

ISO/TR 230-11:2018-04 (E)

Test code for machine tools - Part 11: Measuring instruments suitable for machine tool geometry tests

Contents		Page
Foreword		v
Introduction		vi
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Preliminary remarks	5
4.1	Measuring units	5
4.2	Uncertainty of measuring instrument	5
4.2.1	General	5
4.2.2	Environment factors	7
4.2.3	Measuring equipment factors	9
4.2.4	Setup and procedure factors	11
4.2.5	Software and calculation factors	17
4.3	Measuring equipment calibration (ISO 10012)	17
4.3.1	General	17
4.3.2	Manufacturer and supplier of measuring instruments	18
4.3.3	User of measuring instruments	18
4.3.4	Measurement uncertainty	18
4.4	Comparison of measurement results by instruments using different measurement principles	18
5	Description of measuring instruments	19
6	Mechanical artefacts for general use	20
6.1	General	20
6.2	Reference straightedge	23
6.3	Test mandrels with taper shanks	27
6.4	Mandrels between centres	32
6.5	Reference squares	34
6.6	Reference cube	36
6.7	Surface plates	37
6.8	Reference sphere	38
6.9	1D ball array	39
6.10	2D ball array	42
6.11	Step gauge	43
6.12	Gauge block	44
7	Length and displacement measuring instruments	45
7.1	General	45
7.2	Instruments for large and medium range linear displacements	46
7.2.1	Laser interferometer	46
7.2.2	Reference linear scale	49
7.2.3	Standard scale	50
7.3	Instruments for short range linear displacements	51
7.3.1	Contact-type sensors	51
7.3.2	Non-contact sensors	55

7.3.3	Contact probing system	60
8	Straightness measuring devices	63
8.1	General	63
8.2	Taut wire with optical reading device	64
8.3	Laser interferometer with straightness optics	66
8.4	Alignment telescope	67
8.5	Two planes laser scanning device	70
8.6	Alignment laser	71
9	Squareness measuring devices	72
9.1	General	72
9.2	Laser interferometer with squareness and straightness optics	73
9.3	Index table with straightedge	74
9.4	Three planes laser scanning device	76
10	Flatness measuring devices	77
10.1	General	77
10.2	Sweep optical square	78
10.3	Laser interferometer with angular optics	80
10.4	Single plane laser scanning device	81
11	Angle measuring instruments	82
11.1	General	82
11.2	Level	83
11.2.1	Precision level	83
11.2.2	Electronic level	84
11.2.3	Inclinometer	85
11.3	Autocollimators	86
11.3.1	Autocollimator	86
11.3.2	Photo-electric autocollimators	87
11.3.3	Laser autocollimators	88
11.4	Laser interferometer with angular optics	89
11.5	Reference indexing table with optical angle reading device	90
11.6	Optical polygon with optical reading device	91
11.7	Laser assisted index device	92
11.8	Reference angle encoders	93
12	Special purpose instruments	94
12.1	General	94
12.2	Single dimensional position reading device	94
12.2.1	Telescoping ball bar	94
12.2.2	Long range telescoping ball bar	96
12.2.3	Fibre interferometer	97
12.3	Multi-dimensional position reading device	98
12.3.1	Two-dimensional digital scale	98
12.3.2	Laser tracing system	99
12.3.3	3D-probe for spheres (contact type)	100
12.3.4	3D-probe head, non-contact type	101
12.4	Other position reading device	103
12.4.1	Spindle error test equipment	103
12.4.2	Swivelling angle measuring device	104
13	Special application examples of the instruments	105
13.1	Spindle rotation accuracy measurement	105
13.2	Thermal displacement measurements	105
13.3	Tool position set	105
13.4	Workpiece positioning	105
	Annex A (informative) Checking devices for instruments in the workshop	106

Annex B (informative) Existing ISO and national standards for measuring equipment (2015) 112
Annex C (informative) Special caution for supporting system of measuring devices 113
Annex D (informative) Reference table of uncertainty contributor 115
Bibliography 126