

ICS 25.060.20

CCS J 52



**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 23291-2009

**Machine tools -- Test conditions for self-centering,
manually-operated chucks with one-piece jaws**

机床 整体爪手动自定心卡盘检验条件

(English Translation)

Issued on: March 5, 2009

Implemented on: October 1, 2009

Issued by: Standardization Administration of China

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Foreword

This revised standard adopts ISO 3089:2005 "Machine overall self-centering chuck jaws manually check condition" (in English).

This standard is based on ISO 3089:2005 redrafted.

Because of the special needs of our industry, this standard at the time of adoption of international standards has been modified. The technical differences between a single vertical line labeled Knowledge involved in their terms of margin.

This standard ISO 3089:2005 main technical differences are as follows.

- Chuck nominal diameter of not more than 125mm and greater than the geometric precision chuck 500mm test tolerance values \u200b\u200bhave been adjusted;
- G3 term geometric precision of tolerance values \u200b\u200bhave been adjusted;
- G4 item inspection "test should be larger than the outer diameter of the ring arc diameter clamping jaws" to "test should be smaller than the outer diameter of the ring arc diameter clamping jaws." for ease of use, this standard also made the following editorial changes.
- Remove the foreword and introduction of international standards;
- "This International Standard" be replaced by "this standard";
- With a decimal point instead of a comma as the decimal point, "";
- Geometric tolerances and reference symbol represented by China's relevant provisions of the standard;

--- Of ISO 3089:2005 referenced ISO 230-1:1996, with the corresponding GB/T 17421.1-1998 substitute;

--- Deleted references.

The standard proposed by China Machinery Industry Federation.

The standard metal cutting machine tools by the National Standardization Technical Committee (SAC/TC22) centralized.

This standard was drafted. Huhhot Zhonghuan (Group) Co., Ltd., Yantai Institute of machine tool accessories, and Zhejiang Machinery Co., the company.

1 Scope

This standard specifies two or more machines manually jaw self-centering chuck Geometric tests and the corresponding tolerances.

This standard applies to quick clamping of workpieces of different sizes overall hard jaw chuck.

This standard only defines the chuck rotation center of the workpiece correction accuracy test is not applicable to other dynamic performance tests, such as testing or folder balance Clamping force testing.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 17421.1-1998 Test code for machine tools - Part 1. under no-load or finishing conditions Geometric accuracy of machines (EqvISO 230-1.1996)

3 General Description

The standard of all dimensions and tolerances in millimeters (mm).

4 Accuracy class

This standard specifies a precision.

5 Geometric tests

5.1

The main gear

Chuck clamping test rods (G3 test items) or ring test (test items ~ G7 G4 entry) should use the main gear, the main gear is a means Given reference gear.

5.2 Input torque

Geometric tests when the input torque should be the same, using the manufacturer's prescribed about 67% Chuck maximum allowable input torque.

5.3 Test rods

Test rods for high-quality steel and hardened, in order to avoid damage to the chuck clamping force outer surface. The accuracy of the test rods should be consistent GB/T 17421.1-1998 of A. 3, the same size bar examination requirements.

5.4.1 General

Inspection ring/disk application quality steel and hardened, in order to avoid the chuck clamping force caused by damage to the surface, in order to reduce distortion test loop Movies Loud, read the data should be close to the jaw.

5.4.2 Anti-claw ring with test accuracy

Anti-claw ring with test/plate accuracy should be in accordance with Table 1.