

# INTERNATIONAL STANDARD

**ISO**  
**11630**

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## **Cranes — Measurement of wheel alignment**

*Appareils de levage à charge suspendue — Mesure de l'alignement des galets*

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Reference number  
ISO 11630:1997(E)

## Foreword

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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.

International Standard ISO 11630 was prepared by Technical Committee ISO/TC 96, *Cranes*, Subcommittee SC 4, *Test methods*.

Annex A of this International Standard is for information only.

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# Cranes — Measurement of wheel alignment

## 1 Scope

This International Standard establishes requirements for methods of measuring the alignment of crane wheels in accordance with ISO 4310, ISO 9373 and ISO 12488-1.

The procedures given are based on the use of optical methods for measurement, however this International Standard permits the use of other methods which ensure at least an equivalent accuracy of measurements.

This International Standard applies to measurements on four-wheel cranes which move on rails (except railway cranes).

NOTE — Procedures for measurements on cranes with more than four wheels are intended for the next edition of this International Standard.

## 2 Normative references

The following standards contain provisions, which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreement based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 4310:1981, *Cranes — Test code and procedures*.

ISO 9373:1989, *Cranes and related equipment — Accuracy requirements for measuring parameters during testing*.

## 3 Measurement of the alignment of crane wheels in plan view

The measurement of the alignment of wheels on cranes should proceed by the following steps:

- a) select the baseline for the coordinate system;
- b) establish the geodetic rectangle;
- c) measure distances from the sides of the geodetic rectangle to the wheels;
- d) calculate actual deviations of the wheels in plane from the design position.

Measurements shall be made in accordance with ISO 4310 and ISO 9373. See also ISO 12488-1.

**3.1 Selection of baseline for the coordinate system**

To simplify the calculation of deviations, it is necessary to assume a base coordinate system and take measurements in reference to it.

**3.1.1** From two select points on the external surface of the crane end-carriage, erect perpendiculars as shown in figure 1.

**3.1.2** On the perpendicular thus erected from the crane end-carriage, measure off segments  $Y_0$  of equal length. The theodolite should be positioned so that the direction of the collimating ray passes through the ends of the segments  $Y_0$ .

**3.1.3** Taking the location of the theodolite as point O and arbitrary point of the theodolite collimating ray outside the crane as point R, then O and R will identify the direction of the  $x$  axis and serve as a base to establish the geodetic rectangle (see figure 1).

**3.2 Establishing the geodetic rectangle**

**3.2.1** Based on the points O and R, the geodetic rectangle OPQR is established using the theodolite. The error in laying out corners of the rectangle should not exceed 6 seconds of arc.

Identify the vertices P and Q by corresponding points as shown in figure 2.

**3.2.2** Measure distances OP, QR, PQ and OR. Differences in the dimensions (OP-QR) and (PQ-OR) shall not exceed

- a) for cranes with span  $S \leq 10$  m:  $\pm 2$  mm;
- b) for cranes with span  $S > 10$  m:  $\pm [2 + 0,1(S - 10)]$  mm.

**3.3 Measurement of distances from the sides of the geodetic rectangle to the crane wheels**

**3.3.1** Establish reference points corresponding to the crane wheels (see figure 2) and measure distances on the sides OR and PQ of the geodetic rectangle from points O, P, Q and R to the reference points, distances  $X_O$ ,  $X_P$ ,  $X_Q$  and  $X_R$ .

Record the measurements in table 1.

**3.3.2** Measure distances  $Y_{O1}$ ,  $Y_{O2}$ ,  $Y_{P1}$ ,  $Y_{P2}$ ,  $Y_{Q1}$ ,  $Y_{Q2}$ ,  $Y_{R1}$ ,  $Y_{R2}$ ,  $D_{OH}$ ,  $D_{PH}$ ,  $D_{QH}$  and  $D_{RH}$  from each crane wheel as shown in figure 2.

Record the measurements in table 1.

**Table 1 — Position of crane wheels in plan view**

Dimensions in millimetres

Geodetic rectangle side dimension				x-axis distance to wheels				y-axis distance to wheels								Reference dimension <sup>1)</sup>			
OP	PQ	QR	OR	$X_O$	$X_P$	$X_Q$	$X_R$	$Y_{O1}$	$Y_{O2}$	$Y_{P1}$	$Y_{P2}$	$Y_{Q1}$	$Y_{Q2}$	$Y_{R1}$	$Y_{R2}$	$D_{OH}$	$D_{PH}$	$D_{QH}$	$D_{RH}$

1)  $D_{OH}$ ,  $D_{RH}$ ,  $D_{PH}$  and  $D_{QH}$  shall be as large as practical.

### 3.4 Calculation of actual deviations of crane wheels in plan view

3.4.1 Using the data in table 1, calculate the angle of deviation (in radians or per thousand) of crane wheels in plan using the equations:

$$\gamma_O = \frac{Y_{O1} - Y_{O2}}{D_{OH}} - \gamma; \quad \gamma_P = \frac{Y_{P1} - Y_{P2}}{D_{PH}} - \gamma;$$

$$\gamma_Q = \frac{Y_{Q1} - Y_{Q2}}{D_{QH}} - \gamma; \quad \gamma_R = \frac{Y_{R1} - Y_{R2}}{D_{RH}} - \gamma;$$

where

$$\gamma = \frac{Y_{O1} - Y_{O2} + Y_{P1} - Y_{P2} + Y_{Q1} - Y_{Q2} + Y_{R1} - Y_{R2}}{D_{OH} + D_{PH} + D_{QH} + D_{RH}}$$

3.4.2 Using the data from table 1 and the crane base length  $B$  (see figure 4) given in the crane specification, calculate deviations of the crane base, for each side of the crane from the equations:

$$\Delta e_{PQ} = B - \left[ PQ - X_P - X_Q - \left( \frac{D_{PH} + D_{QH}}{2} \right) \right]$$

$$\Delta e_{OR} = B - \left[ OR - X_O - X_R - \left( \frac{D_{OH} + D_{RH}}{2} \right) \right]$$

3.4.3 Using the data from table 1, calculate the misalignment of the crane wheel planes in plan view from the equations:

$$\Delta F_{PQ} = \frac{Y_{P1} + Y_{P2} - Y_{Q1} - Y_{Q2}}{2}$$

$$\Delta F_{OR} = \frac{Y_{O1} + Y_{O2} - Y_{R1} - Y_{R2}}{2}$$

3.4.4 Using the data from table 1, the length of the crane span  $S$  and the crane wheel tread width  $S_w$  given in the crane specification, calculate deviations of the span  $\Delta S$  for each pair of crane wheels

$$S_{OP} = S - \left( OP - \frac{Y_{O1} + Y_{O2} + Y_{P1} + Y_{P2}}{2} - S_w \right)$$

$$S_{QR} = S - \left( QR - \frac{Y_{R1} + Y_{R2} + Y_{Q1} + Y_{Q2}}{2} - S_w \right)$$

3.4.5 Using the data from table 1, calculate the misalignment  $\Delta N$  in plan view for a pair of crane wheels

$$\Delta N_{OP} = X_O - X_P$$

$$\Delta N_{QR} = X_Q - X_R$$

## 4 Determination of the alignment of crane wheels in elevation profile

### 4.1 General

For measurements required to calculate the deviations of crane wheels in elevation profile, use the geodetic rectangle established according to the procedures given in 3.1 and 3.2.

Then, proceed with the following steps to determine the deviations of crane wheels in elevation profile:

- a) measure distances from the sides of the geodetic rectangle to the crane wheels;
- b) calculate the actual deviations of crane wheels from the vertical.

### 4.2 Measurement of distances from the sides of the geodetic rectangle to crane wheels

Measure distances  $T_{O1}$ ,  $T_{O2}$ ,  $T_{P1}$ ,  $T_{P2}$ ,  $T_{Q1}$ ,  $T_{Q2}$ ,  $T_{R1}$ ,  $T_{R2}$ ,  $D_{OV}$ ,  $D_{RV}$ ,  $D_{PV}$  and  $D_{QV}$  from each crane wheel as shown in figure 3.

Record the measurements in table 2.

**Table 2 — Position of crane wheels in elevation profile**

Dimensions in millimetres

$T_{O1}$	$T_{O2}$	$T_{P1}$	$T_{P2}$	$T_{Q1}$	$T_{Q2}$	$T_{R1}$	$T_{R2}$	$D_{OV}$	$D_{RV}$	$D_{PV}$	$D_{QV}$

### 4.3 Calculation of actual deviations of crane wheels from the vertical in elevation profile

Using the data from table 2, calculate the angles of deviations  $\delta$  (in radians or per thousand) of the crane wheels from the vertical in elevation profile using the equations:

$$\delta_O = \frac{T_{O1} - T_{O2}}{D_{OV}} ; \quad \delta_P = \frac{T_{P1} - T_{P2}}{D_{PV}} ;$$

$$\delta_Q = \frac{T_{Q1} - T_{Q2}}{D_{QV}} ; \quad \delta_R = \frac{T_{R1} - T_{R2}}{D_{RV}} .$$

## 5 Determination of vertical deviations of crane wheels from the horizontal

### 5.1 General

Before taking measurements, the crane should be positioned on a specially aligned section of the crane rails whose length is not less than that of the crane base and along which the difference in rail height does not exceed 1 mm.

In order to determine the vertical deviations of the crane wheels, proceed as follows:

- a) raise one side of the crane;
- b) measure perpendicular distances from the raised wheels to the rail;
- c) repeat the procedure for other side of the crane;
- d) calculate the actual vertical deviations of the crane wheels from the horizontal.

## 5.2 Procedure to raise one side of the crane

Raise one side of the crane as shown in figure 4 so that both wheels on that side are clear of the rail.

## 5.3 Measurement of distances from the raised wheels to the rail

The measuring instrument error shall not exceed 0,1 mm.

Measure the perpendicular distances  $Z_O$  and  $Z_R$  from the rail to the bottom of the respective wheels, as shown in figure 4.

After taking measurements, lower the raised side of the crane to its initial position and repeat the procedure for the other side of the crane to determine  $Z_P$  and  $Z_Q$ .

Record the measurements in table 3.

**Table 3 — Vertical distances from the raised wheels of the crane to the rail**

Dimensions in millimetres

$Z_O$	$Z_P$	$Z_Q$	$Z_R$

## 5.4 Calculation of vertical deviations of the crane wheels from the horizontal position

Using the data from table 3, calculate the deviations of the crane wheels from the horizontal position  $\Delta h$  for each side of the crane

$$\Delta h_{R1} = Z_O - Z_R$$

$$\Delta h_{R2} = Z_P - Z_Q$$

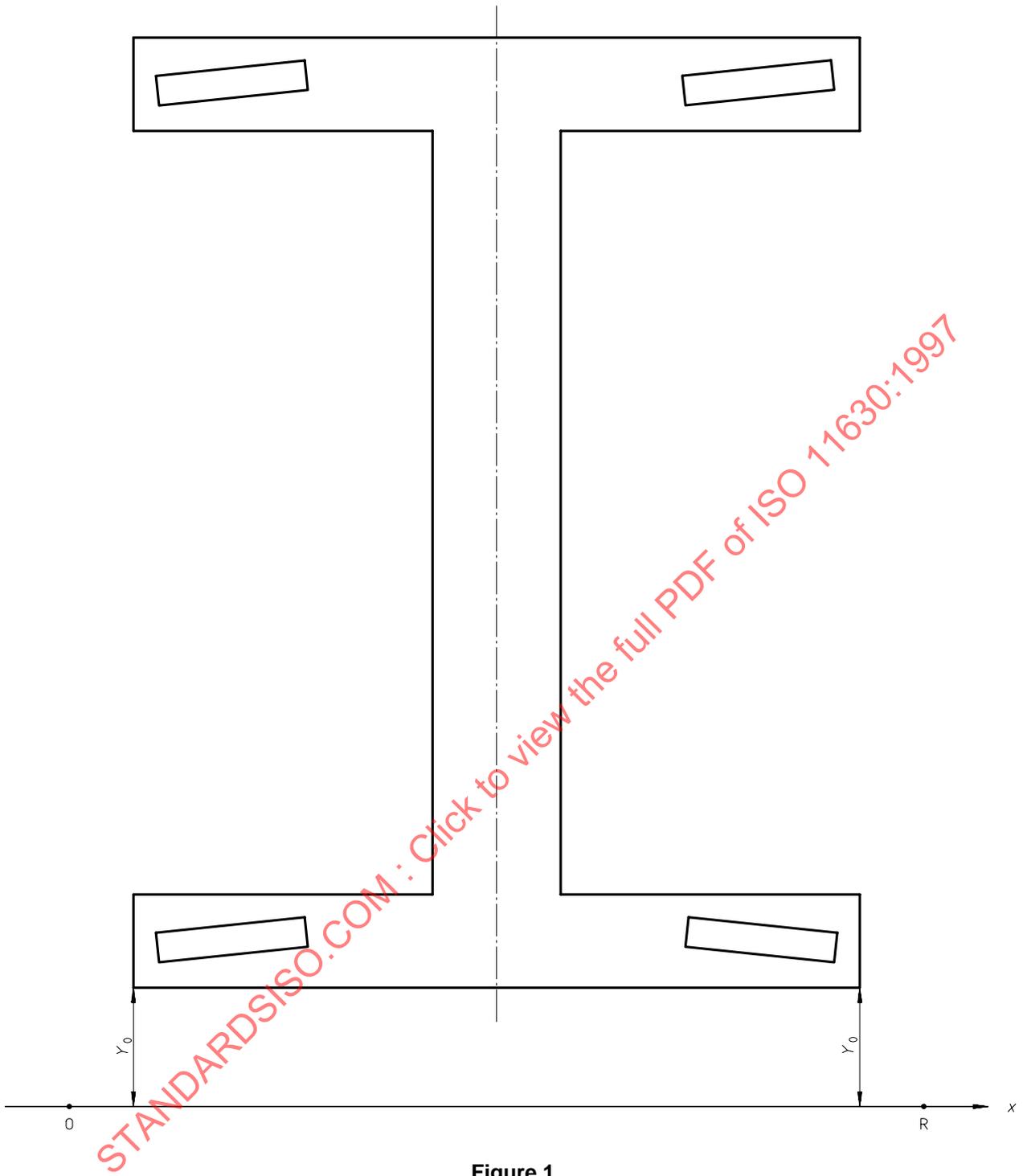


Figure 1

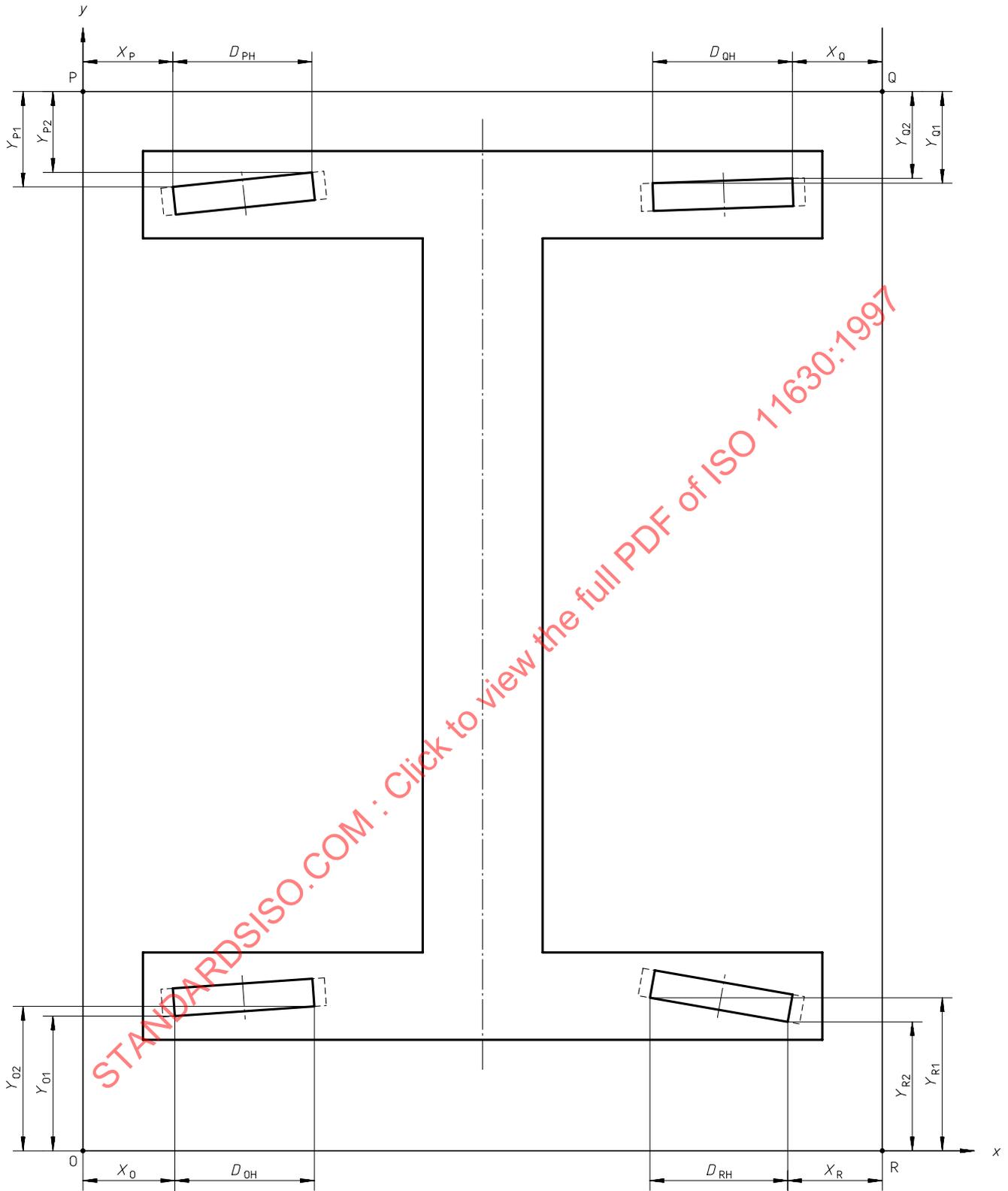


Figure 2

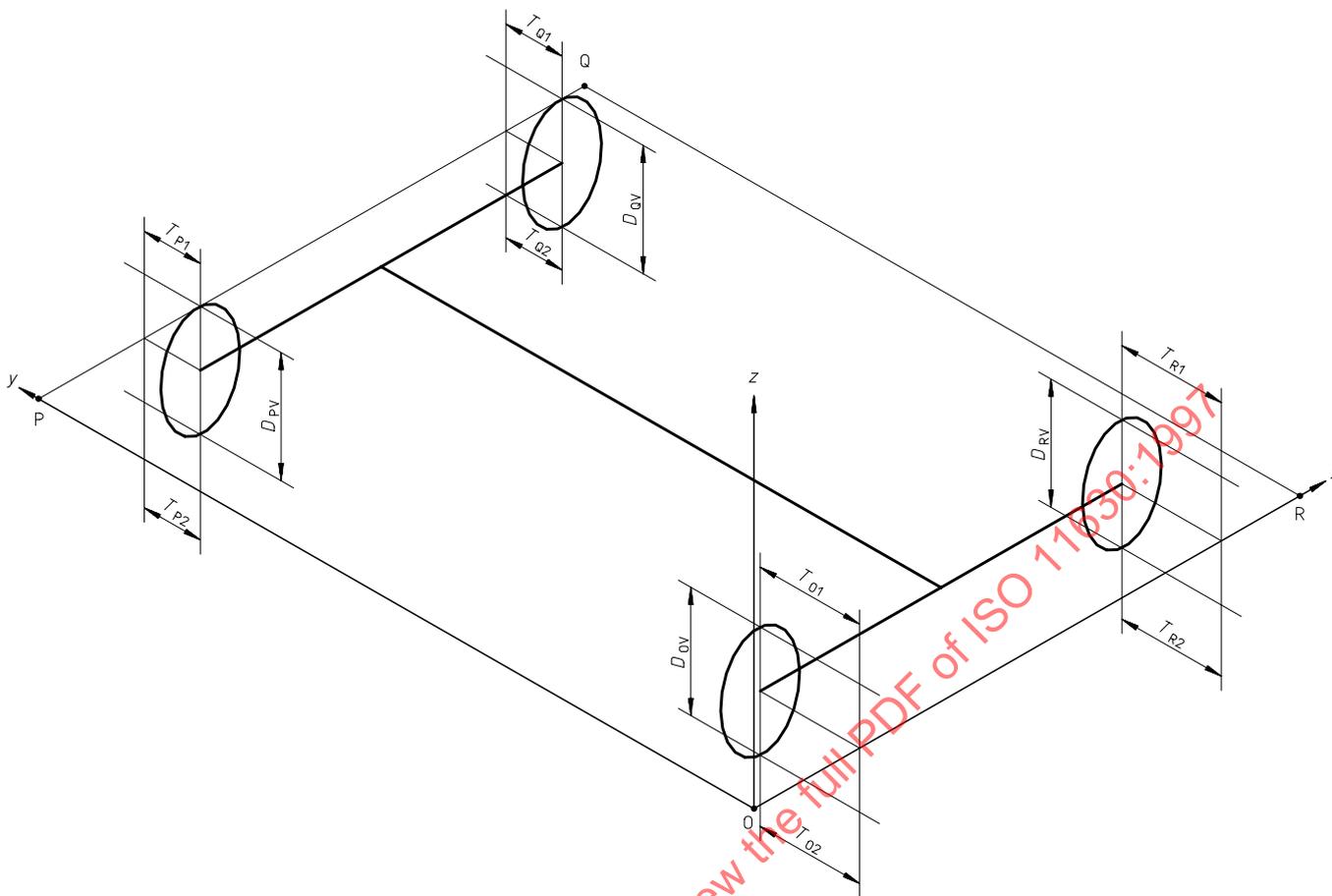


Figure 3

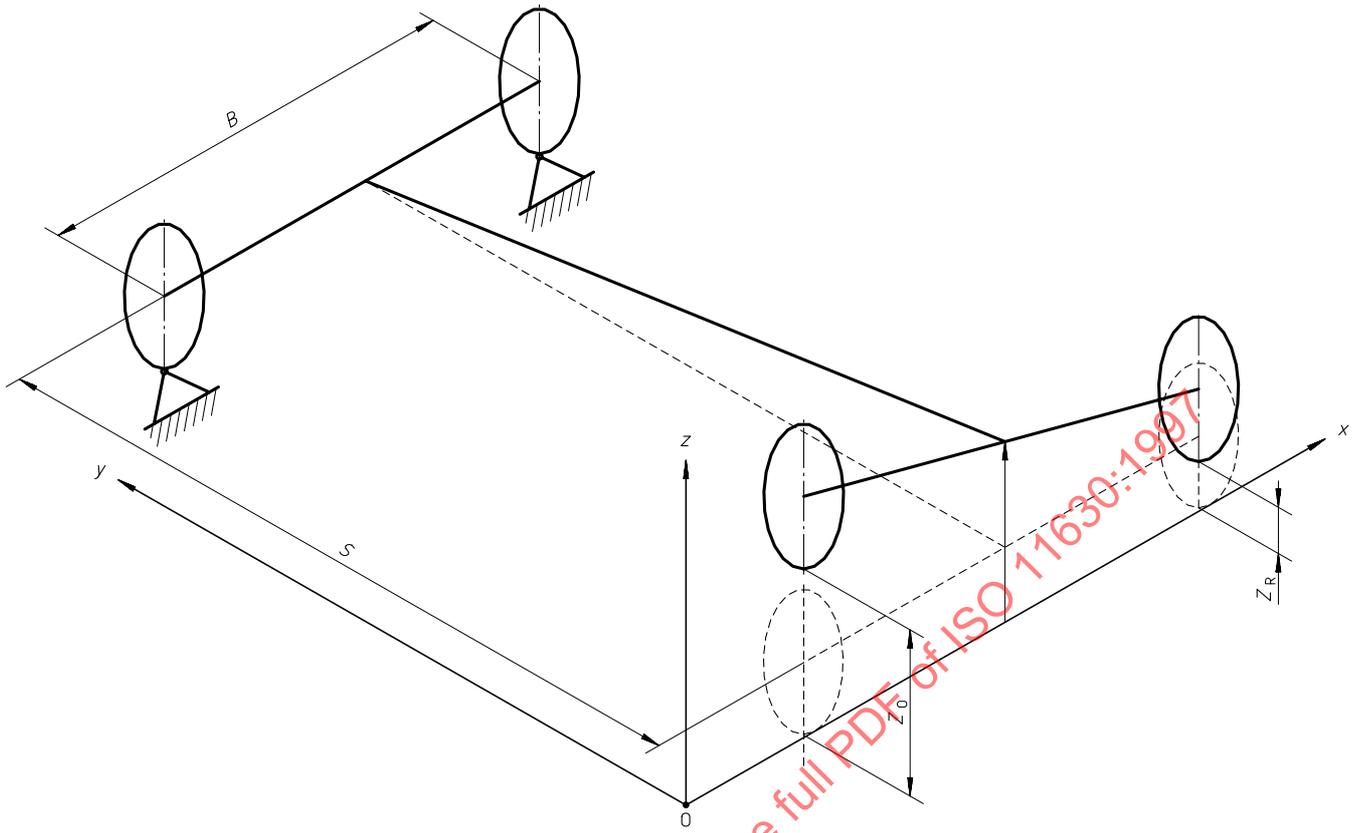


Figure 4

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