

ASME B5.57-2012
[Revision of ASME B5.57-1998 (R2006)]

Methods for Performance Evaluation of Computer Numerically Controlled Lathes and Turning Centers

AN AMERICAN NATIONAL STANDARD



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CONTENTS

Foreword		vi
Committee Roster		vii
Correspondence With the B5 Committee		viii
1	Scope	1
2	References	7
3	Nomenclature	17
4	Definitions	20
5	Environmental Specifications	33
6	Environmental Tests	35
7	Machine Performance	43
8	Machine Performance (Additional)	88
9	Test Equipment and Instrumentation	102
Figures		
4-1	The Six Basic Error Motions of an Axis of Rotation.....	21
4-2	Error Motion Polar Plot Showing a Polar Chart Center, a Least-Squares-Circle Center, and Error Motion Values About These Centers	24
4-3	An Example of a Structural Loop Showing a Workpiece, Spindle, Machine Bed, and Tool	31
6.2.1.4-1	Setup Showing Two Displacement Sensors Used to Measure the Environmental Temperature Variation Error (<i>ETVE</i>) Between a Nominal Tool Location and a Work Spindle	36
6.2.1.4-2	Setup Showing Three Displacement Sensors Used to Measure the Environmental Temperature Variation Error (<i>ETVE</i>) Between a Nominal Tool Location and a Work Spindle	38
6.2.1.4-3	Graph of Environmental Temperature Variation Error (<i>ETVE</i>) Data	39
6.2.1.6-1	Setup Showing Five Displacement Sensors Used to Measure the Environmental Temperature Variation Error (<i>ETVE</i>)	39
7.2.3-1	Typical Setup for a Laser Interferometer.....	45
7.2.7-1	The Full Data Set for the Positioning Deviations of an Axis	48
7.2.7-2	Positioning Deviations of an Axis, Forward Direction Only	49
7.2.8-1	Periodic Error of a Linear Axis (Unidirectional)	50
7.3.1.1-1	Setup for Measuring Straightness Using an Electronic Indicator and a Mechanical Straightedge	51
7.3.1.2-1	Test Setup for Measuring Straightness Using a Taut Wire	52
7.3.1.3-1	Test Setup for Measuring Straightness Using an Alignment Laser.....	53
7.3.1.4-1	Typical Straightness Interferometer	53
7.3.2-1	Typical Plot Showing Straightness Data With the Straightness for a Particular Axis Clearly Labeled	54
7.4.1-1	Typical Setup for Measuring the Angular Error Motion (Yaw) of the Cross-Slide on a Group 1 Machine	55
7.5.2-	Schematic for the Measurement of Angular Positioning Using an Indexing Table and a Laser Interferometer	56
7.5.2-	Setup for Adjusting the Alignment of an Indexing Table and a Laser Angle Interferometer	56
7.5.5-1	A Polygon Mounted to a Spindle Axis	58
7.5.5-1	Typical Setup for Measuring the Angular Positioning Accuracy of a Rotary Axis Using an Angular Encoder	59



7.5.8.2-1	Typical Setup for Periodic Angular Error Measurement Using Mechanical Means.....	60
7.6.3-1	Test Setups for Measuring Spindle Error Motions in the Case of Fixed Sensitive Direction.....	62
7.6.4-1	Test Setup for Measuring Spindle Error Motions in the Case of Rotating Sensitive Direction.....	64
7.6.4-2	Spindle Test Setup With an Eccentric Ball.....	65
7.7.2.1-1	Sensor Data From a Typical Spindle Thermal Warm-Up Test.....	67
7.7.2.1-2	Tilts of the Axis Average Line, Spindle Warm-Up Test.....	68
7.7.3.1-1	Path for Measuring Thermal Distortion Caused by Moving Linear Axes.....	69
7.7.3.2-1	Position Error Versus Time for a Typical Test for Thermal Distortion Caused by a Moving Linear Axis.....	70
7.7.4.1-1	Typical Results From a Composite Thermal Error Test.....	72
7.8.2.1-1	Setup for Measuring Squareness of the Cross-Slide to the Work Spindle Using a Mechanical Straightedge.....	74
7.8.2.1-2	Schematic Showing the Angles Involved When Measuring Cross-Slide Squareness to the Spindle Axis.....	74
7.8.2.1-3	Typical Data From a Cross-Slide Out-of-Squareness Measurement.....	75
7.8.2.2-1	Two Views of the Cylinder Used for Measuring Machine Out-of-Squareness and Parallelism.....	76
7.8.2.2-2	Part-Trace Test Past Centers to Determine Cross-Slide Squareness With the Spindle Axis.....	77
7.8.2.2-3	Typical Data From a Cross-Slide Out-of-Squareness Measurement by Part Tracing Past Center.....	77
7.8.2.3-1	Cylinder Reversal for Cross-Slide Squareness.....	78
7.8.3.1-1	Setup for Straightedge Rotation on a Vertical Spindle Lathe for Measuring Z-Axis Parallelism to the C-Axis.....	78
7.8.3.1-2	Setup for Straightedge Rotation on a Horizontal Spindle Lathe for Measuring Z-Axis Parallelism to the C-Axis.....	79
7.8.3.2-1	Z-Slide Parallelism Schematic Showing the Test Cylinder.....	79
7.8.3.2-2	Typical Data From a Parallelism Measurement Using the Turned Cylinder Method.....	80
7.8.4-1	Dual Straightness Measurement for Parallelism.....	81
7.8.4-2	Graphing of Both Straightness Measurements for Twice the Angle of Parallelism.....	81
7.8.4-3	Setup for Measuring Long-Range Parallelism of the Z-Axis in the Case of a Vertically Traversing Axis.....	82
7.9.2-1	Typical Setup for a 360-deg Ball Bar Test.....	84
7.9.2-2	Typical Results From a 360-deg Ball Bar Test.....	84
7.9.3-1	The Ball Bar Setup for the 190-deg Test on a Lathe.....	85
7.9.3-2	Typical Results From a 190-deg Ball Bar Test on a Lathe.....	85
7.9.4-1	Typical Ball Bar Setup for a 100-deg Test.....	86
7.9.4-2	Typical Results of a 100-deg Ball Bar Test.....	87
7.10.2-1	A Typical Plot of the Power Loss in the Spindle Idle Run Loss Test.....	88
8.2-1	Illustration of Angularity and Offset Between Two Axes of Rotation.....	89
8.2.1-1	Typical Setup for the Shim-and-Face Test.....	90
8.2.1-2	Setup for Measuring the Sag of a Pair of Indicators.....	90
8.2.2-1	Typical Setup for the Reverse Indicator Method.....	91
8.2.3-1	Rotation Axes Alignment Using an Optical Alignment Laser.....	92
8.2.4-1	Two-Spindle Setup for the Alignment of Two Rotation Axes.....	93
8.2.5-1	Schematic of the Measurement of Parallelism of the Z-Axis to the Axis of a Movable Tail Stock.....	93
8.2.5.1-1	Setup for Measuring Tail Stock Alignment Using the In-Feed (Z) Axis.....	94
8.3.1-1	Tool Holders Used for Tool-Change Repeatability.....	95
8.3.2-1	Example Tool Holders to Be Used for Turret Repeatability.....	96
8.4.1-1	Test Part for Determining the Location of a Tool-Setting System and Tool-Setting-System Drift.....	98
8.5.2-1	Approximate Location of Probed Points, Depending on Probe Configuration, When Measuring a Machined Test Part.....	100
8.6.3-1	Approximate Location of Probed Points, Depending on Probe Configuration, When Measuring a Test Sphere.....	101



Forms

1	Machine Description	2
2	Environmental Specifications Guidelines	4
3	Environmental Tests (Section 6)	6
4	Machine Performance (Section 7).....	7
5	Coaxiality of Axes of Rotation (Para. 8.2)	14
6	Subsystems Repeatability (Para. 8.3)	15
7	CNC Performance Tests (Para. 8.5)	16
8	Machine Performance as a Measuring Tool (Para. 8.6)	1

Tables

6.2.2.1-1	Specification Zones Derated Due to an Excessive Expanded Thermal Uncertainty	40
6.3.1-1	Performance Parameters Derated Due to Excessive Environmental Vibration	42
7.2.7-1	Typical Test Results (Test for Linear Axis up to 2 m)	47
7.2.7.9-1	Conversion Factors for Graphically Estimating Standard Uncertainty.....	50
7.7.4.3-1	Typical Presentation of Results From Composite Thermal Error Tests	72
7.9.5-1	Typical Results of a Ball Bar Test	87

Nonmandatory Appendices

A	Guide for Using the Draft Turning Center Standard	105
B	1-Day Test for Machine Performance	106
C	Thermal Environment Verification Tests.....	107
D	Seismic Vibration Verification Tests	109
E	Electrical Power Verification Tests	113
F	Machine Functional Tests	114
G	Machine Leveling and Alignment.....	116
H	Compliance and Hysteresis Checks.....	117
I	Laser and Scale Corrections	120
J	Drift Checks for Sensors, Including Lasers.....	121
K	The Part-Trace Test	124
L	Discussion of the <i>UNDE</i> and Thermal Uncertainty.....	125
M	Calculation of Uncertainties.....	130
N	Sign Conventions for Error Values.....	134



FOREWORD

The primary purpose of this Standard is to provide procedures for the performance evaluation of computer numerically controlled (CNC) lathes and turning centers. These procedures are used to evaluate conformance to specifications, to compare machines, to periodically reverify the suitability of production machines, and to reverify performance of machines after repair or modification. Definitions, environmental requirements, and test methods are specified. This Standard defines the test methods capable of yielding adequate results for most turning centers but is not intended to supplement more complete tests that may be required for particular special applications. The Standard does not address issues of machine safety.

Suggestions for improvement of this Standard are welcome. They should be sent to The American Society of Mechanical Engineers; Attn: Secretary, B5 Standards Committee; Two Park Avenue; New York, NY 10016-5990.

This revision was approved as an American National Standard on November 30, 2012.



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METHODS FOR PERFORMANCE EVALUATION OF COMPUTER NUMERICALLY CONTROLLED LATHES AND TURNING CENTERS

1 SCOPE

This Standard establishes requirements and methods for specifying and testing the performance of CNC lathes and turning centers. In addition to clarifying the performance evaluation of lathes and turning centers, this Standard seeks to facilitate performance comparisons between machines by unifying terminology, general machine classification, and the treatment of environmental effects. The Standard defines testing methods capable of yielding adequate performance results for the majority of turning centers and is not intended to replace more complete tests. It is not the intent of this Standard to place limits on, or to enforce 100%-testing of, any individual machine tool in accordance with this Standard. This shall be the subject of contractual agreement between the Supplier and the User.

The actual specification for turning centers is divided into the following six logical areas:

(a) *General Definitions.* Definitions provided in this Standard are generally consistent with the usage in other referenced documents related to machine tools and metrology, although some are specific to their use in this Standard.

(b) *Machine Environmental Specifications and Responses.* Environmental specifications and responses include thermal, electrical, and vibration specifications and tests, as well as requirements on utility air and other externally supplied services.

(c) *Machine Accuracy Performance as a Machine Tool.* Machine accuracy performance as a machine tool includes positioning accuracy and repeatability for linear and rotary axes, angular error motion of linear axes, spindle axis of rotation analysis, machine thermal tests, critical alignments, and contouring performance using circular tests.

(d) *Machine Cutting Performance and Short-Term Reliability.* Machine cutting performance and short-term reliability includes tests of spindle idle run losses and

maximum metal-removal capability. Additionally, the machine is run for approximately 24 h to determine short-term reliability.

(e) *Additional Machine Performance.* Additional performance sections are provided for axis of rotation alignment, tail stock alignment, subsystems repeatability, tool-setting performance, CNC performance, and machine performance as a measuring tool.

(f) *Machining Test Parts.* This Standard provides for the machining of test parts for a particular manufacturing application. These test parts shall be fully specified as part of the original purchasing agreement between the User and the Supplier. Such specification shall include, but not be limited to, material, tooling, machining sequence, and inspection procedure.

This Standard is rather comprehensive, and for smaller, less-expensive machines, a shorter series of tests for conformance to specification is given in Nonmandatory Appendix B.

1.1 Performance Forms (Sample)

A schematic of the machine with axis directions should be provided along with Forms 1 through 8.

1.2 Alternatives

Where specifications use definitions and procedures different than those in this Standard, the alternative items shall be identified and made part of the machine specification. Such procedures should follow the philosophy outlined in the previous paragraphs and be specified in equivalent detail.

This Standard allows parts of the environmental test section to be deferred or bypassed, and only the performance test to be carried out. This alternative is allowable only if it is acceptable to both the User and the Supplier and if deferred according to the procedures outlined in para. 6.1.

