

---

**INTERNATIONAL STANDARD**



**2891**

---

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

---

**Modular units for machine tool construction — Centre bases and columns**

*Éléments standard pour la construction des machines-outils — Bâties centrales et montants*

**Second edition — 1977-10-15**

STANDARDSISO.COM : Click to view the full PDF of ISO 2891:1977

---

**UDC 621.9-112**

**Ref. No. ISO 2891-1977 (E)**

**Descriptors** : machine tools, modular units, frames, pillars, specifications, dimensions, interchangeability.

## FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

International Standard ISO 2891-1977, the second edition of this International Standard, has been drawn up by Technical Committee ISO/TC 39, *Machine tools*, and contains the modifications which were circulated, in the form of an amendment, to the member bodies in July 1976.

This amendment has been approved by the member bodies of the following countries :

Australia	India	Spain
Austria	Italy	Switzerland
Belgium	Korea, Rep. of	United Kingdom
Brazil	Mexico	U.S.S.R.
Czechoslovakia	Poland	Yugoslavia
France	Romania	
Hungary	South Africa, Rep. of	

The member bodies of the following countries expressed disapproval of the document on technical grounds :

Germany  
Japan

This second edition cancels and replaces the first edition (i.e. ISO 2891-1973), which had been approved by the member bodies of the following countries :

Austria	Ireland	Thailand
Belgium	New Zealand	Turkey
Czechoslovakia	Poland	United Kingdom
Egypt, Arab Rep. of	Romania	U.S.A.
France	South Africa, Rep. of	U.S.S.R.
Hungary	Sweden	
India	Switzerland	

The member bodies of the following countries had expressed disapproval of the document on technical grounds :

Germany  
Japan

# Modular units for machine tool construction — Centre bases and columns

## 1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies certain dimensions relating to the interchangeability of centre bases and columns used in special purpose machines constructed from modular units.

## 2 DIMENSIONS

**2.1** Dimensions for centre bases shall be in accordance with table 1.

**2.2** Dimensions for columns shall be in accordance with table 2.

## 3 LOCATION OF CENTRE BASES

As an alternative to the location by means of a tenon and slot, as given in this International Standard, location by dowels may be used.

STANDARDSISO.COM : Click to view the full PDF of ISO 2891-1977

4 CENTRE BASES

Dimensions in millimetres

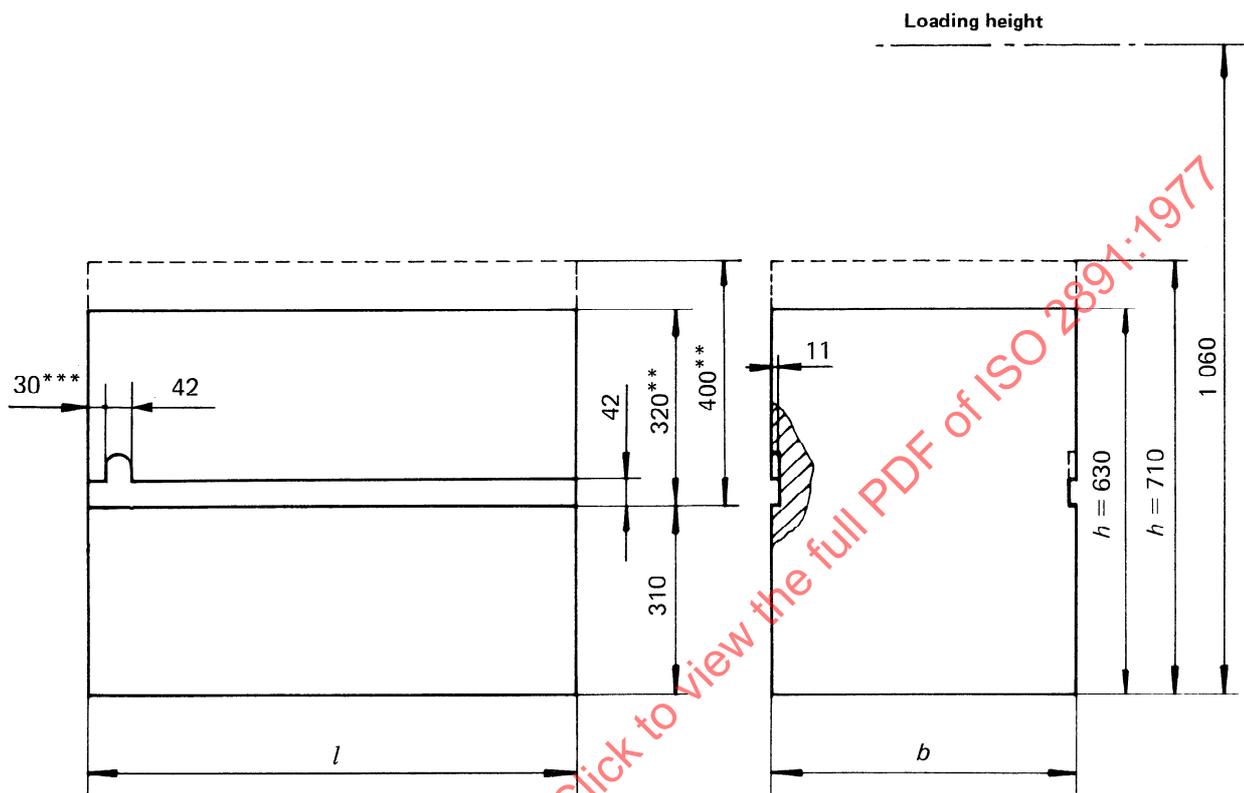


FIGURE 1 – Sketch of a centre base

TABLE 1 – Dimensions of centre bases

Dimensions in millimetres

Length $l^*$	Width $b$							Height $h$
800	500	560	630	710	800	900	—	630 or 710  (alternative)
1 000	—	—	630	710	800	900	1 000	
1 250	—	—	—	710	800	900	1 000	
$l > 1\ 250$	—	—	—	710	800	900	1 000	

\* Where lengths over 1 250 mm are required, they shall be chosen from the R 20 series of preferred numbers.

\*\* Partial dimension dependent upon the value of the height  $h$ .

\*\*\* This dimension is optional.

5 COLUMNS

Dimensions in millimetres

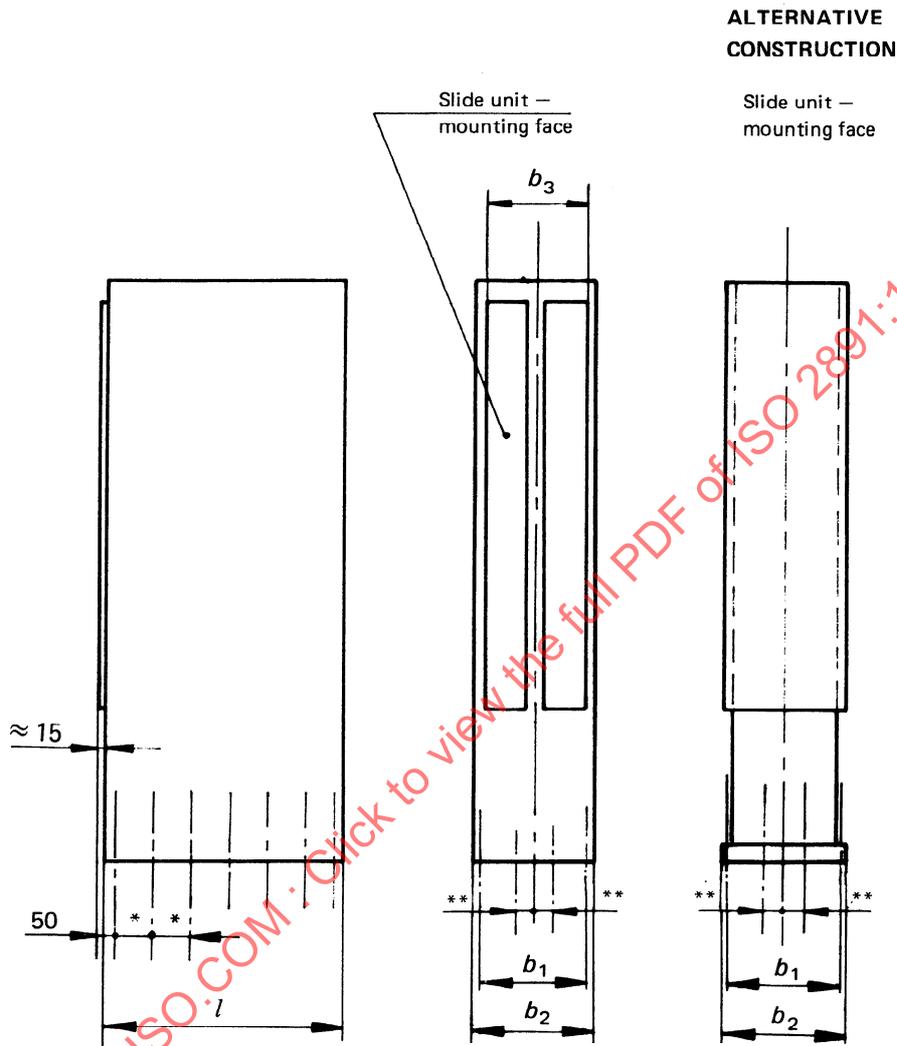


FIGURE 2 – Sketch of a column

TABLE 2 – Dimensions of columns

Dimensions in millimetres

Nominal size	Lateral fixing hole centres $b_1$ $\pm 0,2$	Column width $b_2$	Pad width $b_3$ min.	Column length $l$	Fixing bolt size
250	280	320	270	630	M 16
320	355	400	340	710	M 16
400	450	500	420	800	M 20
500	580	630	520	900	M 20
630	740	800	650	1 000	M 20

\* Lateral fixing bolt holes shall be spaced in increments of 25 mm or whole multiples of 25 mm (manufacturer's selection).  
Tolerances between extreme holes :  $\pm 0,2$  mm.

\*\* Front fixing holes shall be spaced from the centre line in increments of 25 mm or whole multiples of 25 mm (manufacturer's selection).

This page intentionally left blank

STANDARDSISO.COM : Click to view the full PDF of ISO 2891:1977