

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 716

VERIFICATION OF ROCKWELL B AND C SCALE

HARDNESS TESTING MACHINES

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BRIEF HISTORY

The ISO Recommendation R 716, *Verification of Rockwell B and C scale hardness testing machines*, was drawn up by Technical Committee ISO/TC 17, *Steel*, the Secretariat of which is held by the British Standards Institution (BSI).

Work on this question by the Technical Committee began in 1961 and led, in 1965, to the adoption of a Draft ISO Recommendation, which replaced Draft ISO Recommendation No. 522.

In March 1966, this Draft ISO Recommendation (No. 928) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies :

Argentina	Israel	Sweden
Austria	Italy	Switzerland
Belgium	Japan	Turkey
Canada	Korea, Rep. of	U.A.R.
Chile	Netherlands	United Kingdom
Czechoslovakia	New Zealand	U.S.A.
Denmark	Norway	U.S.S.R.
Finland	Portugal	Yugoslavia
France	Romania	
Germany	South Africa,	
Hungary	Rep. of	
India	Spain	

No Member Body opposed the approval of the Draft.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council which decided, in May 1968, to accept it as an ISO RECOMMENDATION.

VERIFICATION OF ROCKWELL B AND C SCALE HARDNESS TESTING MACHINES

1. SCOPE

This ISO Recommendation applies to the verification of testing machines for determining Rockwell hardness in accordance with ISO Recommendation R 80,* *Rockwell hardness test (B and C scales) for steel*.

It describes the indirect method which is suitable for machines in service, and the direct method which is suitable for the initial verification of new machines by the manufacturer and for the verification of rebuilt machines.

2. DIRECT VERIFICATION

Direct verification involves

- (a) verification of the load-applying mechanism (see clause 2.1),
- (b) verification of the indenter (see clause 2.2),
- (c) verification of the measuring device (see clause 2.3).

Before verification is carried out, certain details of the testing machine should be checked (see Annex A).

2.1 Verification of the load-applying mechanism

2.1.1 The verification of the load-applying mechanism at the required loads should be carried out either by means of standardized weights (masses) or by means of an elastic device or proving levers.

2.1.2 The preliminary load and each total load should be measured and, wherever possible, this should be done at not less than three positions of the plunger throughout its range of movement.

2.1.3 The loads should be measured by one of the following three methods :

- (a) balancing against standardized weights (masses) accurate to $\pm 0.1\%$;
- (b) balancing against a load, accurate to $\pm 0.2\%$, applied by means of standardized weights (masses) with mechanical advantage;
- (c) measuring the applied load by means of the deformation of an elastic device which has been previously calibrated to an accuracy of $\pm 0.2\%$.

2.1.4 Three readings should be taken for each load at each position of the plunger (see clause 2.1.2). Immediately before each reading is taken, the plunger should have been moved in the same direction as during testing.

* 2nd edition, 1968.

2.1.5 Each reading of the preliminary load before application and after removal of the additional load should be

$$10 \pm 0.2 \text{ kgf}$$

Each reading of the total load should be

$$150 \pm 0.9 \text{ kgf for a cone indenter (C scale),}$$

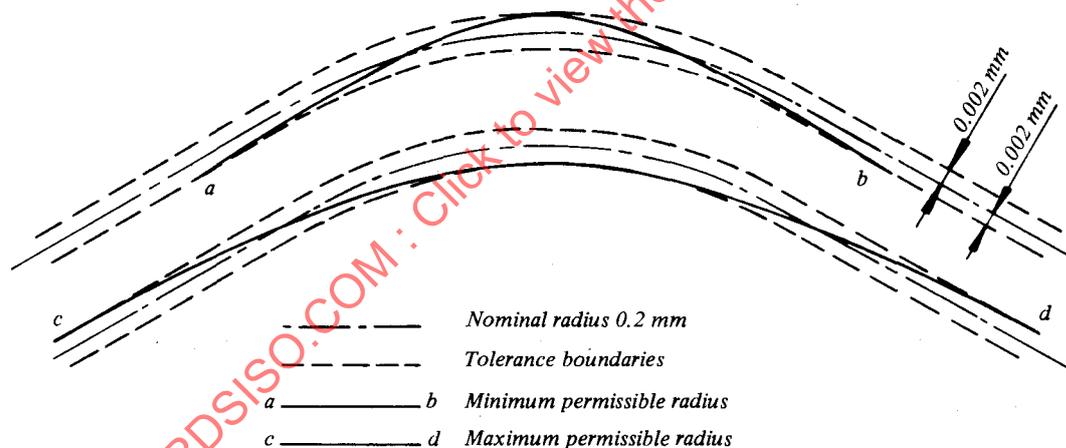
$$100 \pm 0.65 \text{ kgf for a ball indenter (B scale),}$$

2.2 Verification of the indenter (B and C scales)

2.2.1 C scale

2.2.1.1 The verification of the form of the diamond cone can be made by direct measurement or by measurement of its projection on a screen. The verification should be made at not less than four sections.

2.2.1.2 The diamond cone should have an included angle of $120 \pm 0.5^\circ$ and should have its axis in line with the axis of the indenter within 0.5° . The tip of the cone should be spherical with a radius equal to 0.200 mm. The contour of the whole of the tip should not depart by more than 0.002 mm from the theoretical profile (see Figure, below). The surface of the cone should blend in a truly tangential manner with the surface of the spherical tip.



FIGURE

2.2.1.3 The hardness values given by the testing machine do not depend only on the dimensions given in clause 2.2.1.2, but also on the surface roughness and the position of the crystallographic axes of the diamond, and the seating of the diamond in its holder.

For this reason, a performance test is considered necessary. The indenter should be used in a standardizing machine, in which the load applied and the measuring device can be verified by fundamental measurement.

An indenter should be rejected if, during the performance test, the hardness values obtained differ by more than 1 Rockwell unit (in the range 30 to 65 HRC) from those of the standardized blocks calibrated with an accepted indenter.

2.2.2 B Scale

2.2.2.1 For the purpose of verifying the size and hardness of the steel ball used in the indenter, it is considered sufficient to test a sample selected at random from a batch. The ball(s) tested for hardness should be discarded.

2.2.2.2 The balls should satisfy the following requirements :

- (a) the diameter, when measured at not less than three positions, should not differ from the nominal diameter by more than 0.0035 mm (0.00015 in);*
- (b) the Vickers hardness of the balls should not be less than 850 HV 10 when measured in accordance with ISO Recommendation R 81,** *Vickers hardness test for steel*, and applying the appropriate correction for curvature as given in ISO Recommendation R 409, *Table of Vickers hardness values (HV) for metallic materials*. The maximum value of the mean diagonal of the indentation made with a Vickers indenter at 10 kgf is therefore 0.141 mm for a 1.5875 mm (1/16 in) ball.

2.3 Verification of the measuring device

The depth-measuring device should be verified over not less than three ranges, including the ranges corresponding to the lowest and highest hardnesses for which the scales are normally used, by making known incremental movements of the indenter. The depth-measuring device should correctly indicate within ± 0.001 mm, i.e. within ± 0.5 of a scale unit, over each range.

3. INDIRECT VERIFICATION

Indirect verification is carried out by means of standardized blocks calibrated in accordance with ISO Recommendation R 674, *Calibration of standardized blocks to be used for Rockwell B and C scale hardness testing machines*.

Before verification is carried out, certain details of the testing machine should be checked (see Annex A).

3.1 On each standardized metal block five indentations should be made and the hardness number observed to approximately 0.2 of a scale unit. Before making these indentations, at least two preliminary indentations should be made to ensure that the machine is working freely and that the standardized block, the indenter and the anvil are seating correctly. The results of these preliminary indentations should be ignored. The tests should be made in accordance with ISO Recommendation R 80.***

3.2 For special purposes a hardness testing machine may be verified at one hardness value corresponding approximately to the tests to be made, but for general verification of a testing machine the following procedure should be adopted :

3.2.1 *B Scale*. The testing machine should be verified using standardized blocks having hardnesses within each of the following hardness ranges :

40 to 60 HRB,
80 to 100 HRB.

If the testing machine is to be used for determining Rockwell B hardness numbers less than 40, the machine should be verified using standardized blocks having a hardness approximately equal to that of the articles to be tested.

* This tolerance corresponds to Grade 6 of the ISA System (ISA Bulletin 25). Balls for ball bearings will normally satisfy this tolerance.

** 2nd, edition, 1967.

*** 2nd edition, 1968.

3.2.2 *C Scale*. The testing machine should be verified using standardized blocks having hardnesses within each of the following hardness ranges :

20 to 30 HRC,

35 to 55 HRC,

59 to 65 HRC.

4. REPEATABILITY AND ERROR

For each standardized block, let e_1, e_2, \dots, e_5 be the values of the measured increase in depth of indentation, arranged in increasing order of magnitude, where "e" is in units of 0.002 mm as defined in ISO Recommendation R 80.*

4.1 Repeatability

The repeatability of the testing machine under the particular verification conditions is determined by the following quantity :

$$e_5 - e_1$$

4.2 Error

The error of the testing machine under the particular verification conditions is expressed by the following quantity :

$$\bar{H} - H$$

where

$$\bar{H} = \frac{H_1 + H_2 + \dots + H_5}{5}$$

H_1, H_2, \dots, H_5 are the hardness values corresponding to e_1, e_2, \dots, e_5 ,

H is the specified hardness of the standardized block.

5. ASSESSMENT OF VERIFICATION

5.1 Repeatability

The repeatability of the testing machine verified is not considered satisfactory unless the repeatability at each hardness at which the machine is verified is

- for the C scale, less than 3 %,
- for the B scale, less than 6 %,

of the mean value of the increase of depth of indentation used to determine the hardness value (see Appendix).

5.2 Error

The error of the testing machine verified should not be more than the following values :

Scale	Hardness range of standardized block Rockwell hardness HR	Maximum permissible error HR
HRB	40 to 60	± 3
	80 to 100	± 2
HRC	20 to 30	± 2
	35 to 55	± 2
	59 to 65	± 1.5

NOTE. – The values of the maximum permissible errors quoted should be considered as tentative and may be reduced when more experience has been gained.

* 2nd edition, 1968.