

Test conditions for numerically controlled turning machines and turning centres —

Part 6: Accuracy of a finished test piece

ICS 25.040.20

National foreword

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The UK participation in its preparation was entrusted to Technical Committee MTE/1, Machine tools, which has the responsibility to:

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Summary of pages

This document comprises a front cover, an inside front cover, the ISO title page, pages ii to v, a blank page, pages 1 to 12, an inside back cover and a back cover.

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Amendments issued since publication

Amd. No.	Date	Comments

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 6 April 2005

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ISBN 0 580 45763 X

INTERNATIONAL STANDARD

ISO
13041-6

First edition
2005-02-15

Test conditions for numerically controlled turning machines and turning centres —

Part 6: Accuracy of a finished test piece

*Conditions d'essai des tours à commande numérique et des centres
de tournage —*

Partie 6: Exactitude d'une pièce d'essai usinée



Reference number
ISO 13041-6:2005(E)

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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.

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The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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ISO 13041-6 was prepared by Technical Committee ISO/TC 39, *Machine tools*, Subcommittee SC 2, *Test conditions for metal cutting machine tools*.

ISO 13041 consists of the following parts, under the general title *Test conditions for numerically controlled turning machines and turning centres*:

- *Part 1: Geometric tests for machines with a horizontal workholding spindle*
- *Part 2: Geometric tests for machines with a vertical workholding spindle*
- *Part 4: Accuracy and repeatability of positioning of linear and rotary axes*
- *Part 6: Accuracy of a finished test piece*
- *Part 7: Evaluation of contouring performance in the coordinate planes*
- *Part 8: Evaluation of thermal distortions*

The following parts are under preparation:

- *Part 3: Geometric tests for machines with an inverted vertical workholding spindle*
- *Part 5: Accuracy of feeds, speeds and interpolations*

Introduction

A numerically controlled turning machine is a machine tool in which the principal motion is the rotation of the workpiece against the stationary cutting tool(s) and where cutting energy is brought by the workpiece and not by the tool. This machine is controlled by a numerical control (NC) providing automatic function according to of ISO 13041-1:2004, 3.3.4, and can be of single-spindle or multispindle type.

A turning centre is a NC turning machine equipped with power driven tool(s) and the capacity to orientate the work holding spindle around its axis. This machine may include additional features such as automatic tool-changing from a magazine.

The object of ISO 13041 is to supply information as wide and comprehensive as possible on geometric, positional, contouring, thermal and machining tests, which can be carried out for comparison, acceptance, maintenance or any other purpose.

ISO 13041 specifies, with reference to the relevant parts of ISO 230, tests for turning centres and numerically controlled turning machines with/without tailstocks standing alone or integrated in flexible manufacturing systems. ISO 13041 also establishes the tolerances or maximum acceptable values for the test results corresponding to general purpose and normal accuracy turning centres and numerically controlled turning machines.