
**Resistance welding — Locking tapers
for electrode holders and electrode
caps**

*Soudage par résistance — Cônes de serrage pour porte-électrodes et
pointes d'électrodes*

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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see www.iso.org/patents).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

The committee responsible for this document is ISO/TC 44, *Welding and allied processes*, Subcommittee SC 6, *Resistance welding and allied mechanical joining*.

Requests for official interpretations of any aspect of this document should be directed to the Secretariat of ISO/TC 44/SC 6 via your national standards body. A complete listing of these bodies can be found at www.iso.org.

Resistance welding — Locking tapers for electrode holders and electrode caps

1 Scope

This document specifies the dimensions and tolerances for electrode holders and of spot welding electrode caps, where a locking taper is used.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 5182, *Resistance welding — Materials for electrodes and ancillary equipment*

ISO 5821, *Resistance welding — Spot welding electrode caps*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 17677-1 and the following apply. ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

3.1

locking taper

taper allowing for a tight fit between an electrode holder and the electrode cap as their taper angles differ by $0^{\circ} 2' 60''$, ensuring the electrode cap engagement point is at the skirt of the cap and electrode holder

Note 1 to entry: See [Figure 1](#).

Note 2 to entry: Traditionally called “Fisher taper”.

Note 3 to entry: During welding, the electrode cap tightens further on the electrode holder.

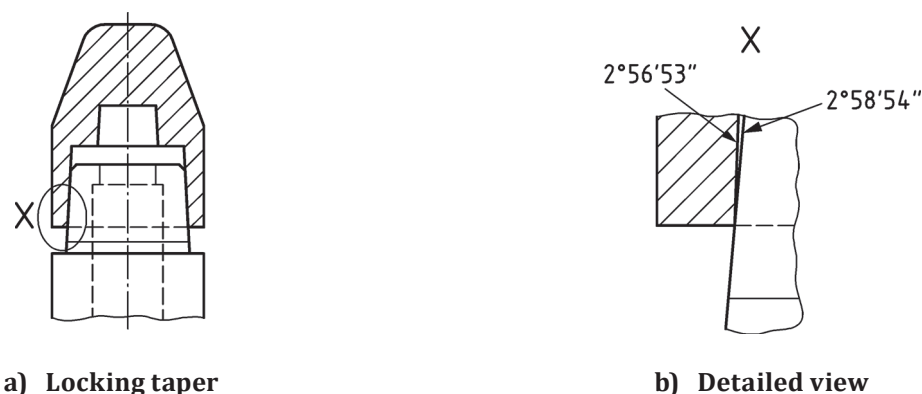


Figure 1 — Principle of a locking taper