical grinding wheel spindle and reciprocating table—Testing of the accuracy* for the purposes of making it easier to compare this Standard with International Standard; to prepare Japanese Industrial Standard conforming with International Standard; and to propose a draft of an International Standard which is based on Japanese Industrial Standard.

Attention is drawn to the possibility that some parts of this Standard may conflict with a patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have technical properties. The relevant Minister and the Japanese Industrial Standards Committee are not responsible for identifying the patent right, application for a patent after opening to the public, utility model right or application for registration of utility model after opening to the public which have the said technical properties.

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In the event of any doubts arising as to the contents,
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Machine tools—Test conditions for surface grinding machines with vertical grinding wheel spindle and reciprocating table—Testing of the accuracy

Introduction This Japanese Industrial Standard has been prepared based on the first edition of ISO 1985 *Machine tools—Test conditions for surface grinding machines with vertical grinding wheel spindle and reciprocating table—Testing of the accuracy* published in 1998 with some modifications of the technical contents.

Portions given sidelines or dotted underlines are the matters not stated in the original International Standard. The list of modifications with the explanation is given in annex 2 (informative).

1 Scope This Standard specifies, with reference to JIS B 6191, both geometric and machining tests on general purpose, normal accuracy, surface grinding machines with reciprocating table and vertical grinding wheel spindle. It also specifies the applicable tolerances corresponding to the above-mentioned tests.

This Standard is not applicable to surface grinding machines with fixed or rotating tables or to machines having longitudinal traverse of the wheel head.

This Standard deals only with the verification of the geometric 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 testing the accuracy.

Note : The International Standard corresponding to this Standard is as follows.
In addition, symbols which denote the degree of correspondence in the contents between the relevant International Standard and JIS are IDT (identical), MOD (modified), and NEQ (not equivalent) according to ISO/IEC Guide 21.

ISO 1985:1998 *Machine tools—Test conditions for surface grinding machines with vertical grinding wheel spindle and reciprocating table—Testing of the accuracy* (MOD)

2 Normative reference The following standard contains provisions which through reference in this Standard, constitute provisions of this Standard. The most recent edition of the standard (including amendments) indicated below shall be applied.

JIS B 6191 *Machine tools—Geometric accuracy tests and practical tests—Test methods*

Note : ISO 230-1:1996 *Test code for machine tools—Part 1: Geometric accuracy of machines operating under no-load or finishing conditions* is equivalent to the said standard.