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**Doc No.: PGD 35 (25352) WC**  
**IS/ISO 6480 : 2019**  
**April 2024**

*भारतीय मानक मसौदा*  
**क्षैतिज आंतरिक ब्रोचिंग मशीनों के लिए परीक्षण अवस्थाएं –**  
**परिशुद्धता का परीक्षण**  
*(IS/ISO 6480 का पहला पुनरीक्षण)*

***Draft Indian Standard***  
**Test Conditions for Horizontal Internal Type Broaching Machines —**  
**Testing of Accuracy**  
*(First revision of IS/ISO 6480)*

ICS 25.080.30

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

Last date of comment: 27-05-2024

**NATIONAL FOREWORD**

*(Formal Clause in the national foreword shall be added later)*

The objective of this document is to supply information as wide and comprehensive as possible on tests on horizontal internal type broaching machines which can be carried out for comparison, acceptance, maintenance or any other purposes. This document also establishes the tolerances for the test results corresponding to general purpose and normal accuracy horizontal internal type broaching machines.

This standard was originally published in 2017 based on ISO 6480 : 1983. First revision has been undertaken to align it with the latest version of ISO 6480.

The text of ISO Standard has been approved as suitable for publication as an Indian Standard without deviations. Certain conventions are, however, not identical to those used in Indian Standards. Attention is particularly drawn to the following:

- a) Wherever the words 'International Standard' appear referring to this standard, they should be read as 'Indian Standard'.
- b) Comma (,) has been used as a decimal marker while in Indian Standards, the current practice is to use a point (.) as the decimal marker.

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.

In this adopted standard, reference appears to the following International Standard for which Indian Standard also exists. The corresponding Indian Standard which is to be substituted in its place is listed below along with its degree of equivalence for the edition indicated.

International Standard	Corresponding Indian Standard	Degree of Equivalence
ISO 230-1:2012 Test code for machine tools — Part 1: Geometric accuracy of machines operating under no-load or quasi-static conditions	IS 2063 (Part 1) : 2016/ ISO 230-1:2012 Test code for machine tools: Part 1 Geometric accuracy of machines operating under no-load or quasi-static conditions ( <i>third revision</i> )	Identical

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 2022 ‘Rules for rounding off numerical values (*second revision*)’.

**NOTE:** The technical content of the draft standard is not available on the website. For details, please refer to ISO 6480 : 2019 or contact:

**Head**  
**Production and General Engineering Department**  
**Bureau of Indian Standards**  
**9 Bahadur Shah Zafar Marg New Delhi-110002**  
**Email: [pgd@bis.gov.in](mailto:pgd@bis.gov.in)**  
**Telefax:011-23234819**