



## DRAFT INDIAN STANDARD IN WIDE CIRCULATION

Reference : 25352

Date : 23 April 2024

**TECHNICAL COMMITTEE : Machine Tools, Machine Tool Elements, and Holding Devices, PGD 35**

To,

**All concerned**

Dear Madam/Sir,

The following document has been prepared by the Machine Tools, Machine Tool Elements, and Holding Devices Sectional Committee, PGD 35. Please [click here](#) to view the document.

**Document Number : PGD 35 (25352) WC**

**Title of the document : Test conditions for horizontal internal type broaching machines Testing of accuracy**

**Document Type : Revision of Indian Standard (IS/ISO 6480 : 1983)**

*This document has following salient features which may require specific attention for your valuable comments:*

- 1) This document specifies, with reference to IS 2063 (Part 1)/ ISO 230-1, the geometric tests on internal type broaching machines with horizontal Z-axis providing the main cutting motion. It also specifies the applicable tolerances corresponding to the tests mentioned above for normal accuracy horizontal internal-type broaching machines. This document explains concepts or configurations and common features of horizontal internal-type broaching machines. It also provides related terminology and the designation of axes.*
- 2) The major changes in this revision are as follows: a) Title has been changed from 'Conditions of acceptance for horizontal internal broaching machines — Testing of the accuracy' to 'Test conditions for horizontal internal type broaching machines — Testing of accuracy'; b) Levelling test, G01, has been deleted and relevant explanations have been added to 5; c) Sections a) and b) of test items G1 have been merged, consequently, only single tolerance is applied; d) As the term "coincidence" no longer exists in ISO 230-1:2012, the term "radial offset of coaxiality deviation" has been used for test item G5; e) 7 has been created to provide considerations for machining tests to be agreed between manufacturer/supplier and user; and f) Imperial units of measurement have been deleted and only metric units are now used.*

Please examine the document and share your comments regarding further improvement in the document.

**Last date for sharing the comments is : 27 May 2024**

The comments should be shared in the prescribed template through this portal only; and the comments so received shall be taken up by the Sectional Committee for necessary action. For any other query, please write an email at [pgd@bis.gov.in](mailto:pgd@bis.gov.in) to the undersigned at Bureau of Indian Standard, Manak Bhawan, 9, Bahadur Shah Zafar Marg, New Delhi.

In case no comments are received, we would presume your approval of the documents. However, in case we receive any comments on the document, the same shall be put up to the Sectional Committee for necessary action.

Thanking You,

**Yours faithfully,**  
**(RAJEEV RANJAN SINGH)**  
**Head (Production and General Engineering Department)**  
**Email: [pgd@bis.gov.in](mailto:pgd@bis.gov.in)**



## व्यापक परिचालन में मसौदा(दे)

हमारा सन्दर्भ : 25352

दिनांक : 23-04-2024

तकनीकी समिति : Machine Tools, Machine Tool Elements, and Holding Devices Sectional Committee, PGD 35

प्राप्तकर्ता : रूचि रखने वाले सभी निकाय

महोदय/या,

निम्नलिखित मसौदा तैयार किया गया है :

प्रलेख संख्या : PGD 35 (25352) WC

शीर्षक :

कृपया इस/इन मानक(को)/संशोधन(नो) के मसौदे(दो) का अवलोकन करें और अपनी सम्मतियाँ यह बताते हुए भेजें कि यदि ये मानक(को) के संशोधन(नो) के रूप में प्रकाशित हो तो इन पर अमल करने में आपके व्यवसाय अथवा कारोबार में क्या कठिनाइयां आ सकती हैं।

सम्मतियाँ भेजने की अंतिम तिथि : 27 May 2024

सम्मतियाँ, यदि कोई हों तो, कृपया यहाँ क्लिक करके ऑनलाइन पोर्टल के माध्यम से ऊपर दी गयी अंतिम तिथि तक दर्ज कराएं।

यह/ये प्रलेख भारतीय मानक ब्यूरो की वेबसाइट [www.bis.gov.in](http://www.bis.gov.in) पर भी उपलब्ध है/हैं।

धन्यवाद।

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