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JAPANESE INDUSTRIAL STANDARD

**Veneer knife grinders —
Test and inspection methods**

JIS B 6543—1991

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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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1. Scope

This Japanese Industrial Standard specifies the test methods for function, running performance and rigidity, and the inspection methods for static accuracy and machining accuracy of veneer knife grinders with a tool fitting surface of length not less than 2000 mm up to not more than 5800 mm.

Remarks 1. Veneer knife grinder is the machine which makes grind finishing by reciprocating movement of the rotating grinder over the whole range of tip length of the cutter fixed on the tool fitting stand.

It is used mainly for grinding the cutter for veneer lathe, slicer and clipper (see JIS B 0114).

2. Applicable standards to this Standard are as follows:

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.

JIS R 6210-Vitrified grinding wheels.

3. The units and numerical values given in { } in this Standard are based on the traditional units and are given for reference.

2. Function inspection methods

The function test on veneer knife grinders shall comply with Table 1.

Table 1. Function test

No.	Test items	Test method
1	Electric device	Test insulation condition once each before and after running test.
2	Fitting and removal of wheel	Test smoothness and positiveness for fitting and removal of wheel, and fastening of screw.
3	Swing angle ⁽¹⁾ adjusting device of wheel	Test smoothness of operation and exactness of indication in adjusting device for swing angle of wheel.
4	Starting, stopping and running of wheel	Let wheel spindle run about 10 times and test positiveness of operation and number of revolution.
5	Fitting and removal of veneer knife	Test smoothness and positiveness for fitting and removal of tool fitting and fastening of screw.
6	Rotating device of tool fitting stand	Rotate tool fitting stand and test smoothness of operation and exactness of indication.
7	Feeding device in depth of cut of wheel	Test smoothness of operation for feeding in depth of cut of wheel and exactness of indication.
8	Starting, stopping and running of wheel fitting stand	Let wheel fitting stand run reciprocally about 10 times and test the functional smoothness and uniformity for whole length of movement.
9	Cutting fluid supplying device	Let cutting fluid supplying device work and test positiveness of its function.
10	Dust proof device of sliding surface	Test functional smoothness and positiveness.
11	Feed direction changing device of wheel fitting stand	Test functional smoothness and positiveness.
12	Safety device	Test functional smoothness and positiveness for worker's safety device and machine protective device. (See JIS B 6507)
13	Lubricating device	Test functional smoothness and positiveness such as oil tightness and adequate supply of oil.
14	Accessory device	Test functional smoothness and positiveness.

Note ⁽¹⁾ It is called "run out angle" as well.

Remarks: Those not equipped with the said function in accordance with type may be omitted from the test on the corresponding item in Table 1.