

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 1089

DIMENSIONS OF TUBULAR ELECTRODE HOLDERS
FOR SPOT WELDING MACHINES

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1. SCOPE

This ISO Recommendation concerns tubular electrode holders designed to take straight or cranked electrodes.

2. FIELD OF APPLICATION

This ISO Recommendation applies to the dimensions of a series of tubular electrode holders designed to take straight or cranked electrodes,* except for the 20 mm, 50 mm and 63 mm sizes which are for straight electrodes only.

3. SIZE

The size of an electrode holder is described by referring to the nominal diameter which is the outside diameter of the holder (dimension H). Electrode holders are of the following sizes : 20 mm, 25 mm, 31.5 mm, 40 mm, 50 mm and 63 mm.

4. DIMENSIONS

Electrode holders should conform to the dimensions shown in the Table on the opposite page.

* For this reason, the dimension T on the Figure, opposite, allows lengths of taper greater than those given in ISO Recommendation R 670, *Dimensions of straight resistance spot welding electrodes*.