
International Standard



7569

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

Woodworking machines — Planing machines for two-, three- or four-side dressing — Nomenclature and acceptance conditions

Machines à bois — Machines à raboter pour le travail sur deux, trois ou quatre faces — 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 7569 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 — Planing machines for two-, three- or four-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 planing machines for two-, three- or four-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 and Italian 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) and Italy (UNI). 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 planing machines for two-, three- or four-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 numbers 12.22, 12.23 and 12.24 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 horizontal cutterblocks, vertical spindle and other moving parts, and for a 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.

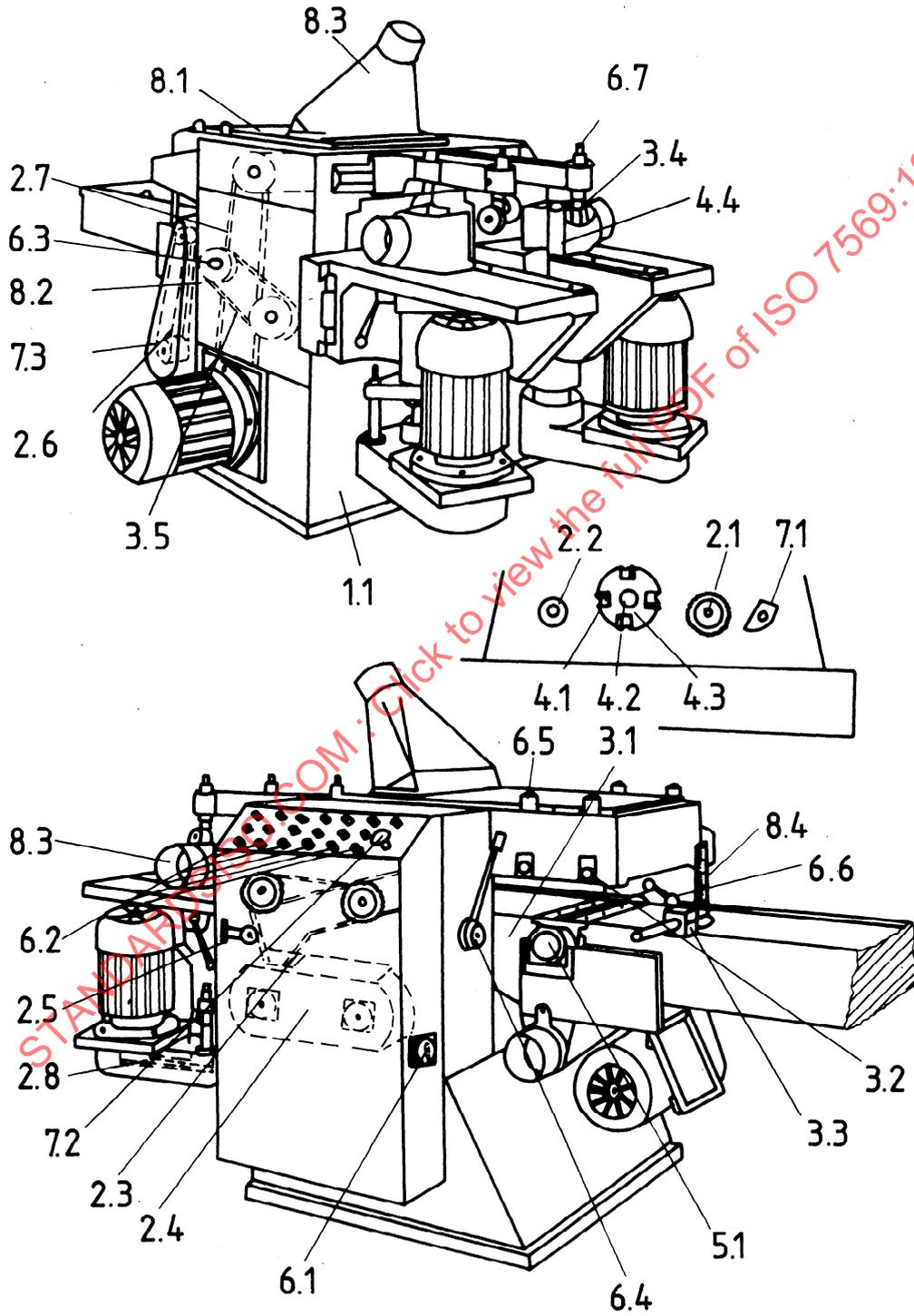
3.5 It is up to the user to choose, in agreement with the manufacturer, those tests relating to the properties which are of interest to him, but these tests shall be clearly stated when ordering a machine.

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.

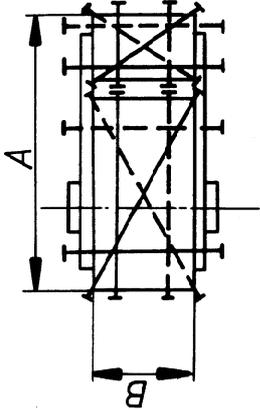
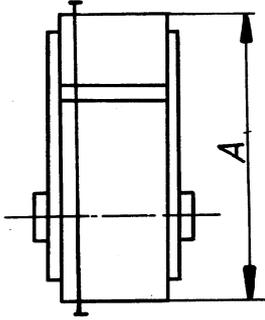
1) At present at the stage of draft.

4 Nomenclature

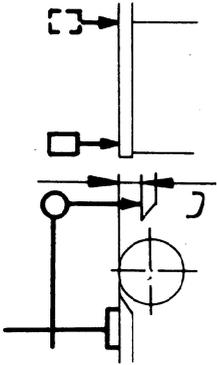
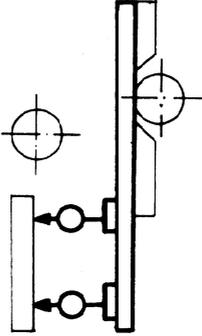
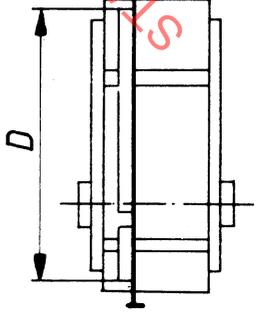


Reference	English	French
	Planing machines for two-, three- or four-side dressing	Machines à raboter pour le travail sur deux, trois ou quatre faces
1	Framework	Ossature
1.1	Main frame	Bâti
2	Feed of workpiece and/or tools	Déplacement des pièces et/ou outils
2.1	Infeed roller	Cylindre d'aménagement
2.2	Outfeed roller	Cylindre de sortie
2.3	Feed roller drive chain	Chaîne d'entraînement des cylindres d'aménagement
2.4	Variable speed gear	Réducteur de vitesse
2.5	Chain tensioner	Pignon du tendeur de chaîne
2.6	Belt drive for bottom spindle	Courroie d'entraînement de l'arbre inférieur
2.7	Belt drive for top spindle	Courroie d'entraînement de l'arbre supérieur
2.8	Belt drive for milling cutterblocks	Courroie d'entraînement des arbres porte-fraises
3	Workpiece support clamp and guide	Support, maintien et guidage des pièces
3.1	Table	Table
3.2	Feed roller	Rouleau d'entraînement
3.3	Lateral pressure	Presseur latéral
3.4	Vertical pressure	Presseur vertical
3.5	Transmission for table rise and fall movement	Chaîne de transmission du réglage vertical de la table
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 planing	Broche porte-outils
4.4	Cutterblock milling	arbre porte-fraise
5	Workheads and tool drives	Unité de travail et son entraînement
5.1	Cutterblock bearing	Palier de roulement
6	Controls	Commandes
6.1	Master switch	Commutateur général
6.2	Switches controlling each motor	Commutateur de commande de moteur individuel
6.3	Table vertical adjustment control	commande de réglage vertical de la table
6.4	Feed speed control	Commande du variateur de vitesse
6.5	Drive feed roller control	Commande de rouleaux d'entraînement
6.6	Lateral pressure control	Commande du presseur latéral
6.7	Vertical pressure control	Commande du presseur vertical
7	Safety devices (examples)	Dispositifs de sécurité (exemples)
7.1	Anti-kick-back fingers	Linguet antirecul
7.2	Emergency stop	Bouton d'arrêt d'urgence
7.3	Belt guard	Capot protège-courroie
8	Miscellaneous	Divers
8.1	Hood	Capot
8.2	Access door to control gear	Porte d'accès aux organes mécaniques
8.3	Dust extraction hood	Buse d'aspiration
8.4	Scale for depth of cut	Règle micrométrique
9	(clause free)	(chapitre libre)
10	Examples of work	Exemples de travail

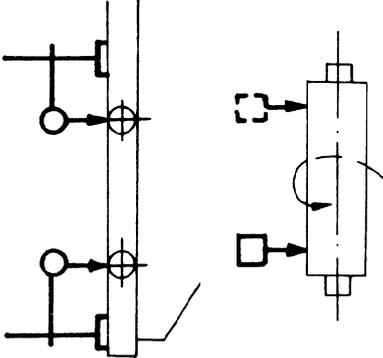
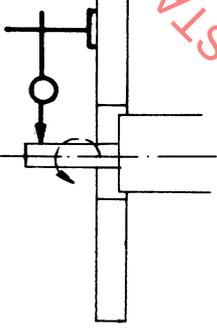
5 Acceptance conditions and permissible deviations — Geometrical tests

No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G1		<p>Checking of flatness of the tables:</p> <ul style="list-style-type: none"> a) longitudinal straightness b) diagonal straightness c) transverse straightness 	<p>a) and b) 0,20 for $A \leq 1\ 250$ 0,30 for $A > 1\ 250$</p> <p>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.</p>
G2		<p>Checking of longitudinal parallelism of the planes of the two tables</p>	<p>0,20 for $A \leq 1\ 250$ 0,30 for $A > 1\ 250$</p>	<p>Straightedge and feeler gauges</p>	<p>Flat to convex.</p>

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No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G3		<p>Checking of parallelism of lips of tables transversely</p>	<p>$C = 5$ 0,10</p>	<p>Dial gauge</p>	<p>Clause 5.412.2</p>
G4		<p>Checking of parallelism of the top pressure pad with respect to the main 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>Straightedge and dial gauge</p>	<p>Clause 5.412.4 * B is the width of tables.</p>
G5		<p>Checking of parallelism and straightness of the fences</p>	<p>0,10 for $D \leq 400$ 0,20 for $400 < D \leq 1\ 000$ 0,30 for $D > 1\ 000$</p>	<p>Straightedge and feeler gauges.</p>	

No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G6		<p>Checking of the parallelism of the horizontal cutterblocks with respect to the main table, checked with the main table in upper and lower positions</p>	<p>0,10 for $E < 400$</p> <p>0,20 for $E > 400$</p>	<p>Dial gauge</p>	<p>Clause 5.412.4</p>
G7		<p>Measuring of run-out of the horizontal cutterblocks</p>	<p>0,03</p>	<p>Dial gauge</p>	<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>

No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G8		Measuring of run-out of the table rollers	0,15	Dial gauge	Clause 5.612.2 Checked at the ends and centre of each roller.
G9		Measuring of run-out of the top of the vertical spindle	0,03	Dial gauge	Clause 5.612 Measure at the top of the spindle.

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