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Research Article

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An accuracy allocation method for five-axis machine tools based on geometric error cost sensitivity prioritizing tool direction deviation

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Abstract: Accuracy allocation is crucial in the accuracy design of machining tools. Current accuracy allocation methods primarily focus on positional deviation, with little consideration for tool direction deviation. To address this issue, we propose a geometric error cost sensitivity-based accuracy allocation method for five-axis machine tools. A geometric error model consisting of 41 error components is constructed based on homogeneous transformation matrices. Volumetric points with positional and tool direction deviations are randomly sampled to evaluate the accuracy of the machine tool. The sensitivity of each error component at these sampling points is analyzed using the Sobol method. To balance the needs of geometric precision and manufacturing cost, a geometric error cost sensitivity function is developed to estimate the required cost. By allocating error components affecting tool direction deviation first and the remaining components second, this allocation scheme ensures that both deviations meet the requirements. We also perform numerical simulation of a BC-type five-axis machine tool to validate the method. The results show that the new allocation scheme reduces the total geometric error cost by 27.8% compared to a uniform allocation scheme, and yields the same positional and tool direction machining accuracies.

Key words: Five-axis machine tool; Accuracy allocation; Geometric error modeling; Error cost sensitivity; Tool direction deviation priority

1 Introduction

Five-axis machine tools have unique advantages in complex surface machining and manufacturing, being widely used in the aerospace, aviation, shipbuilding, automotive, and defense industries. The machining accuracy of five-axis machine tools directly reflects a country's advanced manufacturing technology level. Numerous factors affect the machining accuracy of five-axis machine tools, including geometric errors (Fan et al., 2024; Jiang and Cripps, 2015; Zhang HN et al., 2024), thermal errors (Wei et al., 2024; Zhu et al., 2023), errors induced by cutting forces, servo errors, and tool wear (Díaz-Saldaña et al., 2023; Yu et al., 2021). Among these factors, geometric errors and thermal errors together account for approximately 50-70% of the total, with geometric errors alone accounting for approximately 40% (Li et al., 2018). Geometric errors exhibit systematic characteristics, repeatability, and stability (Xia et al., 2019). Designing tolerances for geometric errors at the initial stage of machine tool development is a valid strategy for improving the machining accuracy. However, there are as many as 41 geometric error components in five-axis machine tools (Xing et al., 2019). These error components have different degrees of influence on machine tool accuracy, and require different costs to implement tolerance controls for. Therefore, it is important to quantify the importance of each error component, and design tol-

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erances based on their importance and relative implementation costs.

To study the importance of error components on machine tool accuracy, we perform a sensitivity analysis. Sensitivity analysis involves investigating the degree to which different inputs to a model influence the uncertainty in the output (Saltelli et al., 2019) and is typically divided into two types: local and global sensitivity analysis (Zhang Z et al., 2024). Local sensitivity analysis involves examining the influence of a single parameter in the inputs on the output results. Global sensitivity analysis involves studying the variations and interactions of multiple parameters, and how these affect the output results (Liu et al., 2019); this is an effective tool for machine tool precision research. Since machine tool geometric error models typically take the geometric error values of each axis as inputs and tool positioning deviations (either positional or tool directional) as outputs, performing global sensitivity analysis is an effective way to quantify the importance of each geometric error component, identify critical error components, and guide machine tool precision design.

In recent years, scholars have conducted extensive research on machine tool accuracy using sensitivity analysis methods. For example, Song et al. (2024) proposed an error allocation method based on sensitivity analysis and an optimized genetic algorithm, which was used to allocate accuracy for a five-axis ultra-precision machine tool. Ding et al. (2023) proposed a method for analyzing geometric error influence on key gear evaluation deviations, and crucial geometric errors were identified based on the Morris sensitivity analysis method. Additionally, Niu et al. (2021) introduced an improved second-order partial correlation coefficient based on the Pearson product-moment correlation coefficient. They considered the dynamic influence of the rapid fluctuations in error parameters during the motion component's stroke on the machining accuracy. Their research provided guidance for improving the accuracy of CNC machine tool machining through comprehensive study of the local effects, correlations, and fluctuations of geometric errors. In another study, Fan et al. (2020) divided a workpiece into five regions based on the open and twist angles, and proposed a quantitative interval sensitivity analysis method. They identified critical geometric errors in each region. Zhong et al. (2019) calculated the sensitivity of assembly errors to machine tool motion accuracy, using the partial differential method. They identified the most critical assembly errors and improved machine tool motion accuracy by adjusting the tightness of corresponding guide rail installations. Building on sensitivity analysis, some scholars have also researched tolerance design for critical geometric errors in machine tools. For instance, Cheng et al. (2018) calculated the first-order sensitivity and global sensitivity of geometric errors in CNC machine tools using the Sobol method. Specifically, they integrated sensitivity analysis results into the cost function for tolerance optimization design. Moreover, Wu et al. (2020a) traced 13 critical geometric errors in a three-axis CNC machine tool based on orthogonal experiments. By solving optimization objective functions, they provided tolerance bands for various critical errors under differing tolerance levels (IT2~IT10). Zhang et al. (2017) proposed an allocation approach of the geometric errors for optimizing total cost and reliability and used a mathematical model to perform the optimization process of accuracy allocation by using the NSGA-II algorithm.

Most of the research mentioned above uses sensitivity analysis to identify critical geometric errors, or key motion axes affecting machine tool machining accuracy, and provides guidance for accuracy allocation or geometric error compensation based on the results. In existing research, sensitivity analysis methods typically require measurement of all geometric errors of the machine tool and the identification of critical errors is based on measured values (Xiang and Wu, 2021); this limits their effectiveness in guiding forward design of machine tools. In terms of guidance for machine tool accuracy allocation, most studies only determine key geometric error components (Chen et al., 2013; Cheng et al., 2014; Fan et al., 2020; Niu et al., 2021; Zhong et al., 2019), and methods that can quantitatively determine tolerance bandwidths for each error component are lacking (Cheng et al., 2014; Wu et al., 2020a). Furthermore, most studies focus on the positional deviations of machine tools, while neglecting tool direction deviations. In reality, five-axis machine tool direction deviations are of equal importance to positional deviations in many operating conditions (Xiong et al., 2019), such as drilling (Lin et al., 2015; Yuan et al.,

2014), flank milling (Zhang et al., 2016), and gear form grinding (Xia et al., 2020; Xia et al., 2019).

To address the aforementioned issues, we propose an accuracy allocation method for five-axis machine tools based on geometric error sensitivity and cost analysis. The first step of the method is to allocate the allowable ranges of geometric error components that affect tool direction deviations, ensuring that the tool direction deviations at the sampling points meet the accuracy requirements. The next step is to allocate the allowable ranges of the remaining geometric error components, making sure that the positional deviations at the sampling points also meet the accuracy requirements. This approach ensures that both the positional and tool direction deviations are constrained. During the optimization process, it is objective that the cost sensitivities of each geometric error be equal. This reasonably allocates costs to set tolerances for the geometric error components, resulting in the lowest-cost allocation scheme that meets the accuracy requirements.

2 Establishing the geometric error model

2.1 Sources of geometric errors in five-axis machine tools

According to the definition from ISO (International Standards Organization) 230-1 (ISO, 2012a), each linear axis of a machine tool has six geometric errors. These include three linear errors in the directions of the three coordinate axes (one positioning error, and two linear errors perpendicular to the axis) and three angular errors (the pitch, yaw, and roll errors). These geometric errors are related to the position of the motion axis and are called position-dependent geometric errors (PDGEs). They are primarily determined by the precision of the components that make up the motion axis. Additionally, there are three perpendicularity errors between the three linear axes, which are not related to the position of the motion axes. Such errors are called position-independent geometric errors (PIGEs), and are mainly caused by assembly deviations in the motion components. According to the definition in ISO 230-7 (ISO, 2012b), each machine tool rotary axis also has six PDGEs, comprising three linear errors and three angular errors. Additionally, each rotary axis has four PIGEs, including two perpendicularity errors and two positioning deviations in the direction perpendicular to the axis line. Fig. 1 shows the geometric errors described above, using the Y-axis and C-axis as an example.

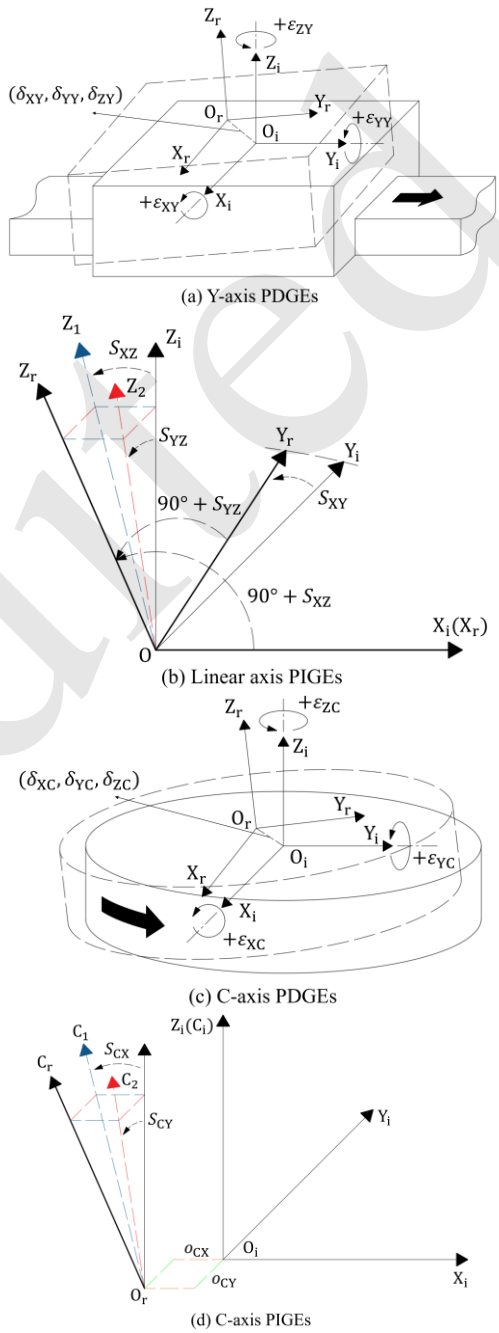

Fig. 1. Geometric errors in linear and rotary axes of a machine tool.

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2.2 Geometric error modeling of five-axis machine tools

Taking a typical BC-type five-axis machine tool with dual rotary tables as an example, we establish a geometric error model of the machine tool for subsequent sensitivity analysis. A schematic of the BC-type five-axis machine tool is shown in Fig. 2(a), which includes three linear axes (X, Y, Z) and two rotary axes (B, C). The kinematic chain of this machine tool is denoted as WCBMXYZT, and its kinematic chain structure is illustrated in Fig. 2(b). Among them, the B-axis and C-axis belong to the workpiece kinematic chain, while the X-axis, Y-axis, and Z-axis belong to the tool kinematic chain. The kinematic chain follows the transmission sequence of "WCS→CCS→BCS→MCS→XCS→YCS→ZCS→TCS." Here, WCS represents the workpiece coordinate system, and CCS, BCS, XCS, YCS, and ZCS represent the coordinate systems of the C-axis, B-axis, X-axis, Y-axis, and Z-axis, respectively. MCS represents the machine tool coordinate system, and TCS represents the tool coordinate system.

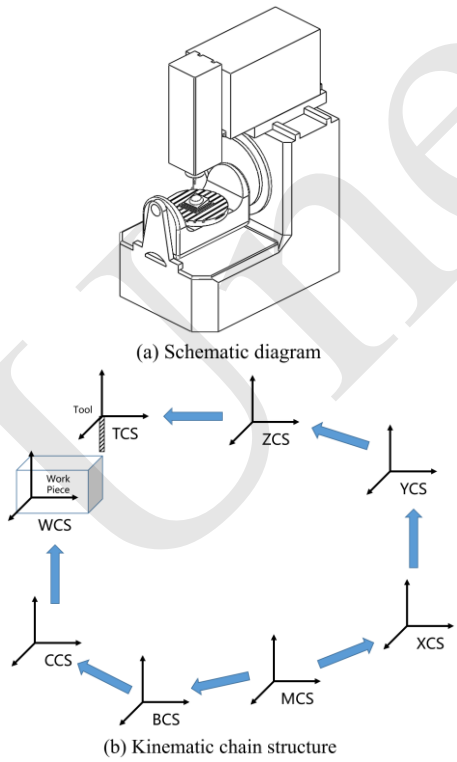

Fig. 2. A typical BC-type five-axis machine tool with dual rotary tables.

In the kinematic chain of the machine tool, there are a total of five motion components: the X, Y, Z, B, and C axes. As discussed earlier, these five motion axes involve a total of 41 geometric errors, including 30 PDGEs and 11 PIGEs. The names of all geometric errors are listed in Table 1, where δ represents linear error, ε represents angular error, S represents perpendicularity error, and o represents positioning deviation of the rotary axis in the direction perpendicular to the axis.

Table 1. List of geometric errors for the BC-type five-axis machine tool with dual rotary tables.

Geometric Errors		
PDGEs	X-axis	$\delta_{XX}, \delta_{YX}, \delta_{ZX}, \varepsilon_{XX}, \varepsilon_{YX}, \varepsilon_{ZX}$
	Y-axis	$\delta_{XY}, \delta_{YY}, \delta_{ZY}, \varepsilon_{XY}, \varepsilon_{YY}, \varepsilon_{ZY}$
	Z-axis	$\delta_{XZ}, \delta_{YZ}, \delta_{ZZ}, \varepsilon_{XZ}, \varepsilon_{YZ}, \varepsilon_{ZZ}$
	B-axis	$\delta_{XB}, \delta_{YB}, \delta_{ZB}, \varepsilon_{XB}, \varepsilon_{YB}, \varepsilon_{ZB}$
	C-axis	$\delta_{XC}, \delta_{YC}, \delta_{ZC}, \varepsilon_{XC}, \varepsilon_{YC}, \varepsilon_{ZC}$
PIGEs		$S_{XY}, S_{YZ}, S_{XZ}, S_{BX}, S_{BZ}, S_{CX}, S_{CY}, o_{BX}, o_{BZ}, o_{CX}, o_{CY}$

In WCS, the error matrix E for tool positioning can be calculated as:

$$E = {}^{\mathrm{T}}_{\mathrm{W}}T^{\mathrm{r}} - {}^{\mathrm{T}}_{\mathrm{W}}T^{\mathrm{i}} \tag{1}$$

where ${}^{\mathrm{T}}_{\mathrm{W}}T^{\mathrm{r}}$ is the actual transformation matrix from the tool coordinate system to the workpiece coordinate system, and ${}^{\mathrm{T}}_{\mathrm{W}}T^{\mathrm{i}}$ is the ideal transformation matrix from the tool coordinate system to the workpiece coordinate system. Details of the model derivation are provided in the electronic supplementary materials (ESM).

3 Sensitivity and cost analysis of geometric errors over the volumetric workspace

3.1 Sensitivity analysis of geometric errors

We next conduct a sensitivity analysis to quantify the influence of each geometric error component (among the 41 input components) on the machine tool's positional and tool direction deviations. The Sobol method, which we will employ for this task, has two main characteristics (Wang et al., 2023): (1) It quantitatively analyzes the degree of influence of each input parameter on the model output; (2) It calculates the sensitivity index of each parameter within a specific range of values. In general, the geometric errors of machine tools are close to a normal distri-

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bution (Cheng et al., 2014). Therefore, in this study, all 41 geometric errors of the five-axis machine tool are considered as normally distributed, with the center value μ being set to 0. Based on the basic rules of normal distributions, the relationship between the standard deviation σ and the tolerance bandwidth T is $T = 6\sigma$ (Wu et al., 2020b). Points were randomly sampled within the normal distribution range of the 41 geometric errors using the Sobol sequence method (Sobol, 2001), which has high stability and fast convergence. Then, the Saltelli sampling method (Chan et al., 1997) was used to construct a sample list and a corresponding model output list, based on which the Sobol indices of the model inputs were calculated. Compared to the original Sobol method, the Saltelli sampling method has a smaller computational load and is easier to implement in programming.

3.2 Volumetric sampling points considering the tool direction deviation

The input for the geometric error model consists of 41 geometric error values and a five-axis coordinate point P. Therefore, a single Sobol sensitivity analysis can only yield sensitivity indices for the 41 geometric errors at a single five-axis coordinate point P, i.e., ${}^{P}S_i(i = 1, 2, \cdots, 41)$. These sensitivity indices represent the importance of each geometric error in influencing the machine tool's positional or tool direction deviation at that point. To ensure that the sensitivity analysis results reflect the characteristics of geometric errors in the workspace of the machine tool, a sensitivity analysis for geometric errors in the workspace of the machine tool is proposed.

As shown in Fig. 3, n sampling points are selected symmetrically at the centers of four body diagonals in the workspace of the machine tool's linear axes, resulting in a total of $4n$ thee-axis coordinates. Then, within the stroke ranges of the two rotary axes of the machine tool, m_1 and m_2 sampling points are selected. By combining the sampling points of the linear and rotary axes, a total of $4nm_1m_2$ five-axis coordinates $P_j(j = 1, 2, \cdots, 4nm_1m_2)$ can be obtained. This list of five-axis coordinates provides the sampling points for subsequent sensitivity analysis of the workspace, and development of precision equivalence algorithms.

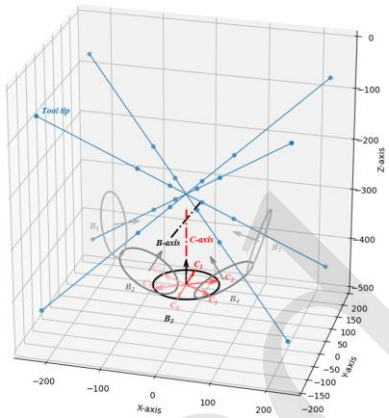

Fig. 3. Volumetric sampling points from a combination of the linear and rotary axes.

The selection of sampling points is based on actual operating conditions. As such, the points are not evenly distributed considering the frequency distribution of the linear and rotary axes. We found that the results of the sensitivity analysis based on the volumetric sampling points shown in Fig. 3 are relatively close to those based on the tool paths of specific workpieces. Therefore, these volumetric sampling points can be used as a basis for general analysis.

By performing a single Sobol sensitivity analysis for the positional and tool direction deviations at each sampling point P_j, sensitivity indices ${}^{P_j}S_i(i = 1, 2, \cdots, 41; j = 1, 2, \cdots, 4nm_1m_2)$ for the 41 geometric errors can be obtained. In this study, the sensitivity indices of the geometric errors at all sampling points are averaged, to obtain the sensitivity indices for the machine tool's workspace:

$$S_i^{\mathrm{T}} = \frac{1}{4nm_1m_2} \sum_{j=0}^{4nm_1m_2} {}^{P_j}S_i \tag{2}$$

This sensitivity index S_i^{T} represents the importance of each geometric error in influencing the overall positional deviation or tool direction deviation of the machine tool. A higher sensitivity index for a certain geometric error indicates that this geometric error is more impactful on the positional deviation or tool direction deviation.

3.3 Geometric error cost sensitivity

The sensitivity analysis in Section 3.1 indicates which error components are more important, but it

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ignores the manufacturing cost of each error component. A cost analysis is necessary to determine which error components can reasonably be addressed.

Therefore, we conduct a cost analysis of the geometric errors based on a cost tolerance model. According to relevant literature (Armillotta, 2020), commonly used cost tolerance models comprise thirteen types, such as the exponential model, reciprocal model, reciprocal square model, reciprocal power model, and polynomial model. Among these, the reciprocal square model is most commonly used:

$$C(T) = A + \frac{B}{T^2} \tag{3}$$

Here, C represents the part manufacturing cost, T represents the tolerance, A represents a fixed cost constant that is independent of the tolerance, and B represents the coefficient of the feature curve related to the tolerance. Considering how the geometric errors of each axis accumulate (due to the manufacturing and assembly tolerances of the components of each axis), we choose to substitute the tolerance bandwidth of the geometric error components in the reciprocal square model to calculate the cost; this represents the estimated cost of controlling the tolerance bandwidth of the geometric error components. In this case, the estimated cost of the overall machine accuracy design can be represented as:

$$C_{\text{total}} = \sum_{i=1}^{41} C(T_i) = \sum_{i=1}^{41} \frac{k_i}{T_i^2} \tag{4}$$

where C_{total} is the total estimated cost of the machine accuracy design, T_i represents the allowable range of variation for the ith geometric error, and k_i represents the cost coefficient of the ith geometric error. Since different geometric error components have different impacts on the overall machine accuracy, as well as varying implementation difficulties (Tian, 2014), their differences in sensitivity and implementation cost should be considered when allocating the allowable variation ranges. The cost coefficient k_i of the geometric error components represents the difficulty of achieving static accuracy for that geometric error component, including both PDGEs and PIGEs. This coefficient can be determined through regression analysis based on relevant data held by the machine tool manufacturer.

Considering how the sensitivities of the geometric error components represent their impact on overall accuracy, we want to allocate more cost to the important error components and avoid wasting cost on noncritical error components. Accordingly, we propose using the ratio of the sensitivity of the geometric error components to their estimated cost as the cost sensitivity, that is:

$$\omega_i = \frac{S_i^{\text{T}}}{C_i} \tag{5}$$

Here, ω_i represents the cost sensitivity of the ith geometric error component, S_i^{T} represents its sensitivity, and C_i represents its estimated cost. The cost sensitivity of a geometric error component essentially expresses the impact of cost changes on accuracy for that specific component. When the sensitivity of a geometric error component is low and the implementation cost is high, the cost sensitivity of that geometric error component is low, indicating that cost changes have a limited impact on accuracy, and implying a significant waste of funds; in this case, the tolerance level for that geometric error component should be relaxed. Conversely, when the sensitivity of a geometric error component is high and the implementation cost is low, this indicates that cost changes can effectively improve the accuracy. In this scenario, there is still room for improvement in the accuracy of that geometric error component, and it is recommended to increase the cost invested into that geometric error component and reduce the tolerance.

Under this assumption, when the cost sensitivities of each geometric error component in an accuracy allocation scheme are equal, it indicates that the cost of the precision design is optimally utilized across all components. Such an allocation scheme is considered to have the lowest cost.

4 Accuracy allocation with priority given to tool direction deviation

4.1 Priority of tool direction deviation and angular error components

As stated in Section 1, the issue of tool direction deviation is neglected in most studies despite its im-

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portance (Xiong et al., 2019), particularly for situations such as drilling (Lin et al., 2015; Yuan et al., 2014), flank milling (Zhang et al., 2016), and gear form grinding (Xia et al., 2020; Xia et al., 2019). In the conditions above, tool direction deviation impacts the resulting quality of the target surface, for instance in regard to perpendicularity of the central axis of a drilled hole, the parallelism and perpendicularity of a milled side, or the precision of a gear surface. Thus, only ensuring positional precision may mean that Geometric Dimensioning and Tolerancing (GD&T) requirements are not met.

Here, we elaborate on this point for the situation of flank milling. As shown in Fig. S1(a), an inclined conical workpiece is being processed by five-axis flank milling, whose GD&T requirements are given by the surface profile in Fig. S1(b). Fig. S1(c) shows both the ideal condition and the condition where there is a tool direction deviation of $\Delta\theta$. The point at the tip of the tool is controlled to ensure positional precision in both conditions. However, as shown in Fig. S1(d), the tool direction deviation may cause the inclined cone surface profile to fail to meet the GD&T requirements.

In conditions with stringent GD&T requirements, positional precision control alone may be insufficient to meet the requirements. Thus, tool direction deviation should also be considered.

Among all 41 error components, the linear error components can only affect the positional deviation. Only angular error components can affect tool direction deviation, and they also affect positional deviation. Depending on the geometric model for each machine tool, some of the angular error components whose rotation vector is parallel to the tool vector do not affect tool direction deviation, either. Therefore, we propose a method of first adjusting error components that affect tool direction deviation, and then adjusting the remaining error components to ensure that the allocation scheme meets the requirements for both tool direction and positional deviations. The first stage of adjustment only adjusts those error components affecting the tool direction deviation, making sure that the tool direction deviation meets the requirements. In the first stage of adjustment, error components with zero sensitivity to tool direction deviation are ignored, and their value ranges will be determined in the second stage of adjustment. The second stage of adjustment will start only when all value ranges of error components affecting tool direction deviation have been determined. Through the above method, both tool direction and positional deviations of the machine tool can be controlled.

4.2 Accuracy allocation process

During adjustment of the tolerance bandwidths for various geometric error components, it is essential to ensure that each iteration scheme possesses equivalent accuracy. In other words, the tool direction deviation $\boldsymbol{\Delta V}$ and the positional deviation $\boldsymbol{\Delta P}$ for each iteration scheme should be at similar levels. Therefore, we constrain the machine tool's directional and positional deviations by probabilities of $\boldsymbol{\Delta V}$ and $\boldsymbol{\Delta P}$, respectively, to be less than a certain threshold at any five-axis coordinates. The range of percentages these probabilities fall into will define the target accuracy of the machine tool.

In this study, we use a globally-scaled accuracy allocation scheme called the overall scaling algorithm, as depicted in Fig. 4(a). This ensures that both the initially-determined tolerance allocations and each set of accuracy allocation schemes meet the accuracy criteria during the iterative process, thus enabling precision equivalence.

Based on the previous analysis, we know that the cost sensitivity index represents the impact of the cost change of geometric error components on the machine tool accuracy. When the cost sensitivities of each geometric error component are equalized, the accuracy allocation scheme with the lowest cost is achieved. Meanwhile, considering that the tool direction deviation $\boldsymbol{\Delta V}$ is only influenced by angular error components, the geometric error components affecting $\boldsymbol{\Delta V}$ are allocated first in the adjustment to achieve the target directional precision. Subsequently, the remaining geometric error components are allocated to achieve the target positional precision. The adjustment algorithm proposed in this study can be summarized as follows:

Step 1. Use the global scaling algorithm to scale the initially-determined tolerance values for the 41 geometric error components, achieving the target precision. Then output the scaled accuracy allocation scheme AS_1 as the initial value for optimization.

Step 2. Perform sensitivity analysis on the scaled tolerance values, calculating the cost sensitiv-

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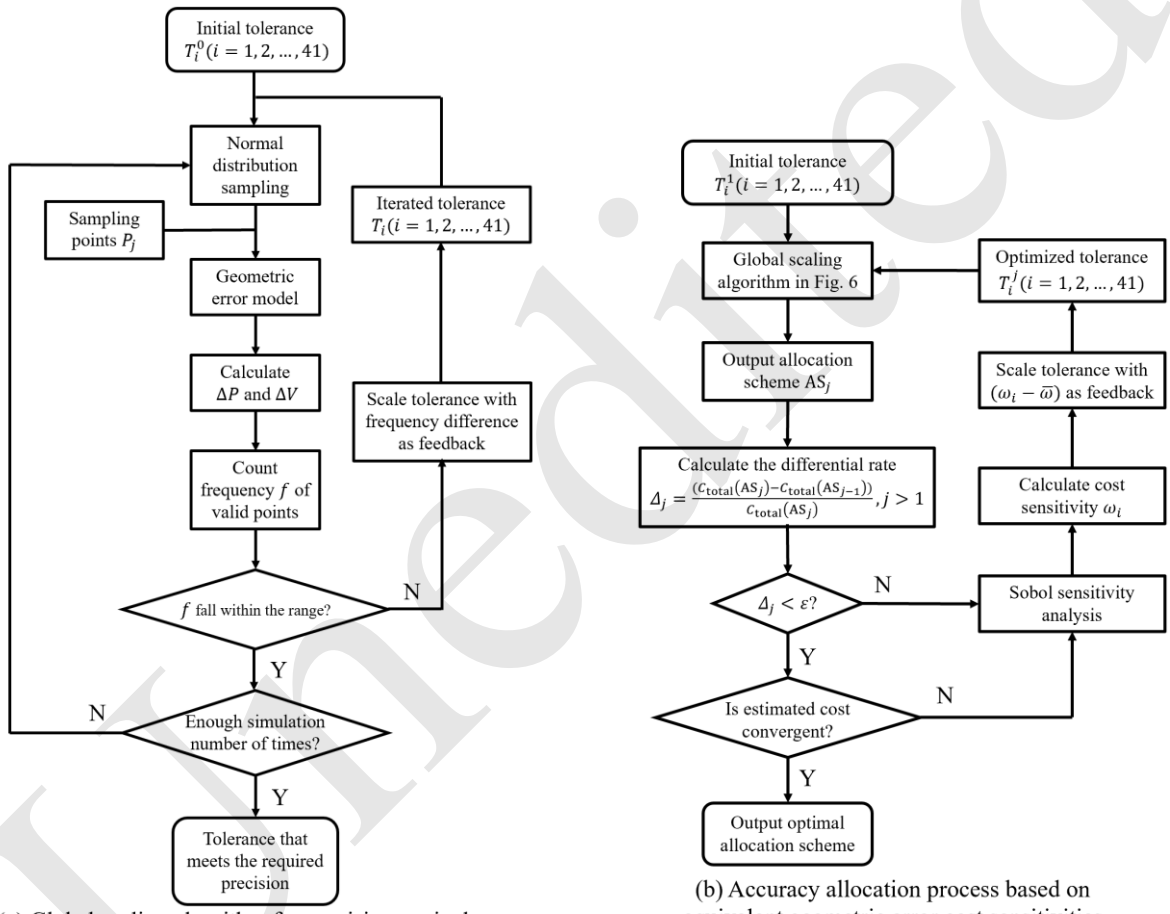
ity index ω_i.

Step 3. Calculate the average value of cost sensitivity for each geometric error component, i.e., $\overline{\omega} = \frac{1}{n}\sum_{i=1}^{n}\omega_i$, and adjust the tolerance of each geometric error component using the difference $(\omega_i - \overline{\omega})$ as feedback, i.e., $T_i^j = k(\omega_i - \overline{\omega})T_i^{j-1}$.

Step 4. Use the global scaling algorithm on the adjusted tolerance values T_i^j to achieve the target precision. Then output the scaled accuracy allocation scheme AS_j as the iterated result.

Step 5. Calculate the differential rate Δ_j of estimated cost between two iterations. If Δ_j is less than a specific threshold ε in consecutive iterations, this indicates that the estimated cost is convergent, and the allocation scheme can be selected as the final output. Otherwise, repeat step 2) iteratively.

A flowchart of the algorithm is shown in Fig. 4(b).



(a) Global scaling algorithm for precision equivalence

(b) Accuracy allocation process based on equivalent geometric error cost sensitivities

Fig. 4. Accuracy allocation process

5 Simulation and verification

5.1 Configuration of initial parameters

The BC-type five-axis machine tool with dual rotary tables shown in Fig. 2 is next used to conduct a simulation. Based on the theory of HTM, we calculated the coordinate transformation matrices between each coordinate system. We used the *Python* programming language to establish the geometric error model of the machine tool, enabling the calculation of positional deviation $\boldsymbol{\Delta P}$ and tool direction deviation $\boldsymbol{\Delta V}$.

In the simulation, six test points were selected along the four body diagonals within the workspace of three linear axes of the machine tool, as shown in Fig. 3. The distribution of sampling points for the rotary axes is presented in Table 2. After permutation and combination, a total of 720 sampling points were

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generated over the volumetric workspace.

Table 2. Distribution of sampling points for rotary axes.

B-axis	C-axis
-75 °	0 °
-30 °	60 °
0 °	120 °
30 °	180 °
75 °	240 °
	300 °

Initial tolerance ranges for the 41 geometric errors were set based on achievable accuracies for typical five-axis CNC machine tools and some relevant references (Cheng et al., 2014). Among them, the tolerance range for 19 linear errors was set to $[-10, 10]$ μm, and the tolerance range for 22 angular errors was set to $[-20, 20]$ μrad.

Based on relevant design requirements suggested in the literature, we set the accuracy thresholds for positional deviation and tool direction deviation to be 20 μm and 40 μrad, respectively. We also set the specific percentage range (described in Section 4.2) to be 95±1%. This means the probability that $|\boldsymbol{\Delta V}| \leq$ 40 μrad and $|\boldsymbol{\Delta P}| \leq 20$ μm at any five-axis coordinate should be within the range of 95±1% in order to meet the target accuracy.

5.2 Tool direction accuracy allocation

The precision equivalent scaling algorithm shown in Fig. 4(a) was used on the initial tolerance values to adjust the angular error components that affect tool direction deviation. This adjustment was made to ensure that the tool direction deviation from the tolerance configuration met the target accuracy. The scaled tolerance configuration was then used as the initial value in the optimization, as shown in Table 3.

Table 3. Optimization initial values (unit: linear error components/μm; angular error components/μrad; * indicates variations in error components).

Error item	Allowable range	Error item	Allowable range	Error item	Allowable range
δ_{XX}	$[-10.0, 10.0]$	$*\varepsilon_{XZ}$	$[-18.2, 18.2]$	S_{XY}	$[-20.0, 20.0]$
δ_{YX}	$[-10.0, 10.0]$	$*\varepsilon_{YZ}$	$[-18.2, 18.2]$	$*S_{YZ}$	$[-18.2, 18.2]$
δ_{ZX}	$[-10.0, 10.0]$	ε_{ZZ}	$[-20.0, 20.0]$	$*S_{XZ}$	$[-18.2, 18.2]$
$*\varepsilon_{XX}$	$[-18.2, 18.2]$	δ_{XB}	$[-10.0, 10.0]$	S_{BX}	$[-20.0, 20.0]$
$*\varepsilon_{YX}$	$[-18.2, 18.2]$	δ_{YB}	$[-10.0, 10.0]$	$*S_{BZ}$	$[-18.2, 18.2]$
ε_{ZX}	$[-20.0, 20.0]$	δ_{ZB}	$[-10.0, 10.0]$	$*S_{CX}$	$[-18.2, 18.2]$
δ_{XY}	$[-10.0, 10.0]$	$*\varepsilon_{XB}$	$[-18.2, 18.2]$	$*S_{CY}$	$[-18.2, 18.2]$
δ_{YY}	$[-10.0, 10.0]$	$*\varepsilon_{YB}$	$[-18.2, 18.2]$	o_{BX}	$[-10.0, 10.0]$
δ_{ZY}	$[-10.0, 10.0]$	$*\varepsilon_{ZB}$	$[-18.2, 18.2]$	o_{BZ}	$[-10.0, 10.0]$
$*\varepsilon_{XY}$	$[-18.2, 18.2]$	δ_{XC}	$[-10.0, 10.0]$	o_{CX}	$[-10.0, 10.0]$
$*\varepsilon_{YY}$	$[-18.2, 18.2]$	δ_{YC}	$[-10.0, 10.0]$	o_{CY}	$[-10.0, 10.0]$
ε_{ZY}	$[-20.0, 20.0]$	δ_{ZC}	$[-10.0, 10.0]$		
δ_{XZ}	$[-10.0, 10.0]$	$*\varepsilon_{XC}$	$[-18.2, 18.2]$		
δ_{YZ}	$[-10.0, 10.0]$	$*\varepsilon_{YC}$	$[-18.2, 18.2]$		
δ_{ZZ}	$[-10.0, 10.0]$	$*\varepsilon_{ZC}$	$[-18.2, 18.2]$		

Total estimated cost only considering the error components with variations:

$$C_{\text{total}} = \sum_{i=1}^{18} C(T_i) = \sum_{i=1}^{18} \frac{k_i}{T_i^2} = 8774669$$

To achieve the target accuracy for tool direction deviation, among the 22 angular error components, the allowable range for 17 components was reduced from the initial $[-20, 20]$ μrad to $[-18.2, 18.2]$ μrad. However, five angular error components, ε_{ZX}, ε_{ZY}, ε_{ZZ}, S_{XY}, and S_{BX}, remained unchanged. This is because the vectors of these components are parallel to the tool axis and do not affect the tool direction deviation. Additionally, two angle error components, ε_{ZY} and ε_{ZZ}, coincide with the tool axis and therefore do not affect the positional deviation. Hence, the actual number of error components that need to be allocated is 39. The sensitivity analysis for tool direction deviation based on the initial tolerance configuration is shown in Fig. 5.

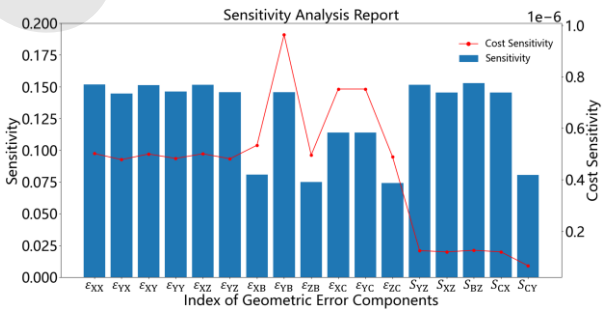

Fig. 5. Sensitivity analysis of tool direction deviation for the initial tolerance values.

In the simulation, the inverse square cost tolerance model was used to calculate the cost of the geometric error components, as shown in Eq. (4). Generally, it is more challenging to control PDGEs in linear axes than in rotational axes, and PIGEs tend to be much larger than PDGEs (Chen et al., 2023). Therefore, we assigned coefficient values of 1, 0.5, and 4 to the cost tolerance model for PDGEs in linear axes, PDGEs in rotational axes, and PIGEs, respectively. The initial values, as shown in Table 3, were optimized using the aforementioned accuracy allocation method. The iterative process is depicted in Fig.

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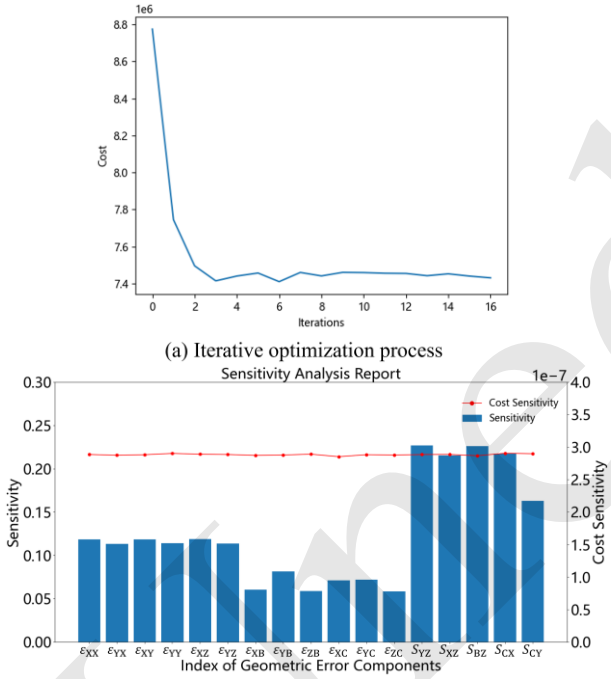
6(a), and the sensitivity analysis results after convergence are shown in Fig. 6(b). The geometric error components that underwent changes are listed in Table 4. From Fig. 6(a), one can observe that the result converges after approximately eight iterations. Fig. 6(b) reveals that the cost sensitivities of various error components become approximately equal after optimization, indicating that the cost has been maximally utilized (i.e., the resulting allocation plan is the one with the lowest cost). If we only consider the error components involved in the adjustment, then during the allocation of angular error components affecting tool direction deviation, the geometric error cost decreased by 15.2%.



(a) Iterative optimization process

(b) Sensitivity analysis results after convergence

Fig. 6. Optimization results of tool directional deviation.

Table 4. Geometric error components with variations during tool direction deviation optimization (unit: μrad).

Error item	Allowable range	Error item	Allowable range	Error item	Allowable range
ε_{XX}	$[-15.6, 15.6]$	ε_{XB}	$[-15.4, 15.4]$	S_{YZ}	$[-22.6, 22.6]$
ε_{YX}	$[-15.9, 15.9]$	ε_{YB}	$[-13.3, 13.3]$	S_{XZ}	$[-23.2, 23.2]$
ε_{XY}	$[-15.6, 15.6]$	ε_{ZB}	$[-15.7, 15.7]$	S_{BZ}	$[-22.5, 22.5]$
ε_{YY}	$[-15.9, 15.9]$	ε_{XC}	$[-14.2, 14.2]$	S_{CX}	$[-23.1, 23.1]$
ε_{XZ}	$[-15.6, 15.6]$	ε_{YC}	$[-14.1, 14.1]$	S_{CY}	$[-26.7, 26.7]$
ε_{YZ}	$[-15.9, 15.9]$	ε_{ZC}	$[-15.7, 15.7]$		

Total estimated cost only considering the error components above:

$$C_{\text{total}} = \sum_{i=1}^{18} C(T_i) = \sum_{i=1}^{18} \frac{k_i}{T_i^2} = 7{,}442{,}521$$

5.3 Positional accuracy allocation

In Section 5.2, the allowable ranges of 17 angular error components were determined to ensure that the tool direction deviation reached the target accuracy. Subsequently, the remaining 22 geometric error components were allocated to achieve the target accuracy for positional deviation. The precision-equivalent scaling algorithm shown in Fig. 4(a) was applied to the optimized allocation scheme (described in Section 5.2) to scale the remaining 22 geometric error components, ensuring that the positional deviation in the tolerance configuration met the target accuracy. The geometric error components that underwent changes are listed in Table 5, and were used as the initial values for positional deviation optimization. Sensitivity analysis for positional deviation based on the initial tolerance configuration is shown in Fig. 7. Following the same accuracy allocation method, the remaining 22 geometric error components were iteratively optimized. The process is shown in Fig. 8(a), the sensitivity analysis results after convergence are presented in Fig. 8(b), and the optimization results are summarized in Table 6. Solely considering the error components involved in the adjustment, during the optimization of the positional deviation, the geometric error cost decreased by 34.4%.

Table 5. Initial values for positional deviation optimization (unit: linear error components/μm; angular error components/μrad).

Error item	Allowable range	Error item	Error item	Error item	Allowable range
δ_{XX}	$[-7.56, 7.56]$	δ_{XZ}	$[-7.56, 7.56]$	δ_{YC}	$[-7.56, 7.56]$
δ_{YX}	$[-7.56, 7.56]$	δ_{YZ}	$[-7.56, 7.56]$	δ_{ZC}	$[-7.56, 7.56]$
δ_{ZX}	$[-7.56, 7.56]$	δ_{ZZ}	$[-7.56, 7.56]$	S_{XY}	$[-15.1, 15.1]$
ε_{ZX}	$[-15.1, 15.1]$	δ_{XB}	$[-7.56, 7.56]$	S_{BX}	$[-15.1, 15.1]$
δ_{XY}	$[-7.56, 7.56]$	δ_{YB}	$[-7.56, 7.56]$	o_{BX}	$[-7.56, 7.56]$
δ_{YY}	$[-7.56, 7.56]$	δ_{ZB}	$[-7.56, 7.56]$	o_{BZ}	$[-7.56, 7.56]$
δ_{ZY}	$[-7.56, 7.56]$	δ_{XC}	$[-7.56, 7.56]$	o_{CX}	$[-7.56, 7.56]$
				o_{CY}	$[-7.56, 7.56]$

Total estimated cost only considering the error components above:

$$C_{\text{total}} = \sum_{i=1}^{21} C(T_i) = \sum_{i=1}^{21} \frac{k_i}{T_i^2} = 11{,}778{,}153$$

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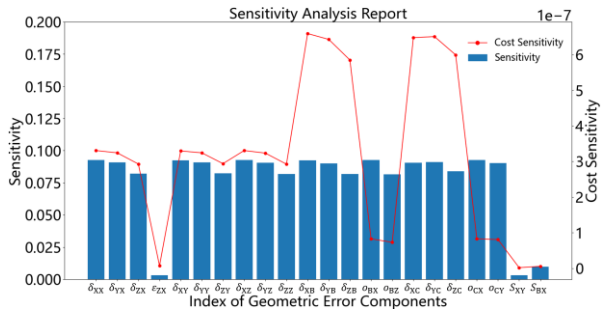
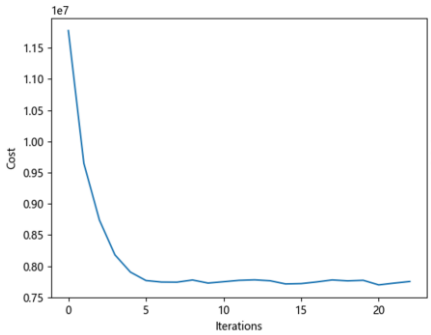
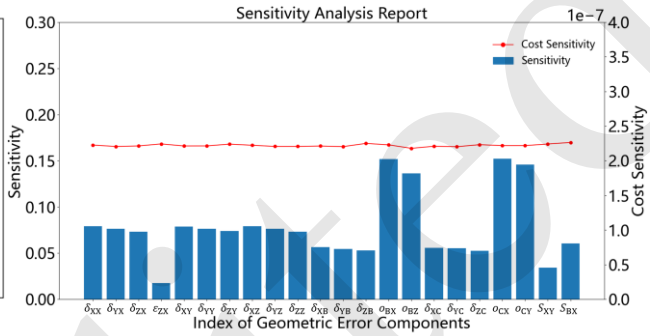


Fig. 7. Sensitivity analysis of positional deviation for initial tolerance values.



(a) Iterative optimization process



(b) Sensitivity analysis results after convergence

Fig. 8. Optimization results of positional deviation.

5.4 Allocation results and verification

In the two adjustment iterations, the cost sensitivities of the geometric error components involved in the adjustments tended to be equal, and both the tool direction deviation and positional deviations reached the target precision, indicating that the method converged. The accuracy allocation scheme, as shown in Tables 4 and 6, includes the allowable ranges of all geometric error components that need to be determined. From Tables 4 and 6, it can be determined that the total estimated cost of the allocation scheme is 15,163,102.

Table 6. Final values of positional deviation optimization (unit: linear error components/μm; angular error components/μrad).

Error item	Allowable range	Error item	Allowable range	Error item	Allowable range
δ_{XX}	$[-6.71, 6.71]$	δ_{XZ}	$[-6.71, 6.71]$	δ_{YC}	$[-5.64, 5.64]$
δ_{YX}	$[-6.80, 6.80]$	δ_{YZ}	$[-6.81, 6.81]$	δ_{ZC}	$[-5.83, 5.83]$
δ_{ZX}	$[-6.95, 6.95]$	δ_{ZZ}	$[-6.95, 6.95]$	S_{XY}	$[-51.2, 51.2]$
ε_{ZX}	$[-35.9, 35.9]$	δ_{XB}	$[-5.59, 5.59]$	S_{BX}	$[-38.7, 38.7]$
δ_{XY}	$[-6.71, 6.71]$	δ_{YB}	$[-5.69, 5.69]$	o_{BX}	$[-9.70, 9.70]$
δ_{YY}	$[-6.81, 6.81]$	δ_{ZB}	$[-5.84, 5.84]$	o_{BZ}	$[-10.11, 10.11]$
δ_{ZY}	$[-6.95, 6.95]$	δ_{XC}	$[-5.63, 5.63]$	o_{CX}	$[-9.65, 9.65]$
				o_{CY}	$[-9.86, 9.86]$

Total estimated cost only considering the error components above:

$$C_{\text{total}} = \sum_{i=1}^{21} C(T_i) = \sum_{i=1}^{21} \frac{k_i}{T_i^2} = 7{,}720{,}581$$

A uniform allocation scheme was used for comparison with our allocation method. Essentially, a distribution scheme with uniform allocation of linear and angular errors is used to achieve the same target precision, with the resulting geometric error tolerance list shown in Table 7.

Table 7. The uniform allocation scheme (unit: linear error components/μm; angular error components/μrad).

Error item	Allowable range	Error item	Allowable range	Error item	Allowable range
δ_{XX}	$[-7.42, 7.42]$	ε_{XZ}	$[-18.2, 18.2]$	S_{XY}	$[-14.8, 14.8]$
δ_{YX}	$[-7.42, 7.42]$	ε_{YZ}	$[-18.2, 18.2]$	S_{YZ}	$[-18.2, 18.2]$
δ_{ZX}	$[-7.42, 7.42]$	ε_{ZZ}	$[-20.0, 20.0]$	S_{XZ}	$[-18.2, 18.2]$
ε_{XX}	$[-18.2, 18.2]$	δ_{XB}	$[-7.42, 7.42]$	S_{BX}	$[-14.8, 14.8]$
ε_{YX}	$[-18.2, 18.2]$	δ_{YB}	$[-7.42, 7.42]$	S_{BZ}	$[-18.2, 18.2]$
ε_{ZX}	$[-14.8, 14.8]$	δ_{ZB}	$[-7.42, 7.42]$	S_{CX}	$[-18.2, 18.2]$
δ_{XY}	$[-7.42, 7.42]$	ε_{XB}	$[-18.2, 18.2]$	S_{CY}	$[-18.2, 18.2]$
δ_{YY}	$[-7.42, 7.42]$	ε_{YB}	$[-18.2, 18.2]$	o_{BX}	$[-7.42, 7.42]$
δ_{ZY}	$[-7.42, 7.42]$	ε_{ZB}	$[-18.2, 18.2]$	o_{BZ}	$[-7.42, 7.42]$
ε_{XY}	$[-18.2, 18.2]$	δ_{XC}	$[-7.42, 7.42]$	o_{CX}	$[-7.42, 7.42]$
ε_{YY}	$[-18.2, 18.2]$	δ_{YC}	$[-7.42, 7.42]$	o_{CY}	$[-7.42, 7.42]$
ε_{ZY}	$[-20.0, 20.0]$	δ_{ZC}	$[-7.42, 7.42]$		
δ_{XZ}	$[-7.42, 7.42]$	ε_{XC}	$[-18.2, 18.2]$		
δ_{YZ}	$[-7.42, 7.42]$	ε_{YC}	$[-18.2, 18.2]$		
δ_{ZZ}	$[-7.42, 7.42]$	ε_{ZC}	$[-18.2, 18.2]$		

Total estimated cost: $C_{\text{total}} = \sum_{i=1}^{39} C(T_i) = \sum_{i=1}^{39} \frac{k_i}{T_i^2} = 20{,}997{,}862$

The simulation results indicate that compared to the uniform allocation scheme, our accuracy alloca-

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tion scheme reduces the overall geometric error estimated cost by 27.8% (from 20,997,862 to 15,163,102), while maintaining the target precision for both tool direction deviation and positional deviations.

A total of 10,000 random sampling points were selected in a uniform distribution across the machine tool's workspace along each axis, and the number and frequency of points satisfying $|\boldsymbol{\Delta V}| \leq 40\,\mu\text{rad}$ for tool direction deviation and $|\boldsymbol{\Delta P}| \leq 20\mu\text{m}$ for positional deviation were counted under the accuracy allocation. The results are presented in Table 8, showing that the frequencies fall within the interval of 95±1%. This indicates that the allocation scheme meets the previously mentioned target precisions for both positional and tool direction deviations.

Table 8. Deviation statistics of randomly sampled points within the workspace.

	Quantity of Points	Frequency (%)
$\boldsymbol{\lvert\Delta V\rvert \leq 40\mu\text{rad}}$	9,550	95.50
$\boldsymbol{\lvert\Delta P\rvert \leq 20\mu\text{m}}$	9,416	94.16

Using both the uniform allocation scheme shown in Table 7 and the proposed accuracy allocation scheme, simulations were conducted for machining an inclined conical part, as shown in Fig. 9. The simulation results are presented in Fig. 10, Fig. 11, and Table 9. In Fig. 10, (a) and (b) represent the positional deviation of both allocation schemes. In Fig. 11, (a) and (b) represent the tool direction deviation of both allocation schemes. One can see that both allocation schemes yield the same accuracy. From Table 9, it is clear that our proposed method achieves a reduction in geometric error cost while maintaining the overall precision of the machine tool.

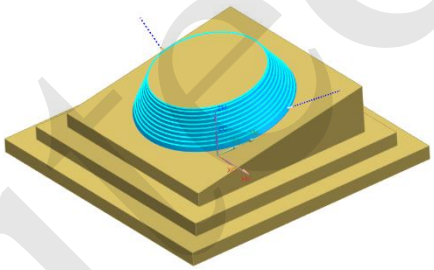
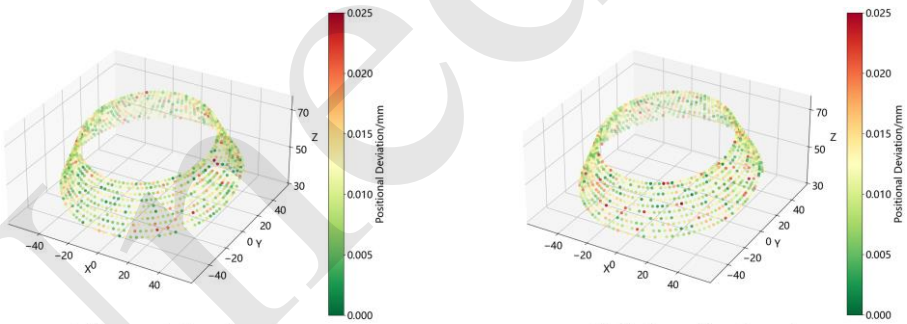
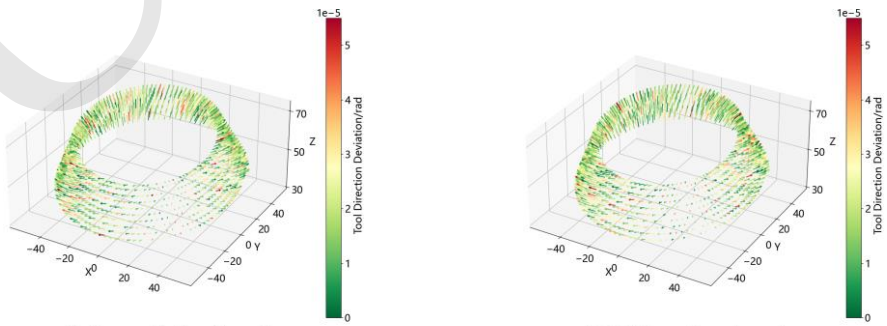


Fig. 9. Inclined conical workpiece.



(a) Proposed allocation scheme (b) Uniform allocation scheme

Fig. 10. Simulated machining results of positional deviation.



(a) Proposed allocation scheme (b) Uniform allocation scheme

Fig. 11. Simulated machining results of tool direction deviation.

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Table 9. Comparison of simulated machining results.

	Uniform Allocation Scheme	Allocation Scheme by Our Proposed Method	Improvement Rate
Mean Positional Deviation/mm	0.0108	0.0107	-0.93%
Variance of Positional Deviation/mm^2	2.04×10^{-5}	1.94×10^{-5}	/
Frequency of $\lvert\Delta P\rvert \le 20\mu m$	0.9688	0.9696	+0.08%
Mean Tool direction deviation/rad	2.00×10^{-5}	1.99×10^{-5}	-0.50%
Variance of Tool direction deviation/rad^2	1.08×10^{-10}	1.15×10^{-10}	/
Frequency of $\lvert\Delta V\rvert \le 40\mu rad$	0.9584	0.9592	+0.08%
Estimated Cost	20,997,862	15,163,102	-27.8%

5.5 Verification of priority for tool direction deviation

To verify the sequence of adjusting the error components does indeed impact the allocation results, a comparative simulation was conducted; specifically, the error components that do not affect tool direction deviation are allocated first and those that do are allocated second. That is to say, the positional accuracy is allocated first while the tool direction accuracy is allocated second. This is the opposite of our proposed method. The two-step allocation results are listed in Tables 10 and 11.

Table 10. Final values of positional deviation optimization (unit: linear error components/μm; angular error components/μrad).

Error item	Allowable range	Error item	Allowable range	Error item	Allowable range
δ_{XX}	$[-6.34, 6.34]$	δ_{XZ}	$[-6.33, 6.33]$	δ_{YC}	$[-5.35, 5.35]$
δ_{YX}	$[-6.42, 6.42]$	δ_{YZ}	$[-6.42, 6.42]$	δ_{ZC}	$[-5.54, 5.54]$
δ_{ZX}	$[-6.64, 6.64]$	δ_{ZZ}	$[-6.65, 6.65]$	S_{XY}	$[-48.7, 48.7]$
ε_{ZX}	$[-34.1, 34.1]$	δ_{XB}	$[-5.32, 5.32]$	S_{BX}	$[-36.7, 36.7]$
δ_{XY}	$[-6.33, 6.33]$	δ_{YB}	$[-5.36, 5.36]$	o_{BX}	$[-9.12, 9.12]$
δ_{YY}	$[-6.42, 6.42]$	δ_{ZB}	$[-5.54, 5.54]$	o_{BZ}	$[-9.68, 9.68]$
δ_{ZY}	$[-6.66, 6.66]$	δ_{XC}	$[-5.34, 5.34]$	o_{CX}	$[-9.16, 9.16]$
				o_{CY}	$[-9.26, 9.26]$

Total estimated cost only considering the error components above:

$$C_{\text{total}} = \sum_{i=1}^{21} C(T_i) = \sum_{i=1}^{21} \frac{k_i}{T_i^2} = 8{,}603{,}772$$

Table 11. Final values of tool direction deviation optimization (unit: μrad).

Error item	Allowable range	Error item	Allowable range	Error item	Allowable range
ε_{XX}	$[-15.6, 15.6]$	ε_{XB}	$[-15.4, 15.4]$	S_{YZ}	$[-22.5, 22.5]$
ε_{YX}	$[-15.9, 15.9]$	ε_{YB}	$[-13.3, 13.3]$	S_{XZ}	$[-23.1, 23.1]$
ε_{XY}	$[-15.6, 15.6]$	ε_{ZB}	$[-15.7, 15.7]$	S_{BZ}	$[-22.5, 22.5]$
ε_{YY}	$[-15.9, 15.9]$	ε_{XC}	$[-14.2, 14.2]$	S_{CX}	$[-23.1, 23.1]$
ε_{XZ}	$[-15.6, 15.6]$	ε_{YC}	$[-14.1, 14.1]$	S_{CY}	$[-26.6, 26.6]$
ε_{YZ}	$[-15.9, 15.9]$	ε_{ZC}	$[-15.7, 15.7]$		

Total estimated cost only considering the error components above:

$$C_{\text{total}} = \sum_{i=1}^{18} C(T_i) = \sum_{i=1}^{18} \frac{k_i}{T_i^2} = 7{,}462{,}941$$

From Tables 6 and 10, one can observe that the sequence of adjusting the error components indeed affects the allocation results, which is reflected in how all the error components are allocated to narrower allowable ranges (see Table 10). Thus, the total estimated cost has increased from 7,720,581 to 8,603,772. However, looking at Tables 4 and 11, the results are almost unchanged.

The effects of the adjusting sequence and the difference between the two types of error components can be explained by the following: when allocating positional accuracy in the comparative simulation, each error component affecting tool direction deviation remained at its original standard $[-20, 20]$ μrad, which could not meet the tool direction accuracy requirement. However, when allocating positional accuracy in the formal experiment, the directional accuracy had already been allocated, and the error components affecting tool direction deviation were adjusted to a higher precision standard than $[-20, 20]$ μrad. Thus, in the comparative simulation, the error components in Table 10 had to be adjusted to narrower allowable ranges to compensate for the differences in angular error components. For both the formal and comparative simulations, the process for directional accuracy allocation involved the same input, and hence there are limited differences between the results shown in Tables 4 and 11.

Thus, one can conclude that the effects of the adjusting sequence are related to the original standards of the error components that affect tool direction deviation. If the adjusting sequence of the comparative simulation is used, then when the original standard of the error components affecting tool direction deviation is lower than the directional accuracy requirement (as in the case of this study), the allocation results will be tilted towards excess precision. In

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contrast, when the standard is higher than the requirement, the allocation results will lean towards a lack of precision. Both results are not conducive to obtaining an optimal allocation scheme. However, the adjusting sequence of the formal experiment solved this exact problem. If the adjusting sequence from our proposed method is used, regardless of whether the original standard of the angular error components is higher or lower than the required accuracy, the allocation results are similar without an excess or lack of precision. Thus, the necessity of the adjusting sequence has been demonstrated.

Similarly, a total of 10,000 points were randomly sampled to verify the accuracy of the allocation scheme. The results are listed in Table 12.

Table 12. Deviation statistics of the randomly sampled points within the workspace.

	Formal Experiment	Comparative Simulation
Frequency of $\lvert\Delta V\rvert \leq 40\mu\text{rad}$	95.50%	95.59%
Frequency of $\lvert\Delta P\rvert \leq 20\mu\text{m}$	94.16%	94.32%
Estimated Cost	15,163,102	16,066,713

These results are in line with expectation that the positional accuracy and the estimated cost would increase, which is a situation of excess precision and waste of cost.

6 Conclusions

In this study we established a geometric error model for five-axis machine tools, comprising 41 error components, and based on the theory of muti-body systems and homogeneous transform matrices (HTM). We also proposed a Sobol sensitivity analysis method for geometric error components in the general workspace of the machine tool.

By combining the cost and sensitivity of geometric error components, the concept of cost sensitivity for the error components was introduced. Also, an accuracy test criterion for the tool direction and positional deviations was established, along with an algorithm to achieve the target accuracy. This approach accounts for both cost considerations and the equivalence of overall accuracy.

We suggested a two-step allocation method for the geometric error components: first, allocate those components that affect tool direction deviations, and then allocate the remaining error components. Moreover, a simulation example using a ZYXBC-type dual-rotary-table machine tool was shown to demonstrate the feasibility of the method. The simulation results showed that the accuracy allocation scheme met the target accuracy with the lowest cost. The geometric error cost was also reduced by 27.8% compared to a uniform allocation scheme, confirming the method's effectiveness. We also conducted another comparative simulation to demonstrate the necessity of the adjusting sequence derived from our method.

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Author contributions

Xiaojian LIU, Ao JIAO, Yang WANG, Guodong YI, Xiangyu GAO, Xiaochen ZHANG, Yiming ZHANG, Yangjian JI, Shuyou ZHANG and Jianrong TAN designed the research. Ao JIAO processed the corresponding data. Ao JIAO wrote the first draft of the manuscript. Xiaojian LIU helped to organize the manuscript. Xiaojian LIU, Ao JIAO revised and edited the final version.

Conflict of interest

The authors have no relevant financial or non-financial interests to disclose.

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Electronic supplementary materials

Section S1, Fig. S1

中文概要

题　　目：基于几何误差成本灵敏度和姿态偏差先行的五轴机床精度分配方法

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目　　的： 现有五轴机床精度分配方法主要考虑位置偏差，而较少考虑刀具姿态偏差。本文旨在研究一种将刀具姿态纳入考虑的五轴机床精度分配新方法，同时兼顾成本和总体精度，从而得到以合理成本实现目标位置和姿态精度的分配方案，为机床精度正向设计提供量化参考。

创新点： 1. 开发优先考虑刀具姿态偏差的五轴机床精度分配方法；2. 提出几何误差成本灵敏度以实现成本优化的精度分配

方　　法： 1. 基于齐次变换矩阵构建由 41 个误差分量组成的五轴机床几何误差模型（公式(S1)-(S3)）；2. 提出成本灵敏度（公式(5)）和优先考虑姿态偏差的两步精度分配方法（图 4）；3. 通过仿真模拟，所提出的精度分配方法对一台 BC 双转台五轴机床的几何精度进行优化设

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计，验证所提出方法的可行性和有效性（图10和11）。

结　　论： 1. 结合误差分类成本分析和灵敏度分析提出了兼顾成本和总体精度的成本灵敏度指标，提出了机床精度检验准则和实现目标精度的算法；2. 提出了先分配影响刀具姿态的误差分量、后分配其余分量的两步精度分配算法；3. 通过对一台BC双转台五轴机床的几何精度进行仿真优化设计，仿真结果表明，几何误差成本相比均匀分配方案降低了27.8%，从而验证了方法的可行性和有效性。

关键词： 五轴机床；精度分配；几何误差建模；误差成本灵敏度；刀具姿态偏差优先

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