
International Standard



7568

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

Woodworking machines — Thickness planing machines with rotary cutterblock for one-side dressing — Nomenclature and acceptance conditions

Machines à bois — Machines à raboter sur une face avec outil rotatif — Nomenclature et conditions de réception

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Descriptors : machine tools, woodworking machinery, planing machines, vocabulary, tests, measurement, accuracy.

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 7568 was prepared by Technical Committee ISO/TC 39, *Machine tools*.

Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

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Woodworking machines — Thickness planing machines with rotary cutterblock for one-side dressing — Nomenclature and acceptance conditions

1 Scope and field of application

This International Standard specifies the appropriate terminology for each part of the machine and, with reference to ISO 230/1, the geometrical tests for thickness planing machines with rotary cutterblock for one-side dressing; it also gives the corresponding permissible deviations which apply to machines of 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 the equivalent terms in German, Spanish, Italian and Swedish in an annex; these have been included at the request of Technical Committee ISO/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 given in the official languages can be considered as ISO terms.

This International Standard deals only with the verification of accuracy of the machine. It does not apply to testing 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 thickness planing machines with rotary cutterblock for one-side dressing. Practical tests should be exceptions and have to be stated in a previous agreement between the manufacturer and the user.

This International Standard applies to those machines designated by the number 12.212 in ISO 7984.

2 References

ISO 230/1, *Acceptance code for machine tools — Part 1: Geometric accuracy of the machine operating under no load or finishing conditions.*

ISO 7984, *Woodworking machines — Technical classification of woodworking and auxiliary machines.*¹⁾

3 Preliminary remarks

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

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

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 the mounting of instruments or gauging easier, tests may be applied in any order.

3.4 It is not always possible nor 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 shall be clearly stated when ordering a machine.

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

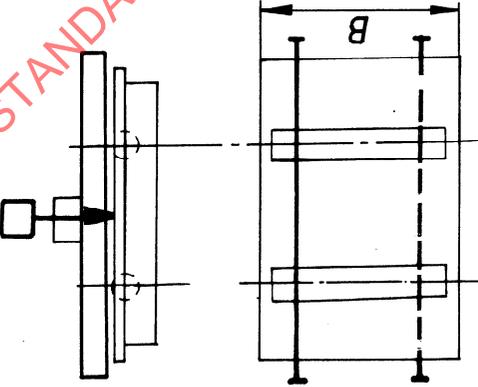
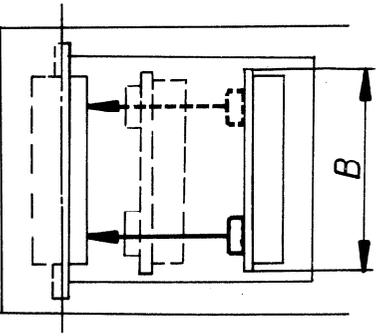
3.7 When establishing the tolerance for a measuring range different from that given in this International Standard (see clause 2.311 in ISO 230/1), it should be taken into consideration that the minimum value of the tolerance is 0,01 mm.

1) At present at the stage of draft.

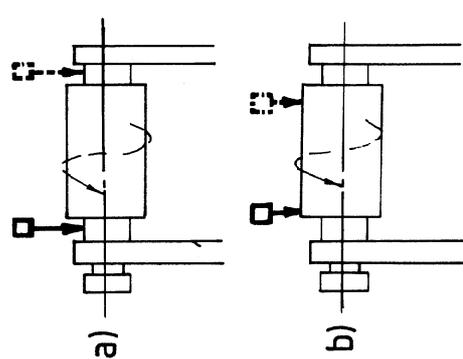
Reference	English	French
	Thickness planing machines with rotary cutterblock for one-side dressing	Machines à raboter sur une face avec outil rotatif
1	Framework	Ossature
1.1	Main frame	Bâti
2	Feed of workpiece and/or tools	Déplacement des pièces et/ou outils
2.1	Infeed feed roller	Cylindre d'entrée
2.2	Outfeed feed roller	Cylindre de sortie
2.3	Table roller	Cylindre de la table
2.4	Table extension roller	Cylindre de la rallonge de table
2.5	Infeed roller drive sprocket	Pignon du cylindre d'entrée
2.6	Outfeed roller drive sprocket	Pignon du cylindre de sortie
2.7	Feed roller drive chain	Chaîne d'entraînement des cylindres d'entrée
2.8	Speed reduction gearbox	Réducteur de vitesse
2.9	Variable speed gear	Variateur de vitesse
2.10	Tensioning idler sprocket	Pignon du tendeur de chaîne
3	Workpiece support clamp and guide	Support, maintien et guidage des pièces
3.1	Table	Table
3.2	Chain transmission for table rise and fall movement	Chaîne de transmission pour le réglage vertical et horizontal
3.3	Table extension	Rallonge de table
3.4	Table elevating screw	Vis de réglage vertical de la table
3.5	Infeed pressure bar	Presseur d'entrée
3.6	Outfeed pressure bar	Presseur de sortie
4	Tool-holders and tools	Porte-outils et outils
4.1	Blades	Lame
4.2	Cutterblock wedge	Coin de blocage de la lame
4.3	Cutterblock	Broche porte-outil
5	Workheads and tool drives	Unité de travail et son entraînement
5.1	Cutterblock bearing	Palier de roulement
6	Controls	Commandes
6.1	Starting switch	Commutateur
6.2	Table vertical adjustment	Réglage vertical de la table
6.3	Feed speed adjustment	Variateur de vitesse
6.4	Feed engagement lever	Débrayage de l'amenée
6.5	Table roller adjustment	Rouleaux de la table
6.6	Table vertical adjustment lock	Verrouillage de la table
7	Safety devices	Dispositifs de sécurité
7.1	Anti-kick-back fingers	Linguet antirecul
7.2	Depth cut limiter	Limiteur de passe
8	Miscellaneous	Divers
8.1	Hood	Capot
8.2	Access door to control gear	Porte d'accès aux organes mécaniques
8.3	Dust extraction outlet	Buse d'aspiration
8.4	Scale for thicknessing	Règle micrométrique
9	(clause free)	(chapitre libre)
10	Examples of work	Exemples de travail
10.1	Thicknessing	Rabotage

5 Acceptance conditions and permissible deviations — Geometrical tests

No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G1		<p>Checking of flatness of the table:</p> <ul style="list-style-type: none"> a) longitudinal straightness b) diagonal straightness c) transverse straightness 	<p>a) and b) 0,20 for $A \leq 1\ 000$ 0,30 for $A > 1\ 000$ c) 0,10 for $B \leq 400$ 0,15 for $400 < B \leq 1\ 000$ 0,20 for $B > 1\ 000$</p>	<p>Straightedge and feeler gauges</p>	<p>Clauses 5.212 and 5.322 For checking c), measure in two places each about 50 mm on either side of the cutterblock. Flat to convex.</p>
G2		<p>Measuring of run-out of the table rollers</p>	<p>0,15</p>	<p>Dial gauge</p>	<p>Clause 5.612.2 Checked at the ends and centre of each roller.</p>

No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G3		<p>Checking of parallelism of the table rollers to the table</p>	<p>0,10 for $B \leq 400$ 0,15 for $400 < B \leq 1\ 000$ 0,20 for $B > 1\ 000$</p>	<p>Straight edge and dial gauge</p>	<p>Clause 5.412.4</p>
G4		<p>Checking of parallelism of the table to the cutterblock in the upper and lower positions</p>	<p>0,10 for $B \leq 400$ 0,15 for $400 < B \leq 1\ 000$ 0,20 for $B > 1\ 000$</p>	<p>Dial gauge</p>	<p>Clause 5.412.4</p>

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No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G5		Measuring of run-out of the cutterblock	0,03	Dial gauge	<p>Clause 5.612.2</p> <p>a) Where the blade setting device is carried from the block shoulders, check on the shoulders.</p> <p>b) Where the blade setting device is carried from the cutterblock, check on the block.</p>

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Annex

Equivalent terms

Reference	German	Spanish	Italian	Swedish
	Dickenhobelmaschine mit Messerwelle für einseitige Bearbeitung	Regruesadora	Pialla a spessore	Planhyvel
1	Ständer	Armazón	Incastellatura	Stativkonstruktion
1.1	Gestell	Bastidor	Basamento	Stativ
2	Vorschub von Werkstück und/oder Werkzeug	Desplazamiento de las piezas y/o de los útiles	Spostamento dei pezzi e/o degli utensili	Matning av arbetsstycke och/eller verktyg
2.1	Einzugswalze	Rodillo de arrastre	Rullo di entrata	Inmatningsvals
2.2	Auszugswalze	Rodillo de salida	Rullo di uscita	Utmatningsvals
2.3	Dickentischwalze	Rodillo de la mesa	Rullo sul piano	Bordrulle
2.4	Stützwalze in der Tischverlängerung	Rodillo de la prolongación de la mesa	Rullo della prolunga del piano	Stödrulle på bordförlängning
2.5	Kettenritzel der Einzugswalze	Piñón del rodillo de arrastre	Pignone del rullo di entrata	Kedjehjul för inmatningsvals
2.6	Kettenritzel der Auszugswalze	Piñón del rodillo de salida	Pignone del rullo di uscita	Kedjehjul för utmatningsvals
2.7	Antriebskette für Vorschubwalzen	Cadena de transmisión de los rodillos de arrastre	Catena di azionamento dei rulli di avanzamento	Drivkedja för matarvalsar
2.8	Geschwindigkeits-reduziergetriebe	Caja reductora	Riduttore di velocità	Reduktionsväxel för matningshastighet
2.9	Geschwindigkeits-änderungsgetriebe	Variador de velocidad	Variatore di velocità	Steglös variator för matningshastighet
2.10	Kettenspannrad	Piñón para tensión de cadena	Pignone tendicatenas	Kedjesträckarhjul
3	Werkstückauflage, -halterung und -führung	Soporte, sujeción y guía de las piezas	Supporto, fissaggio e guida dei pezzi	Styrning av arbetsstycke
3.1	Tisch	Mesa	Piano	Bord
3.2	Kettentrieb zur Höhenverstellung des Tisches	Cadena de transmisión de elevación de la mesa	Catena di trasmissione per regolazione verticale	Kedjetransmission för bordets höjdställning
3.3	Tischverlängerung	Prolongación de la mesa	Prolunga del piano	Bordförlängning
3.4	Spindel für die Höhenverstellung des Tisches	Husillos de elevación de la mesa	Vite di regolazione del piano	Skruv för bordets höjdställning
3.5	Einzugsdruckbalken	Presor de entrada	Pressore di entrata	Tryckbalk på inmatningssidan
3.6	Auszugsdruckbalken	Presor de salida	Pressore di uscita	Tryckbalk på utmatningssidan
4	Werkzeugträger und Werkzeug	Porta-útil y útiles	Portautensili ed utensili	Verktyghållare och verktyg
4.1	Streifenhobelmesser	Cuchillas	Coltelli	Kutterstål
4.2	Messerkeilleiste	Cuñas de bloqueo de las cuchillas	Lardoni conici di bloccaggio dei coltelli	Kil för fasthållning av kutterstål
4.3	Hobelmesserwelle	Árbol porta-útil	Albero portacoltelli	Kutterblock
5	Einbauteile und Teile für den Werkzeugantrieb	Unidad de trabajo y su transmisión	Unità operatrice e suo azionamento	Bearbetningsenheter och drivsystem
5.1	Hobelmesserwellenlager	Soporte del rodamiento	Supporto dei cuscinetti	Kutterlager
6	Bedienungs- und Überwachungsorgane	Mandos	Comandi	Manöverorgan
6.1	Elektrischer Hauptschalter	Conmutador	Interruttore	Startdon
6.2	Höhenverstellung des Tisches	Mando de elevación de la mesa	Comando regolazione verticale	Ratt för bordinställning
6.3	Verstellung der Vorschubgeschwindigkeit	Mando del variador de velocidad	Comando regolazione della velocità di avanzamento	Reglage för matningshastighet
6.4	Vorschubbetätigung	Mando de desembrague	Comando disinnesto dell'avanzamento	Kopplingspak för matningen
6.5	Höhenverstellung der Dickentischwalzen	Mando de regulación del rodillo de la mesa	Comando regolazione rulli del piano	Inställningsdon för bordrulle
6.6	Tischblockierung	Mando de bloqueo de la mesa	Comando bloccaggio piano	Låsning av bordhöjd