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Woodworking machines – Slot mortising machines – Nomenclature and acceptance conditions

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Träbearbetningsmaskiner – Långhålsborrmaskiner – Terminologi och acceptanskontroll

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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 7946 was prepared by Technical Committee ISO/TC 39, *Machine tools*.

Woodworking machines — Slot mortising machines — Nomenclature and acceptance conditions

1 Scope and field of application

This International Standard specifies the nomenclature appropriate to each part of the machine and, with reference to ISO/R 230, the geometrical tests for slot mortising machines, 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 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 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 slot mortising machines, 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 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 main 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.

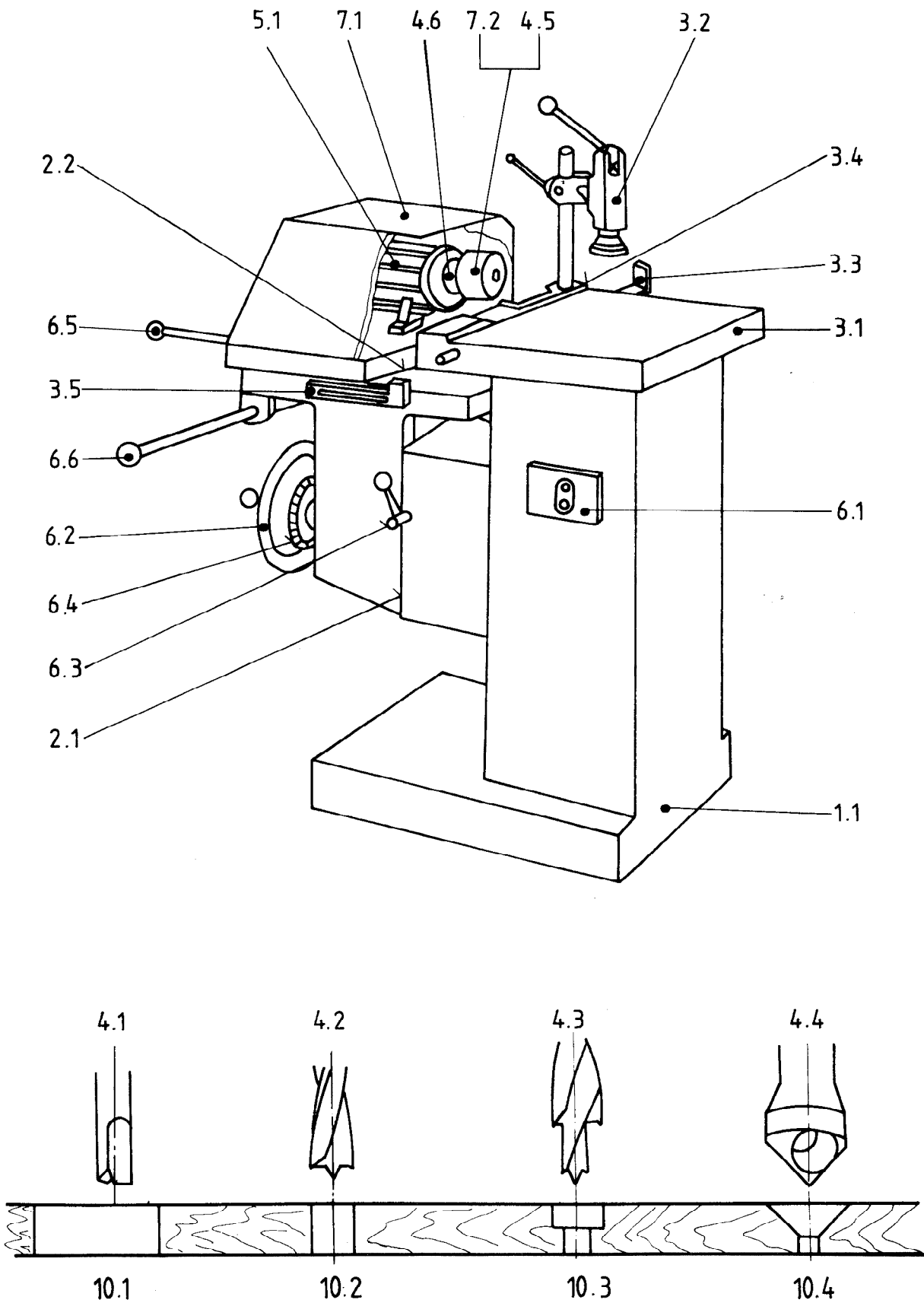
3.5 It is up to the user to choose, in agreement with the manufacturer, those tests relating to the properties which are of interest to him, but these tests are to be clearly stated when ordering a machine.

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.

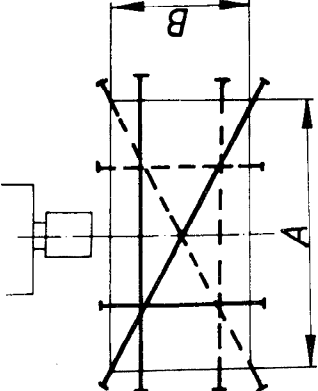
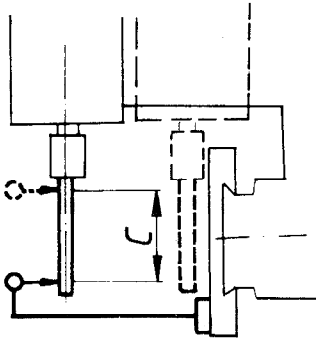
ISO 7946-1985 (E)

4 Nomenclature



Reference	English	French
	Slot mortising machine	Mortaiseuse à mèche simple
1	Framework	Ossature
1.1	Main frame	Bâti
2	Feed of workpiece and/or tools	Déplacement des pièces et/ou outils
2.1	Vertical adjustment slide	Glissière de déplacement vertical de la tête porte-outils
2.2	Infeed slide	Glissière de déplacement horizontal de la tête porte-outils
3	Workpiece support clamp and guide	Support, maintien et guidage des pièces
3.1	Table	Table
3.2	Workpiece clamp	Presscur
3.3	End stop	Guide latéral
3.4	Front fence	Guide longitudinal
3.5	Depth stop	Butée de profondeur de mortaise
4	Toolholders and tools	Porte-outils et outils
4.1	Mortise bit	Outil de mortaisage
4.2	Boring bit	Outil de perçage
4.3	Counterbore	Mèche étagée
4.4	Countersink	Mèche conique
4.5	Chuck	Mandrin
4.6	Spindle	Broche
5	Workheads and tool drives	Unité de travail et son entraînement
5.1	Cutterhead motor	Moteur
6	Controls	Commandes
6.1	Stop/start switch	Commutateur
6.2	Handwheel for vertical adjustment	Commande de réglage vertical du porte-outils
6.3	Vertical adjustment lock	Commande de verrouillage du réglage vertical du porte-outils
6.4	Vertical adjustment scale	Règle graduée du réglage vertical du porte-outils
6.5	Cross traverse lever	Levier de course transversale
6.6	Infeed lever	Levier de pénétration
7	Safety devices (examples)	Dispositifs de sécurité (exemples)
7.1	Cutterhead guard	Capot du moteur
7.2	Chuck guard	Protecteur de mandrin
8	Miscellaneous	Divers
9	Free	Libre
10	Examples of work	Exemples de travail
10.1	Slot mortising	Mortaisage
10.2	Boring	Perçage
10.3	Counter boring	Perçage étagé
10.4	Counter sinking	Perçage conique

5 Acceptance conditions and permissible deviations — Geometrical tests

No.	Diagram	Object	Permissible deviation	Measuring instruments	Observations and references in test code ISO/R 230
G1	 <p data-bbox="644 1615 703 1845"> A = length of the table B = width of the table </p>	Checking of flatness of the table : a) longitudinal straightness b) transverse straightness c) diagonal straightness	a) and c) 0,20 for $A < 630$ 0,40 for $A > 630$ b) 0,10 for $B < 200$ 0,15 for $B > 200$	Straightedge and feeler gauges	Clause 5.322
G2		Checking of parallelism of the spindle axis (in the upper and lower position) to the table surface	0,20 for $C = 150$	Dial gauge and test mandrel	Clause 5.412.4