
International Standard



5734

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Acceptance conditions of mechanical dividing heads for machine tools — Testing of accuracy

Conditions de réception des appareils diviseurs, à commande mécanique, pour machines-outils — Contrôle de la précision

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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.

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 5734 was prepared by Technical Committee ISO/TC 39, *Machine tools*.

This second edition cancels and replaces the first edition (ISO 5734-1978), the geometrical tests G4, G5 and G6 of which have been technically revised.

Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

Acceptance conditions of mechanical dividing heads for machine tools — Testing of accuracy

1 Scope and field of application

This International Standard specifies, with reference to ISO 230/1, geometrical tests on general purpose and normal accuracy mechanical dividing heads for use on machine tools, and the corresponding permissible deviations that apply.

It deals only with the verification of the accuracy of the device. It does not apply to the running of the device, which should generally be checked before the accuracy is tested.

2 Reference

ISO 230/1, *Acceptance code for machine tools — Part 1: Geometric accuracy of machines operating under no-load or finishing conditions.*

3 Preliminary remarks

3.1 In this International Standard, dimensions and deviations are expressed in millimetres and in inches.

3.2 To apply this International Standard, reference should be made to ISO 230/1, especially for the description of measuring methods and the recommended accuracy of testing equipment.

3.3 The sequence in which the geometrical tests are given is related to the sub-assemblies of the device, 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 applied in any order.

3.4 When inspecting a device, it is not always necessary to carry out all the tests given 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 device.

3.5 When establishing the tolerance for a measuring range different from that given in this International Standard (see 2.311 in ISO 230/1), it should be taken into consideration that the minimum tolerance value is 0,01 mm (0.000 4 in).

3.6 For reasons of simplicity the diagrams in this International Standard illustrate only one type of machine.