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

GB/T 31396.2-2015

**Machine tools -- Dimensions and geometric tests for
self-centering chucks with two-piece jaws -- Part 2:
Power-operated chucks with tongue and groove type jaws**

机床 分离爪自定心卡盘尺寸和几何精度检验 第2部分：键、槽配合型动力卡盘

(English Translation)

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Foreword

GB/T 31396 "separation claw machine self-centering chuck size and geometric accuracy test" is divided into three parts.

- Part 1. keys, with groove-type manual chuck;
- Part 2. keys, with groove-type power chuck;
- Part 3. with comb-type power chuck.

This section GB/T Part of 231,396.

This section drafted in accordance with GB/T 1.1-2009 given rules.

This section uses the translation method identical with ISO 3442-2:2005 "separation claw machine self-centering chuck size and geometry Testing of accuracy Part 2. keys, with groove-type power chucks "(in English).

Consistency correspondence between this part of international documents and normative references of our files are as follows.

- GB/T 17421.1-1998 Test code for machine tools - Part 1. under no-load or finishing conditions Geometric accuracy of machines (Eqv ISO 230-1:1996) for ease of use, this section made the following editorial changes.
- Remove the foreword international standards and references;
- Remove the test of geometric precision of the test error column;
- Use the decimal symbol "." Decimal symbol instead of "′" this part is proposed by China Machinery Industry Federation.

This part of the National Metal Cutting Machine Standardization Technical Committee (SAC/TC22) centralized.

This section is drafted. Huhhot Zhonghuan (Group) Co., Ltd., Zhejiang Park card machine annex Limited.

1 Scope

This section GB/T 31396 specifies the separation claw (keys, with groove type) self-centering power chuck interchangeability dimensions and geometric precision inspection and corresponding tolerances.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

ISO 230-1:1996 Test code for machine tools - Part 1. under no-load or finishing conditions Geometric accuracy of machines (Testcode formachinetools-Part 1. Geometricaccuracyofmachinesoperatingunderno-loadorfinishingcondi-tions)

3.1 Units of measurement

This part of all dimensions and tolerances in millimeters (mm).

3.2 Geometric tests

This section only provides precision chuck rotation installation site inspection and a top jaw positioning accuracy test. NA other dynamic performance tests, such as testing or clamping force balance test.

These tests mainly in order to ensure consistent test the accuracy of the base jaws and chuck machining accuracy of the chuck after the beginning of the positioning, alignment, clamping Once operating, the adjustment does not affect the top jaw chuck machining accuracy.

4 Accuracy class

This section only provides a precision.

Power chuck, if necessary, should be provided special adjustable base jaw when instructions are not interchangeable with other base jaw and chuck should be identified.

5 Interchangeability dimensions

Power chuck interchangeability dimensions shown in Figure 1 and Table 1.