

Second edition
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Machine tools — Test conditions for bridge-type milling machines — Testing of the accuracy —

Part 1: Fixed bridge (portal-type) machines

*Machines-outils — Conditions d'essai des machines à fraiser à portique —
Contrôle de la précision —*

Partie 1: Machines à portique fixe



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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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this part of ISO 8636 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 8636-1 was prepared by Technical Committee ISO/TC 39, *Machine tools*, Subcommittee SC 2, *Test conditions for metal cutting machine tools*.

This second edition cancels and replaces the first edition (ISO 8636-1:1987) of which it constitutes a technical revision. Especially,

- a) geometrical tests have been re-arranged; the new G numbers compared to the old ones are given in the following table:

ISO 8636-1:1999	6	7	8	9	10	11	12	13	14	15	16
ISO 8636-1:1987	9	6	5	1	4&7	3	14	13&15	16	12	11

- b) the following extra modifications:

addition of notes in "Object" boxes for G6, G12, G13, G14 and G15; these notes have been added because the machines have several milling heads and the test items are applicable to all of the milling heads;

- c) tolerances on accuracy and repeatability of positioning have been changed according to ISO 230-2:1997.

The actual deviations of all parameters shall be shown as test results, but the tolerances are limited only to certain parameters.

ISO 8636 consists of the following parts, under the general title *Machine tools — Test conditions for bridge-type milling machines — Testing of the accuracy*:

- *Part 1: Fixed bridge (portal-type) machines*
- *Part 2: Travelling bridge (Gartry-type) machines*

Annex A of this part of ISO 8636 is for information only.