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JAPANESE INDUSTRIAL STANDARD

**Test Methods for Performance
and Accuracy of Planer
Knife Grinding Machines**

JIS B 6516—1989

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In the event of any doubt arising,
the original Standard in Japanese is to be final authority.

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Test Methods for Performance and Accuracy of
Planer Knife Grinding Machines

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1. Scope

This Japanese Industrial Standard specifies the test methods related to functions, running performances and rigidities, and the methods of inspection on static accuracies and machining accuracies of the manual knife grinders specified in No. 6821 and the automatic knife grinders specified in No. 6822 of JIS B 0114, hereinafter referred to as the "knife grinding machine", of 400 mm or over to 900 mm or under in length of knife stock.

Remark: In this Standard, units and numerical values given in { } are in accordance with the conventional units, and are appended for informative reference.

2. Methods for Functional Tests

The functional tests for the knife grinding machines shall be in accordance with Table 1.

Applicable Standards:

JIS B 0114-Glossary of Terms for Wood Working Machinery

JIS B 6507-General Code of Safety for Wood Working Machinery

JIS B 6521-Methods of Measurement for Noise Emitted by Wood Working Machinery

Reference Standards:

JIS B 6501-Test Code for Performance and Accuracy of Wood Working Machinery

JIS Z 8203-SI Units and the Use of their Multiples and of Certain other Units

Table 1. Functional Tests

No.	Test item	Test method
1	Electric apparatus	Before and after the running test, examine the insulating conditions once each.
2	Start, stop and running operation of wheel spindle	At an appropriate wheel spindle speed of rotation, carry out 10 times of start and stop continuously to examine the smoothness and reliability of actions.
3	Changing operation of wheel spindle speed of rotation	Change the wheel spindle speed of rotation over entire marked speeds of rotation to examine the smoothness of the actions and reliability to the indication of the operating device.
4	Operation of hand feed handle of table	Travel the table in the left and right by the hand feed handle to examine the smoothness and uniformity of workings throughout the overall length of the motion. Carry out the similar examination also in the front and rear direction of the table.
5	Changing operation of table feed speed	Change the table feed speed over entire marked indications to examine the smoothness of the work and reliability of indications of the operating device.
6	Operation of automatic reversing of table	Travel the table at the minimum and maximum speeds in the left and right direction to examine, regarding the positioning of the automatic reversing and working, the smoothness and reliability respectively.
7	Operation of knife stock	Rotate the knife stock and fix at an arbitrary position to examine the smoothness and reliability of work and the reliability of fixing as well.
8	Changing operation of power cross feed amount of wheel spindle or table	Change the power cross feed amount of wheel spindle or table from the maximum to the minimum to examine the smoothness of workings and reliability of indications of the operating device.
9	Operation of hand feed handle of wheel spindle travel	Travel the wheel spindle in crosswards or vertically by the hand feed handle to examine the smoothness and uniformity of workings throughout the overall length of the motion.
10	Operation of automatic stop position of wheel spindle automatic infeed	Run the machine at the maximum and the minimum automatic infeed amounts of the wheel spindle to examine, with respect to the setting and workings of the automatic stop device, the smoothness and reliability respectively.