

ISO 10791-6:2014-12 (E)

Test conditions for machining centres - Part 6: Accuracy of speeds and interpolations

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Preliminary remarks	2
4.1	Measurement units	2
4.2	Reference to ISO 230-1 and ISO 230-4	2
4.3	Testing sequence	2
4.4	Tests to be performed	2
4.5	Measuring instruments	2
4.6	Diagrams	2
4.7	Position of axes not under test	2
4.8	Software compensation	3
5	Kinematic tests	3
5.1	General	3
5.1.1	Tests described in Annexes A to C	3
5.1.2	Alternative tests in Annexes A and C	3
5.2	Spindle speeds and feed speeds	4
5.3	Linear interpolation motion	7
5.4	Circular interpolation motion	9
Annex A (normative) Kinematic tests for machines with two rotary axes in the spindle head		11
Annex B (normative) Kinematic tests for machines with two rotary axes in the workpiece side		23
Annex C (normative) Kinematic tests for machines with a swivel head and/or a rotary table		34
Annex D (informative) Precautions for test setup for Annexes A to C		44
Bibliography		50