

ISO 19744:2020-02 (E)

Test conditions for numerically controlled broaching machines - Testing of accuracy - Vertical surface type broaching machines

Contents	Page
Foreword	iv
Introduction	v
1 Scope	1
2 Normative references	1
3 Terms and definitions	2
4 Terminology and designation of axes	2
5 Preliminary remarks	4
5.1 Measurement units.....	4
5.2 Reference to the ISO 230 series.....	4
5.3 Testing sequence.....	5
5.4 Tests to be performed.....	5
5.5 Tolerances and minimum tolerance.....	5
5.6 Measuring instruments.....	5
5.7 Diagrams.....	5
5.8 Software compensation.....	6
5.9 Axes not under test.....	6
6 Geometric tests	7
6.1 Straightness errors of linear motions.....	7
6.2 Squareness/Parallelism errors between linear/rotary motions.....	8
6.3 Table and work holding rotary axis.....	16
6.4 Broach holder.....	18
7 Accuracy and repeatability of positioning tests	25
7.1 Positioning of numerically controlled linear axes.....	25
7.2 Positioning of numerically controlled rotary axes.....	27
8 Machining tests	29
Annex A (informative) Terms in other languages	30
Annex B (informative) Recommended tests for surface broaching operation	31
Bibliography	44