International Standard ISO 7008

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Woodworking machines — Single blade circular saw benches with or without travelling table — Nomenclature and acceptance conditions

Machines à bois — Machines à scier circulaires, monolame, à table de menuisier avec ou sans table mobile — Nomenclature et conditions de réception

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national bodies 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 authorized 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 7008 was developed by Technical Committee ISO/TC 39, *Machine tools*, and was circulated to the member bodies in April 1981.

It has been approved by the member bodies of the following countries:

Belgium	India	Romania
Brazil	Ireland	South Africa, Rep. of
China	Italy	Spain
Egypt, Arab Rep. of	Japan	Sweden
France	Korea, Dem. P. Rep. of	United Kingdom
Germany, F.R.	Korea, Rep. of	USSR
Hungary	Mexico	

No member body expressed disapproval of the document.

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Woodworking machines — Single blade circular saw benches with or without travelling table — Nomenclature and acceptance conditions

1 Scope and field of application

This International Standard specifies the terminology appropriate to each part of the machine and, with reference to ISO/R 230, the geometrical test for single blade circular saw benches with or without travelling table and gives the corresponding permissible deviations which apply to machines for general purpose use and normal accuracy.

NOTE — In addition to terms used in two of the three official ISO languages (English and French), this International Standard gives in the annex the equivalent terms in German, Spanish, Italian and Swedish; these have been included at the request of ISO Technical Committee TC 39 and are published under the responsibility of the member bodies for Germany F.R. (DIN), Spain (IRANOR), Italy (UNI) and Sweden (SIS). However, only the terms and definitions given in the official languages can be considered as ISO terms and definitions.

This International Standard deals only with the verification of accuracy of the machine. It does not apply to the testing of the running of the machine (vibrations, abnormal noises, stick-slip motion of the components etc.), nor to its characteristics (speeds, feeds etc.) which should generally be checked before testing accuracy.

This International Standard does not impose any practical test for single blade circular saw benches with or without travelling table. Practical tests should be exceptions and have to be stated in a previous agreement between the producer and the user.

2 Reference

ISO/R 230, *Test code for machine tools.*

3 Preliminary remarks

3.1 In this International Standard all the dimensions and permissible deviations are expressed in millimetres.

3.2 To apply this International Standard, reference should be made to ISO/R 230, especially for installation of the machine before testing, the warming up of the saw spindle and other moving parts and description of measuring methods. The measuring instruments shall not permit errors over 1/3 of the checked tolerances.

3.3 The sequence in which the geometrical tests are given is related to the sub-assemblies of the machine and this in no way defines the practical order of testing. In order to make mounting of instruments or gauging easier, tests may be applied in any order.

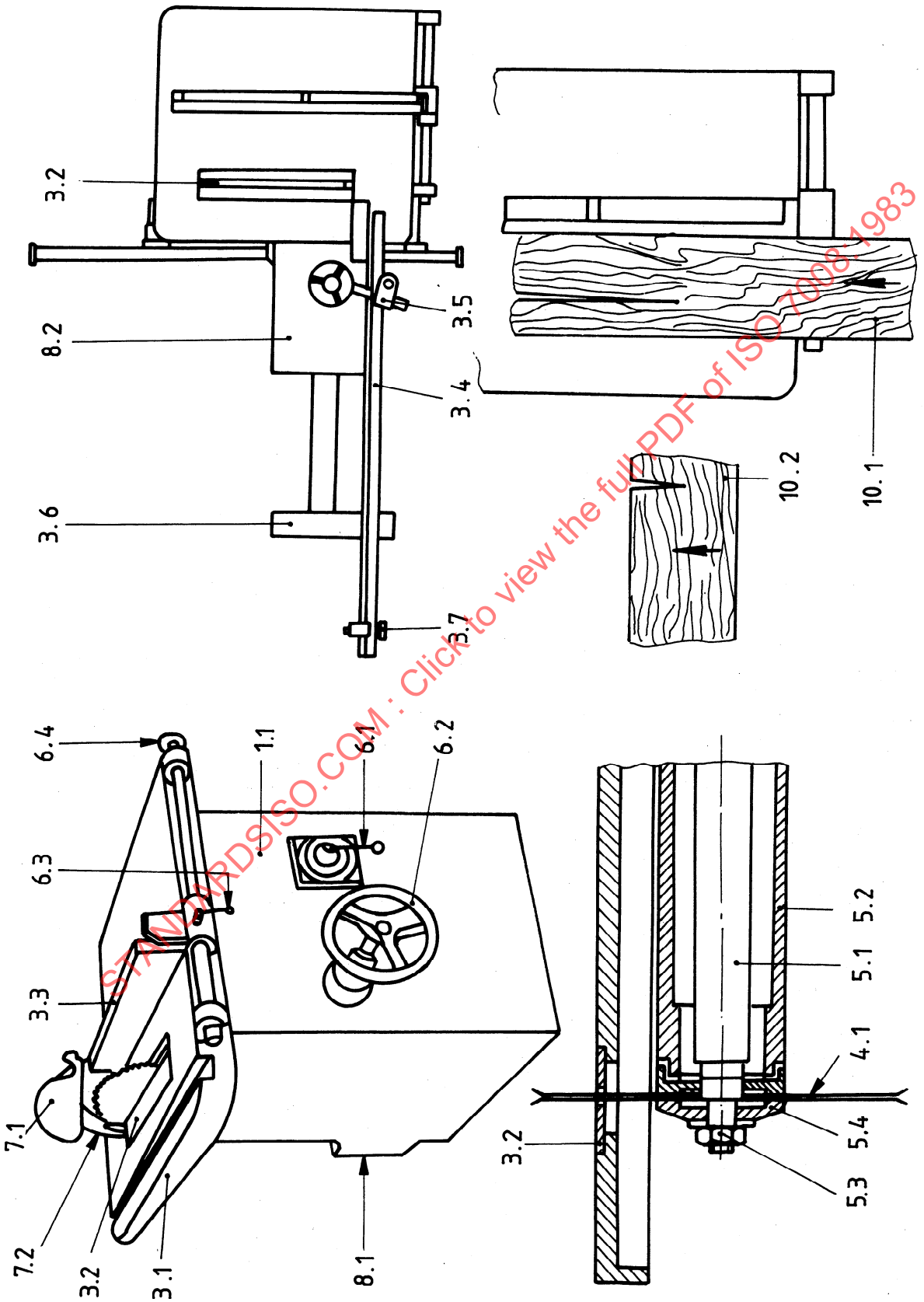
3.4 When inspecting a machine, it is not always possible or necessary to carry out all the tests given in this International Standard.

3.5 It is up to the user to choose, in agreement with the manufacturer, those tests relating to the properties which are of interest to him, but these tests are to be clearly stated when ordering a machine.

3.6 A movement is longitudinal when it takes place in the working direction of the piece.

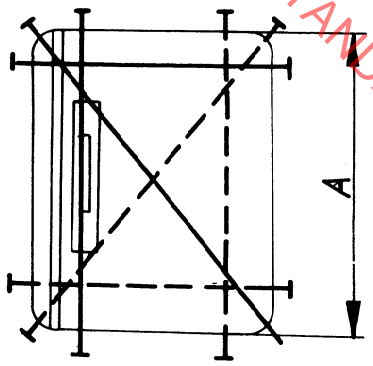
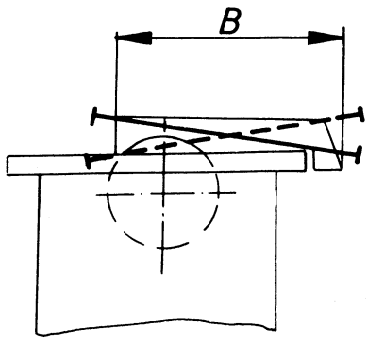
3.7 When establishing the tolerance for a measuring range different from that given in this International Standard (see 2.311 in ISO/R 230), it should be taken into consideration that the minimum value of the tolerance is 0,01 mm.

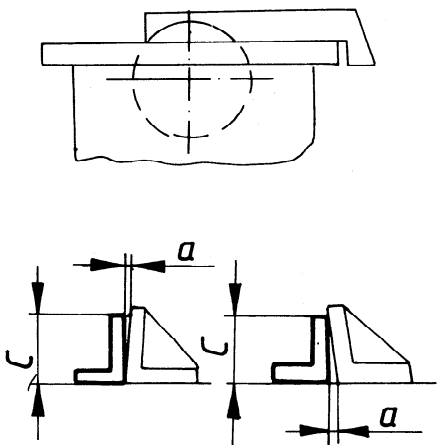
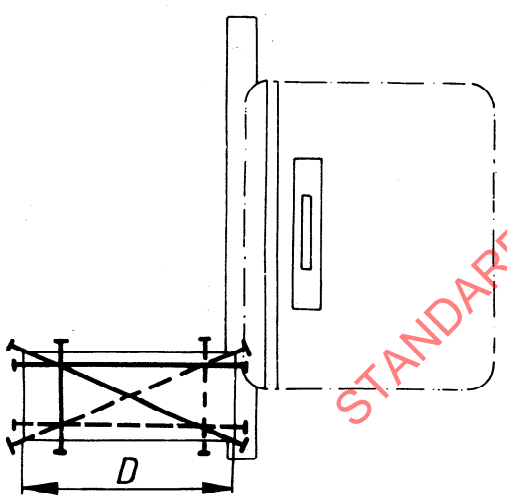
4 Nomenclature

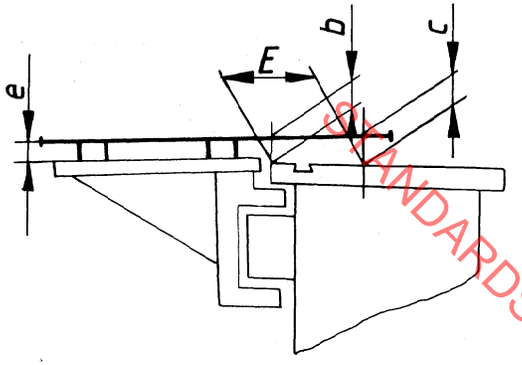
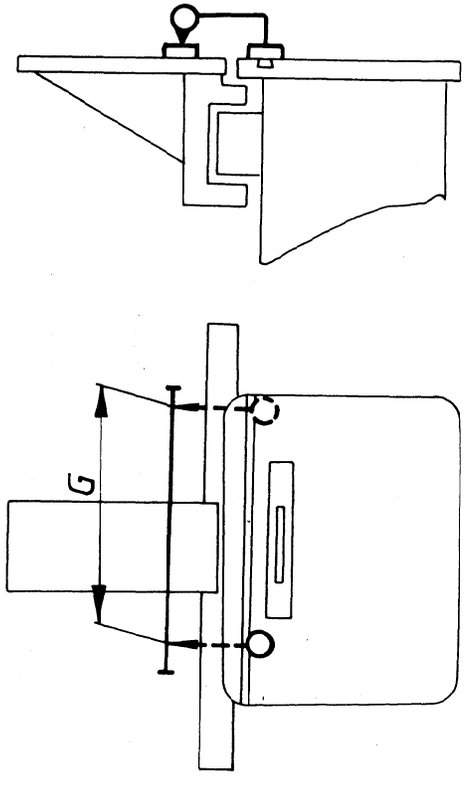


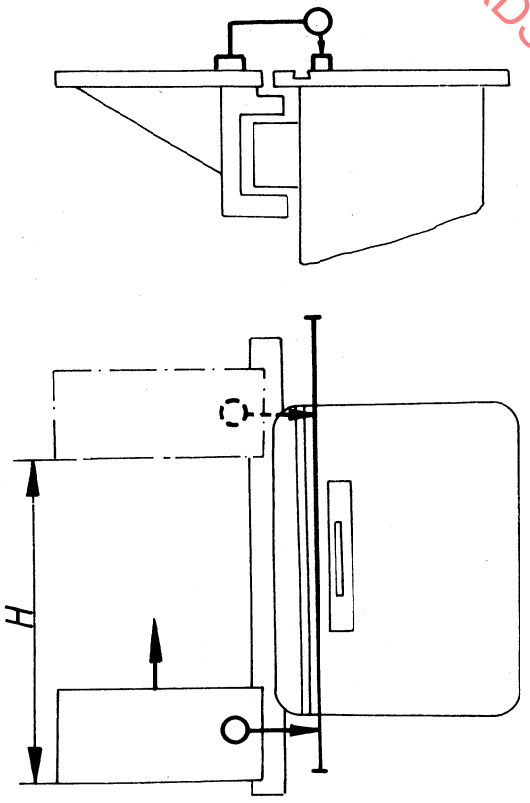
Ref.	English	French
	Single blade circular saw benches with or without travelling table	**Machine à scier circulaire, monolame, à table de menuisier avec ou sans table mobile**
1	**Framework**	**Ossature**
1.1	Main frame	Bâti
2	**Feed of workpiece and/or tools**	**Déplacement des pièces et/ou outils**
3	**Workpiece support clamp and guide**	**Support, maintien et guidage des pièces**
3.1	Table	Table
3.2	Table insert	Plaque amovible
3.3	Fence	Guide longitudinal
3.4	Crosscut fence	Guide coulisseau transversal
3.5	Clamp	Presseur
3.6	Travelling table extension	Rallonge du chariot
3.7	Length stop	Butée réglable
4	**Toolholders and tools**	**Porte-outils et outils**
4.1	Sawblade	Lame
5	**Workheads and tool drives**	**Unité de travail et son entraînement**
5.1	Saw spindle	Broche principale
5.2	Bearing housing	Support de la broche
5.3	Saw spindle nut	Écrou de blocage
5.4	Flange	Flasque de blocage de la lame
6	**Controls**	**Commandes**
6.1	Starting switch	Commutateur
6.2	Sawblade vertical adjustment	Commande de réglage de la lame en hauteur
6.3	Fence lock	Commande de blocage du guide
6.4	Fence adjustment	Commande de réglage fin du guide
7	**Safety devices**	**Dispositifs de sécurité**
7.1	Saw guard	Protecteur de la lame
7.2	Riving knife	Couteau diviseur
8	**Miscellaneous**	**Divers**
8.1	Dust extraction hood	Buse d'aspiration
8.2	Travelling table	Chariot d'équarissage
9	**Free**	**Libre**
10	**Examples of work**	**Exemples de travail**
10.1	Ripping	Coupe en long
10.2	Crosscutting	Tronçonnage (coupe en travers)

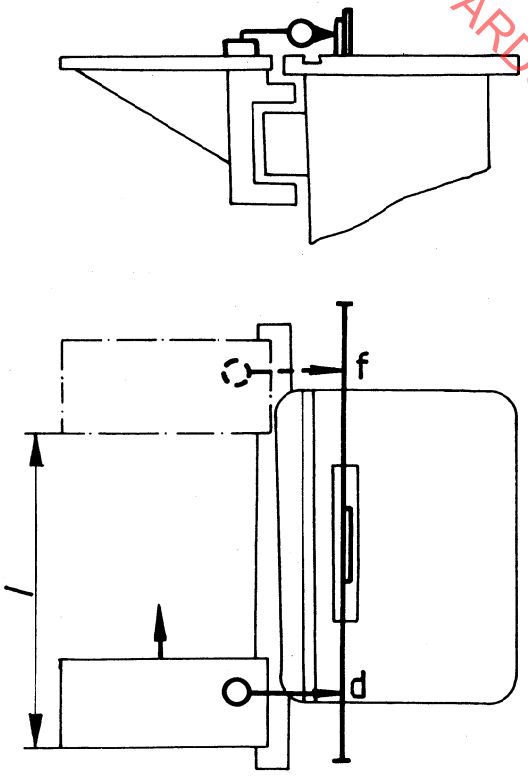
5 Acceptance conditions and permissible deviations

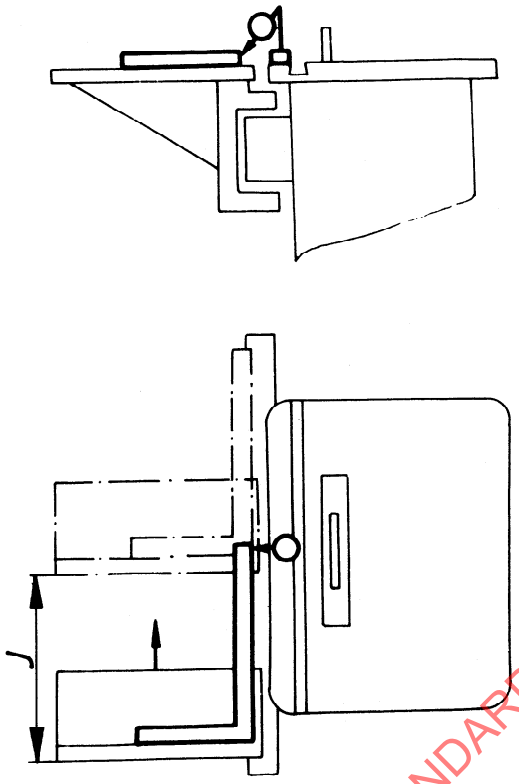
No.	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G1		Checking flatness of the table *a*) transverse straightness *b*) longitudinal straightness *c*) diagonal straightness	*a*) and *b*) 0,20 for $A \leqslant 630$ 0,25 for $630 < A \leqslant 1250$ 0,30 for $A > 1250$ *c*) 0,30 for $A \leqslant 630$ 0,40 for $630 < A \leqslant 1250$ 0,50 for $A > 1250$	Straightedge and feeler gauges	Clause 5.212 and 5.322
G2		Checking diagonal straightness of the fence	0,15 for $B \leqslant 630$ 0,25 for $B > 630$	Straightedge and feeler gauges	Clause 5.212

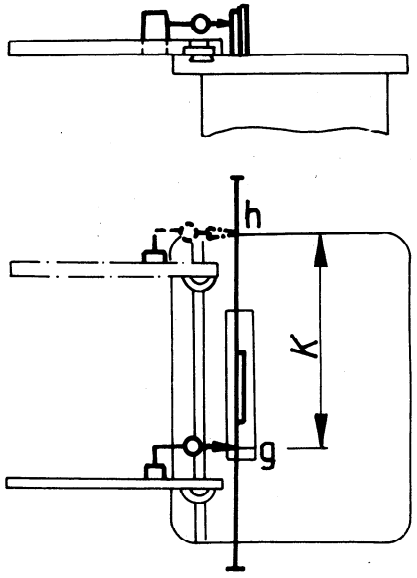
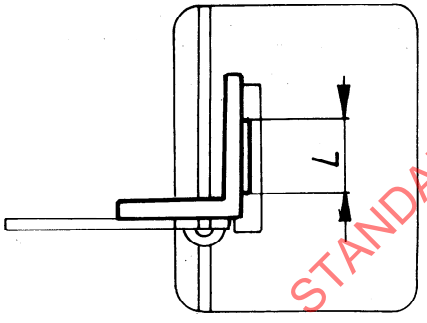
No.	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G3		Checking squareness of the fence to the table	0,15 /100*	Square and feeler gauges	Clause 5.512.2 * Distance C
G4		Checking flatness of the travelling table *a*) longitudinal straightness *b*) transverse straightness *c*) diagonal straightness	*a*), *b*) and *c*) 0,20 for $D \leqslant 630$ 0,30 for $D > 630$	Straightedge and feeler gauges	Clause 5.212 and 5.322

No.	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G5		Checking parallelism in the transverse direction of the travelling table of the machine, in a horizontal plane	$E = 450$ $b - e = 0{,}20$ $c - e = 0{,}20$ $c \geqslant b$	Straightedge and feeler gauges	Clause 5.412.2 Where the travelling table is supported by an edge arm, the permissible deviation is doubled at each end of the movement. The travelling table shall always be higher than the table of the machine. The deviation shall be checked along the whole stroke of the travelling table.
G6		Checking parallelism in the sawing direction of the travelling table to the table of the machine, in the horizontal plane	0,25 for $G = 1000$	Straightedge and dial gauges	Clause 5.412.2

No.	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G7		Checking parallelism of the travelling table motion to the table of the machine, in a vertical plane	0,40 for $H = 1000$	Straightedge and dial gauges	Clause 5.422.22

No.	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G8		Checking parallelism of the travelling table motion to the blade plane	0,40 for $I = 1000$ In positions d and f, the permissible deviations e shall satisfy the relation $e_f > e_d$	Straightedge, dial gauge and control disc	Clause 5.422.22

No.	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G9		Checking squareness of the crosscut fence of the travelling table to its motion	0,15/500*	Dial gauge and square	Clause 5.522.2 * Distance *J*

No	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G10		Checking parallelism of the squaring fence movement to the saw blade	0,20 for $K \leqslant 800$ 0,25 for $800 < K \leqslant 1200$ 0,30 for $K > 1200$ At both ends of the squaring fence stroke, the permissible deviations e shall satisfy the relation $e_h \geqslant e_g$	Straightedge, dial gauge and control disc	Clause 5.422.22
G11		Checking squareness of squaring fence to the saw blade	0,20/450*	Square, feeler gauges and control disc	Clause 5.512.2 * Diameter L