

ISO 14955-4:2019 (E)

Machine tools — Environmental evaluation of machine tools — Part 4: Principles for measuring metal-forming machine tools and laser processing machine tools with respect to energy efficiency

Contents

	Foreword
	Introduction
1	Scope
2	Normative references
3	Terms and definitions
4	Operating states for measurement procedure
4.1	Operating state OFF
4.2	Operating state MAIN SWITCH ON
4.3	Operating state AUXILIARY DRIVES ON
4.4	Operating state MAIN DRIVES ON
4.5	Operating state READY TO RUN IN PRODUCTION MODE
4.6	Operating state PROCESSING
4.7	Operating state TOOL CHANGE
4.8	Typical result of power measurement
5	Evaluation of energy supplied to different types of machine tools
5.1	General
5.2	Energy supplied to presses
5.2.1	General
5.2.2	System boundary
5.2.3	Shift regime
5.2.4	Minimum measuring period
5.2.5	Typical press cycle diagram
5.2.6	Reference and test cycle for hydraulic (servo) presses in PROCESSING
5.2.7	Reference and test cycle for mechanical (servo) presses in PROCESSING
5.2.8	Use of spacers instead of a die during test-run
5.3	Energy supplied to press brakes
5.3.1	General
5.3.2	System boundary
5.3.3	Shift regime
5.3.4	Minimum measuring period
5.3.5	Typical press brake cycle diagram
5.3.6	Reference and test cycle of hydraulic (servo)/mechanical (servo) press brake in operating-state PROCESSING
5.4	Energy supplied to pipe benders
5.4.1	General
5.4.2	System boundary
5.4.3	Shift regime
5.4.4	Minimum measuring period
5.4.5	Test cycle
5.5	Energy supplied to turret punch presses
5.5.1	General
5.5.2	System boundary
5.5.3	Shift regime
5.5.4	Minimum measuring period
5.5.5	Reference and test cycle for turret punch presses in operating state PROCESSING
5.6	Energy supplied to laser processing machine tools

- 5.6.1 General
- 5.6.2 System boundary
- 5.6.3 Shift regime
- 5.6.4 Minimum measuring period
- 5.6.5 Reference and test cycle for laser processing machine tools in operating state
- PROCESSING
- 5.7 Energy supplied to auxiliary devices
- 5.7.1 System boundary
- 5.7.2 Shift regime
- 5.7.3 Pneumatic energy and heat exchange measurement

6 Reporting

Annex A (informative) Hydraulic presses

- A.1 Example of a downstroking hydraulic press (double action press)
- A.2 Power measurement
 - A.2.1 Power measurement at slide
 - A.2.1.1 Hydraulic presses
 - A.2.1.1.1 General
 - A.2.1.1.2 Power during rest in TDC (MT activity 1)
 - A.2.1.1.3 Power during slide descent (MT activity 2 to 4)
 - A.2.1.1.4 Power during decompression (MT activity 5)
 - A.2.1.1.5 Power during slide return (MT activity 6)
 - A.2.1.2 Hydraulic servo presses
 - A.2.1.2.1 General
 - A.2.1.2.2 Power during rest in TDC (MT activity 1)
 - A.2.1.2.3 Power during slide descent (MT activity 2 to 4)
 - A.2.1.2.4 Power during decompression (MT activity 5)
 - A.2.1.2.5 Power during slide return (MT activity 6)
 - A.2.2 Power measurement at die cushion
 - A.2.2.1 Die cushion without energy recovery
 - A.2.2.2 Die cushion with energy recovery
- A.3 Formulae for energy calculation for a hydraulic press cycle (downstroking press)
- A.3.1 General
- A.3.2 Machine tool activity 1: Slide is waiting in TDC for start signal while die is loaded
- A.3.3 Machine tool activity 2: Slide close
- A.3.4 Machine tool activity 3: Forming
- A.3.5 Machine tool activity 4: Embossing
- A.3.6 Machine tool activity 5: Decompression
- A.3.7 Machine tool activity 6: Slide return
- A.3.8 Machine tool activity 6a: Workpiece ejection
- A.4 Quantitative functional mapping for a hydraulic double action press

Annex B (informative) Mechanical presses

- B.1 Example of a downstroking mechanical press (double action press)
- B.2 Power measurement
 - B.2.1 Power measurement at slide
 - B.2.1.1 General
 - B.2.1.2 Power during rest in TDC (MT activity 1)
 - B.2.1.3 Power during slide close (MT activity 2)
 - B.2.1.4 Power during forming and embossing (MT activity 3 and 4)
 - B.2.1.5 Power during decompression (MT activity 5)
 - B.2.1.6 Power during slide return (MT activity 6)
 - B.2.2 Power measurement at die cushion
 - B.2.2.1 Die cushion without energy recovery
 - B.2.2.2 Die cushion with energy recovery
- B.3 Formulae for energy calculation for a mechanical press cycle (downstroking press)
- B.3.1 General
- B.3.2 Machine tool activity 1: Slide is waiting in TDC for start signal while die is loaded
- B.3.3 Machine tool activity 2: Slide close
- B.3.4 Machine tool activity 3: Forming
- B.3.5 Machine tool activity 4: Embossing
- B.3.6 Machine tool activity 5: Decompression
- B.3.7 Machine tool activity 6: Slide return

- B.3.8 Machine tool activity 6a: Workpiece ejection
- B.4 Quantitative functional mapping for a mechanical double action press

Annex C (informative) Hydraulic press brakes

- C.1 Example of a hydraulic press brake
- C.2 Power measurement at a hydraulic press brake
 - C.2.1 General
 - C.2.2 Power during rest in TDC (MT activity 1)
 - C.2.3 Power during slide descent (MT activity 2 to 4)
 - C.2.4 Power during decompression (MT activity 5)
 - C.2.5 Power during beam return (MT activity 6)
- C.3 Formulae for energy calculation for a hydraulic press brake cycle (downstroking press)
 - C.3.1 General
 - C.3.2 Machine tool activity 1: Beam is waiting in TDC for start signal while die is loaded
 - C.3.3 Machine tool activity 2: Beam close
 - C.3.4 Machine tool activity 3: Bending
 - C.3.5 Machine tool activity 4: Pressing
 - C.3.6 Machine tool activity 5: Decompression
 - C.3.7 Machine tool activity 6: Beam return
- C.4 Quantitative functional mapping for hydraulic press brakes

Annex D (informative) Turret punch presses

- D.1 Example of a servo punching press
- D.2 Power measurement at a turret punch press
 - D.2.1 General
 - D.2.2 Power for standby (MT activity 1)
 - D.2.3 Power for die positioning (MT activity 2)
 - D.2.4 Power for workpiece positioning (MT activity 3)
 - D.2.5 Power for punching (MT activity 4)
- D.3 Formulae for energy calculation for a servo punching press
 - D.3.1 General
 - D.3.2 Machine tool activity 1: Standby
 - D.3.3 Machine tool activity 2: Die positioning
 - D.3.4 Machine tool activity 3: Workpiece positioning
 - D.3.5 Machine tool activity 4: Punching
- D.4 Quantitative functional mapping for a servo punching press

Annex E (informative) Laser processing machine tools

- E.1 Example of a laser processing machine tool
- E.2 Power measurement at a flying optics laser processing machine tool
 - E.2.1 General
 - E.2.2 Power for standby (MT activity 1)
 - E.2.3 Power for X-axis and Y-axis positioning (MT activity 2)
 - E.2.4 Power for Z-axis descent and return (MT activity 3 and 7)
 - E.2.5 Power for piercing (MT activity 4)
 - E.2.6 Power for shifting mode to cutting (MT activity 5)
 - E.2.7 Power for cutting (MT activity 6)
- E.3 Formulae for energy calculation for a laser processing machine tool
 - E.3.1 General
 - E.3.2 Machine tool activity 1: Standby
 - E.3.3 Machine tool activity 2: X-axis and Y-axis positioning
 - E.3.4 Machine tool activity 3: Z-axis descent and return
 - E.3.5 Machine tool activity 4: Piercing
 - E.3.6 Machine tool activity 5: Shifting mode to cutting
 - E.3.7 Machine tool activity 6: Cutting
- E.4 Quantitative functional mapping for a laser processing machine tool

Annex F (informative) Pipe bender

- F.1 Example of a pipe bender
- F.2 Power measurement at an all-electric pipe bender
 - F.2.1 General
 - F.2.2 Power for standby (MT activity 1)
 - F.2.3 Energy for pipe loading (MT activity 2)
 - F.2.4 Power for pipe clamping (MT activity 3)

- F.2.5** Power for pipe positioning (MT activity 4)
- F.2.6** Power for pipe bending (MT activity 5)
- F.3** Equations for energy calculation for an all-electric pipe bender
 - F.3.1** General
 - F.3.2** Machine tool activity 1: Standby
 - F.3.3** Machine tool activity 2: Pipe loading
 - F.3.4** Machine tool activity 3: Pipe clamping
 - F.3.5** Machine tool activity 4: Pipe positioning
 - F.3.6** Machine tool activity 5: Pipe bending
- F.4** Quantitative functional mapping for an all-electric pipe bender

Page count: 100