International Standard 7571

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

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

Machines à bois — Machines à dégauchir sur une face avec porte-outil cylindrique — Nomenclature et conditions de réception

First edition — 1986-11-15

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UDC 674.056 : 621.912.25 **Ref. No. ISO 7571-1986 (E)**

Descriptors : machine tools, woodworking machinery, planing machines, surface 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 7571 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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Printed in Switzerland

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

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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 surface planing machines with 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 surface planing machines with 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 12.211.1 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.

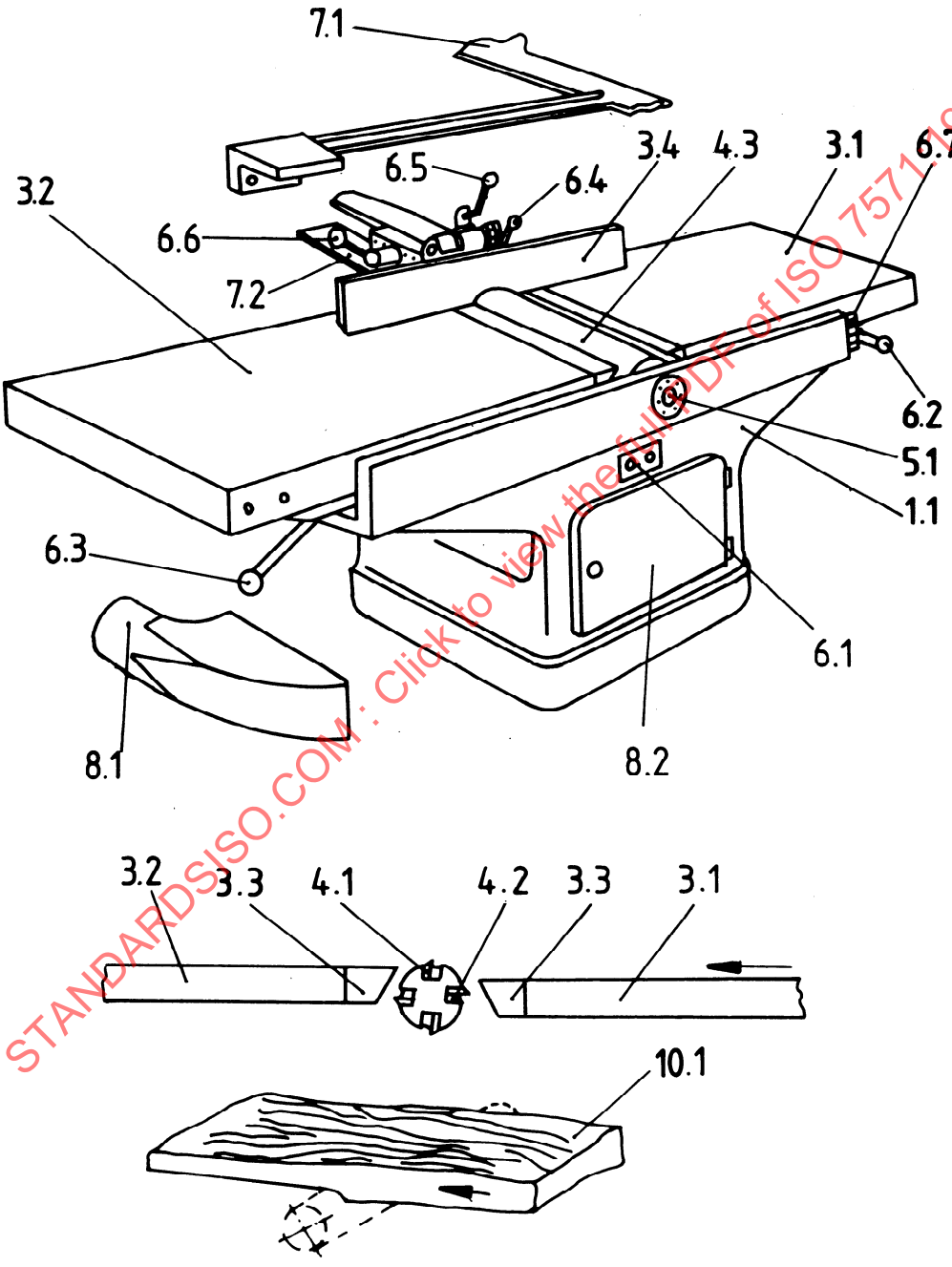
3.5 It is up to the user to choose, in agreement with the manufacturer, those tests relating to the properties which are of interest to him, but these tests shall be clearly stated when ordering a machine.

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.

4 Nomenclature



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Reference	English	French
	Surface planing machines with cutterblock for one-side dressing	**Machines à dégauchir sur une face avec porte-outil cylindrique à lames**
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	Infeed table	Table d'entrée
3.2	Outfeed table	Table de sortie
3.3	Table lip plates	Lèvres des tables
3.4	Canting fence	Guide inclinable
4	**Tool-holders and tools**	**Porte-outils et outils**
4.1	Blade	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	Bearing	Palier de roulement
6	**Controls**	**Commandes**
6.1	Starting switch	Commutateur
6.2	Infeed table vertical adjustment	Réglage vertical de la table d'entrée
6.3	Outfeed table vertical adjustment	Réglage vertical de la table de sortie
6.4	Fence canting adjustment	Réglage d'inclinaison du guide
6.5	Fence canting lock	Verrouillage de l'inclinaison du guide
6.6	Fence traverse lock	Verrouillage du déplacement du guide
6.7	Infeed table adjustment scale	Graduation du réglage micrométrique de la table d'entrée
7	**Safety devices**	**Dispositifs de sécurité**
7.1	Cutterblock guard (bridge type)	Protecteur du porte-outil
7.2	Cutterblock rear guard	Protecteur arrière du porte-outil
8	**Miscellaneous**	**Divers**
8.1	Dust extraction hood	Buse d'aspiration
8.2	Access door to control gear	Porte d'accès aux organes mécaniques
9	(clause free)	(chapitre libre)
10	**Examples of work**	**Exemples de travail**
10.1	Planing	Dégauchissage

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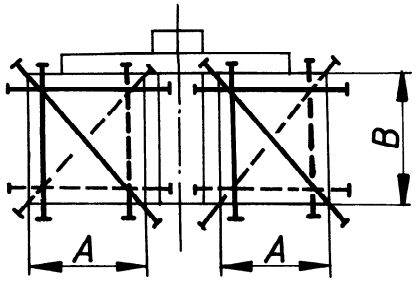
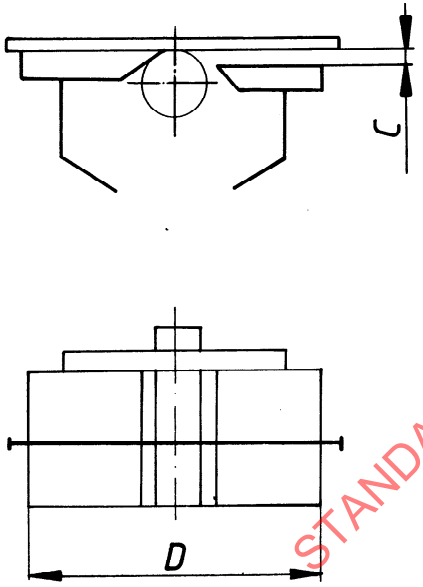
5 Acceptance conditions and permissible deviations — Geometrical tests

No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G1		Checking of flatness of the tables: a) longitudinal straightness b) diagonal straightness c) transverse straightness	a) and b) 0,10 for $A \leqslant 630$ 0,20 for $630 < A \leqslant 1\,250$ 0,30 for $A > 1\,250$ c) 0,10 for $B \leqslant 400$ 0,15 for $B > 400$	Straightedge and feeler gauge	Clauses 5.212 and 5.322
G2		Checking of parallelism of the two tables longitudinally	$C = 5$ 0,10 for $D \leqslant 1\,250$ 0,25 for $1\,250 < D \leqslant 2\,500$ 0,40 for $D > 2\,500$	Straightedge, slip gauges and feeler gauges	Flat to convex.

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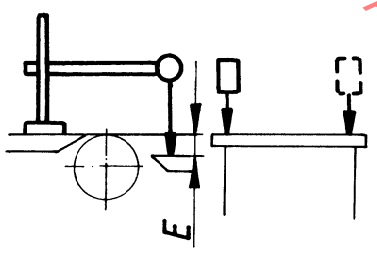
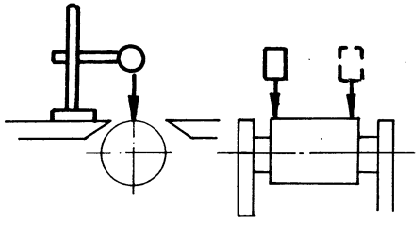
No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G3		Checking of parallelism of the lips of the tables transversely	E = 5 0,10	Dial gauge	Clause 5.412.2
G4		Checking of parallelism of the cutterblock to the rear table	0,10 where the blade setting device is not carried from the cutterblock 0,05 where the blade setting device is carried from the cutterblock	Dial gauge	Clause 5.412.4

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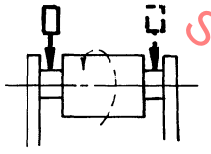
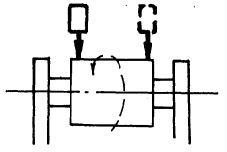
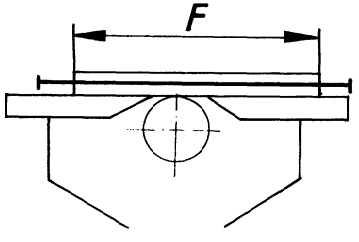
No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G5	a)  b) 	Measuring of run-out of the cutterblock	0,03	Dial gauge	Clause 5.612.2 a) Where the blade setting device is carried from the block shoulders, check on the shoulders. b) Where the blade setting device is carried from the cutterblock, check on the block.
G6		Checking of straightness of the canting fence	0,30 for $F \leqslant 800$ 0,40 for $F > 800$	Straightedge and feeler gauges	Clause 5.212

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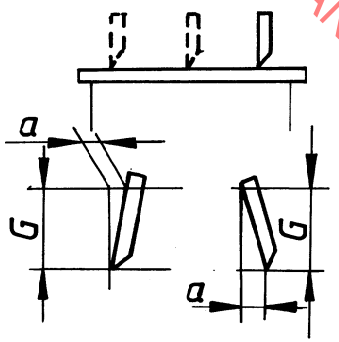
No.	Diagram	Object	Permissible deviations	Measuring instruments	Observations and references in ISO 230/1 test code
G7		Checking of squareness of the canting fence to the tables	a/G 0,10/100	Square and feeler gauges	

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