



SLOVENSKI STANDARD
SIST EN 28430-2:1999

01-december-1999

Elektrouporovno varjenje – Držala elektrod – 2. del: Konična pritrditev, Morsejev konus (ISO 8430-2:1988)

Resistance spot welding - Electrode holders - Part 2: Morse taper fixing (ISO 8430-2:1988)

Widerstandspunktschweißen - Elektrodenhalter - Teil 2: Morsekegelbefestigung (ISO 8430-2:1988)

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Soudage par points par résistance - Porte-électrodes - Partie 2: Cône Morse de fixation (ISO 8430-2:1988)

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Ta slovenski standard je istoveten z: EN 28430-2:1992

ICS:

25.160.30

Varilna oprema

Welding equipment

SIST EN 28430-2:1999

en

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EUROPEAN STANDARD

EN 28430-2:1992

NORME EUROPÉENNE

EUROPÄISCHE NORM

May 1992

UDC 621.791.763.1.039

Descriptors: Welding, resistance welding, spot welding, resistance welding electrodes, electrode holders, dimensions, designation

English version

Resistance spot welding - Electrode holders - Part 2: Morse taper fixing (ISO 8430-2:1988)

Soudage par points par résistance -
Porte-électrodes - Partie 2: Cône Morse de
fixation (ISO 8430-2:1988)

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This European Standard was approved by CEN on 1992-05-22. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

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FOREWORD

In September 1991, CEN Technical Board decided to submit the International Standard

ISO 8430-2:1988 - "Resistance spot welding - Electrode holders - Part 2: Morse taper fixing"

to the formal vote procedure. The result was positive and the standard is now adopted as a European Standard.

National standards identical to this European Standard shall be published at the latest by 1992-11-30 and conflicting national standards shall be withdrawn at the latest by 1992-11-30.

According to the CEN/CENELEC Common Rules the following countries are bound to implement this European Standard : Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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Endorsement notice

The text of the International Standard ISO 8430-2:1988 was approved by CEN as a European Standard without any modification.

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INTERNATIONAL STANDARD

ISO
8430-2

First edition
1988-12-01



INTERNATIONAL ORGANIZATION FOR STANDARDIZATION
ORGANISATION INTERNATIONALE DE NORMALISATION
МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ

Resistance spot welding — Electrode holders —

Part 2 : Morse taper fixing

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Soudage par points par résistance — Porte-électrodes —

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 8430-2 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*.

ISO 8430 consists of the following parts, under the general title *Resistance spot welding — Electrode holders*:

- *Part 1: Taper fixing 1 : 10*
- *Part 2: Morse taper fixing*
- *Part 3: Parallel shank fixing for end thrust*

Resistance spot welding — Electrode holders —

Part 2 : Morse taper fixing

1 Scope

This part of ISO 8430 specifies the dimensions and tolerances of resistance spot welding electrode holders (type B) without offset and with a facility for cable clamping, and where a male Morse taper is used to fix the holder directly to the welding cylinder in multiple spot welding equipment.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 8430. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 8430 are encouraged to investigate the possibility of applying the most recent editions of the standards listed below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 1642 : 1987, *Plastics — Industrial laminated sheets based on thermosetting resins — Specification.*

ISO 5182 : 1978, *Materials for resistance welding electrodes and ancillary equipment.*

ISO 5183-1 : 1988, *Resistance spot welding — Electrode adaptors, male taper 1:10 — Part 1 : Conical fixing, taper 1:10.*

ISO 5821 : 1979, *Resistance spot welding electrode caps.*

ISO 5822 : 1982, *Spot welding equipment — Taper plug gauges and taper ring gauges.*

ISO 5828 : 1983, *Resistance welding equipment — Secondary connecting cables with terminals connected to water-cooled lugs — Dimensions and characteristics.*

ISO 7285 : —¹⁾, *Pneumatic cylinders for mechanized multiple spot welding.*

ISO 9313 : 1988, *Resistance spot welding equipment — Cooling tubes.*

3 Dimensions

The dimensions shall be those given in figure 1 and table 1.

1) To be published.

4 Designation

The designations of electrode holders which comply with this part of ISO 8430 shall comprise the following information in the order given :

- the description block (i.e. "spot welding electrode holder");
- a reference to this part of ISO 8430;
- the type of electrode holder (type B);
- the reference diameter, in millimetres;
- the total length, l_4 , in millimetres;
- the material of which the electrode holder is made, in accordance with ISO 5182.

Example:

A type B (Morse fixing) spot welding electrode holder, of reference diameter 16 mm, total length $l_4 = 103$ mm and material type A 2/1, shall be designated as follows:

Spot welding electrode holder
ISO 8430-2-B-16 × 103-A 2/1

5 Materials

The material of which the electrode holder is made shall be in accordance with ISO 5182, preferably group A, type 2.

The insulation shall be made of the following material: fabric base laminate ISO 1642-PFCC2.

6 Delivery conditions

The fixing shall be protected against damage, e.g. by a coating of synthetic resin.

7 Marking

Electrode holders complying with this part of ISO 8430 shall be marked with the designation laid down in clause 4, but excluding the description block and the reference number of this part of ISO 8430, for example:

B-16 × 103-A 2/1

Dimensions in millimetres,
surface roughness values in micrometres

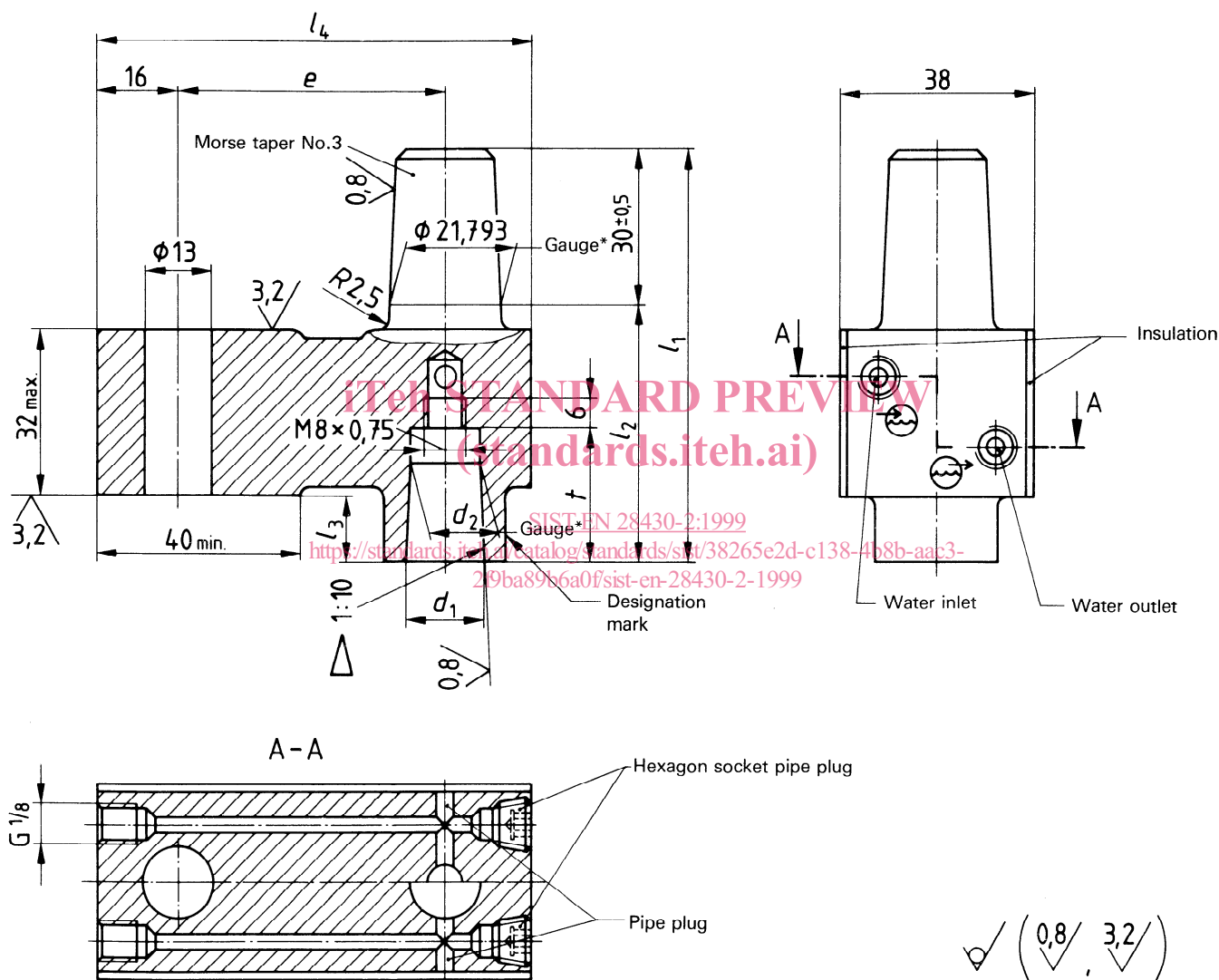


Figure 1 – Dimensions

* For the taper gauge, see ISO 5822.