
INTERNATIONAL STANDARD



2772/II

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

Test conditions for box type vertical drilling machines — Testing of the accuracy — Part II : Practical test

Conditions d'essais des machines à percer verticales à montant ou «perceuses-aléseuses» — Contrôle de la précision — Partie II : Épreuve pratique

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FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up 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.

International Standard ISO 2772/II (originally Draft International Standard ISO/DIS 3020) was drawn up by Technical Committee ISO/TC 39, *Machine-tools*, and circulated to the Member Bodies in March 1972.

It has been approved by the Member Bodies of the following countries :

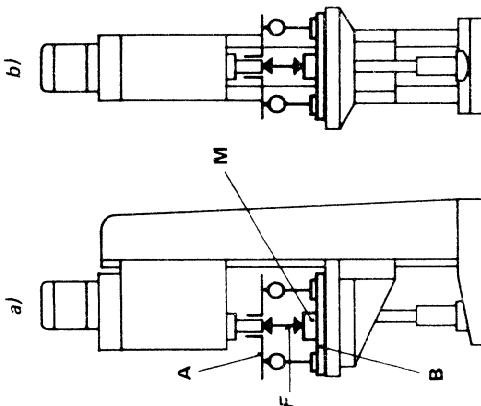
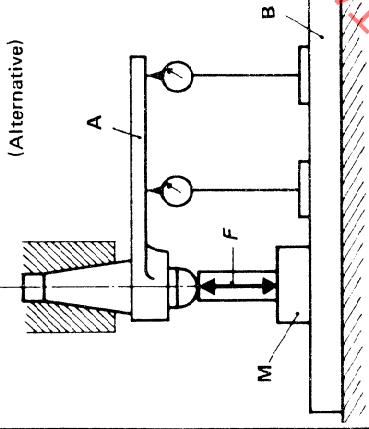
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No Member Body expressed disapproval of the document.

Test conditions for box type vertical drilling machines – Testing of the accuracy – Part II : Practical test

1 SCOPE AND FIELD OF APPLICATION

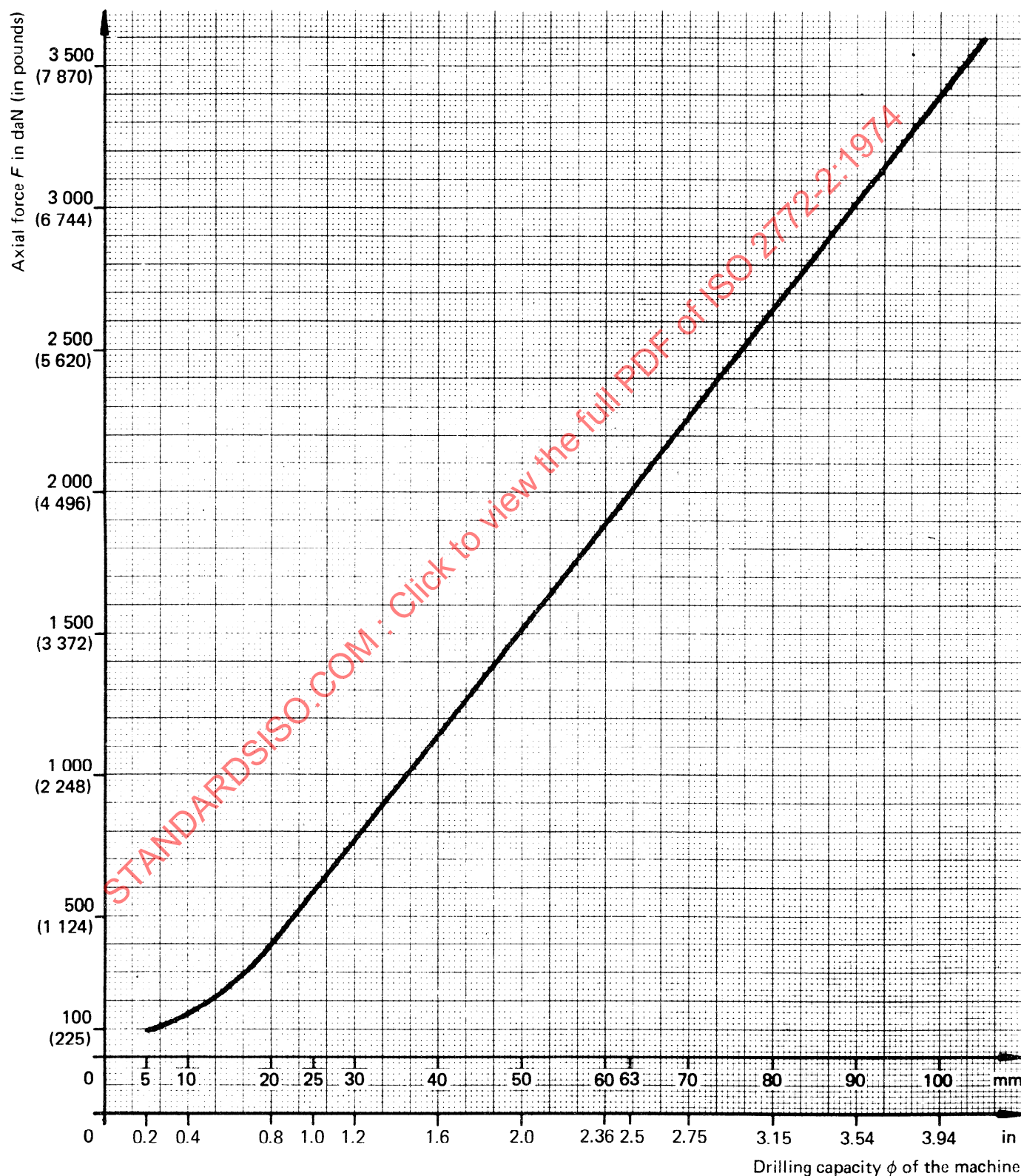
This International Standard specifies the practical test to be carried out for checking box type vertical drilling machines and is a continuation of ISO 2772/I, *Test conditions for box type vertical drilling machines – Testing of the accuracy – Part I : Geometrical tests*.

No.	Diagram	Nature of test	Permissible deviation		Measuring instruments	Observations and references to the test code ISO/R 230
			mm	in		
P1		Measurement of deflection of the spindle axis from its position square with the table under an axial force applied to the spindle : a) in the plane of symmetry of the machine; b) in the plane perpendicular to the plane of symmetry of the machine.	1/1 000		Special equipment	It is unnecessary to follow the test code ISO/R 230. A drilling test shall not be carried out but an axial force F shall be exerted on the spindle nose, using the table surface as a support. The application of force F and the measurement of the deflection under load of the axis of the spindle in relation to the table surface shall be made directly on the spindle nose with the aid of special equipment A mounted directly on the spindle nose. The base B of the load cell shall be of sufficient area and rigidity to eliminate any deformation of the table. The value of force F to be exerted shall be specified by the manufacturer. In the absence of a specified load, reference shall be made to the graph given in the annex to determine the load as a function of the drilling capacity of the machine. Spindle retracted. Spindle head, table, cross slide and knee shall be locked in mid-position on their respective slideways. A calibration sheet of the test instrument M should be supplied.
			0,04/40			

ANNEX

**GRAPH GIVING THE AXIAL FORCE F AS A FUNCTION OF THE DRILLING
CAPACITY ϕ OF THE MACHINE**

NOTE — This graph **only gives typical values** representing average thrusts when drilling medium steel (Tensile strength $R = 0,55$ to $0,65$ GPa*) with freshly sharpened drills.



NOTE — For $\phi > 25$ mm (1 in), the graph is approximately rectilinear.

* Provisional value : $R = 55$ to 65 hbar.

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