

**Kontaktpunktkeevitus. Elektroodide üleminekupuksid, pistikkoonused 1:10. Osa 2: Elektroodikorpuste paralleelne kinnitus elektroodiotsadele jõu rakendamiseks**

Resistance spot welding - Electrode adaptors, male taper 1:10 - Part 2: Parallel shank fixing for end-thrust electrodes

## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

Käesolev Eesti standard EVS-EN 25183-2:1999 sisaldab Euroopa standardi EN 25183-2:1991 ingliskeelset teksti.

Standard on kinnitatud Eesti Standardikeskuse 12.12.1999 käskkirjaga ja jõustub sellekohase teate avaldamisel EVS Teatajas.

Standard on kättesaadav Eesti standardiorganisatsioonist.

This Estonian standard EVS-EN 25183-2:1999 consists of the English text of the European standard EN 25183-2:1991.

This standard is ratified with the order of Estonian Centre for Standardisation dated 12.12.1999 and is endorsed with the notification published in the official bulletin of the Estonian national standardisation organisation.

The standard is available from Estonian standardisation organisation.

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elektroodid, keevitus, keevitusseadmed, kontakeevituse elektroodid, kontaktkeevitus, mõõtmel, punktkeevitus, tähistus

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revised!

ref. EN ISO 5183-2:2001

EUROPEAN STANDARD

EN 25183-2:1991

NORME EUROPEENNE

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EUROPAISCHE NORM

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Descriptors : Resistance welding, spot welding, welding equipment, resistance welding electrodes, tools extensions, spigot-and-socket joints, dimensions, designations, marking

### English version

Resistance spot welding - Electrode adaptors, male taper 1 : 10 - Part 2 : Parallel shank fixing for end-thrust electrodes (ISO 5183-2:1988)

Soudage par points par résistance -  
Allonges d'électrode à embout amovible  
cône mâle 1 : 10 - Partie 2 :  
Emmanchement cylindrique pour poussée  
en bout (ISO 5183-2:1988)

Widerstandsschweißen -  
Elektrodenschäfte mit Außenkegel 1:10  
- Teil 2: Zylindrische Befestigung für  
gerade Beanspruchung (ISO 5183-2:1988)

This European Standard was approved by CEN on 1991-10-31 and is identical to the ISO standard as referred to.

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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.

This European Standard exists 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.

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CEN

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

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### FOREWORD

In 1989, ISO 5183-2:1988 was submitted to CEN Primary Questionnaire-procedure.

Following the positive result of the Primary Questionnaire, the CEN Technical Bureau agreed to submit ISO 5183-2:1988, without modifications, to Formal Vote.

In accordance with the Common CEN/CENELEC 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.

### Endorsement notice

The text of the International Standard ISO 5183-2:1988 was approved by CEN as a European Standard without any modification.

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# INTERNATIONAL STANDARD

ISO  
5183-2

First edition  
1988-12-01



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

**Resistance spot welding — Electrode adaptors, male  
taper 1 : 10 —**

**Part 2 :**  
Parallel shank fixing for end-thrust electrodes

*Soudage par points par résistance — Allonges d'électrode à embout amovible  
(cône mâle 1 : 10) —*

*Partie 2: Emmanchement cylindrique pour poussée en bout*

Reference number  
ISO 5183-2: 1988 (E)

## 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 5183-2 was prepared by Technical Committee ISO/TC 44, *Welding and allied processes*.

Together with ISO 5183-1, ISO 5183-2 cancels and replaces ISO 5183 : 1979, of which it constitutes a technical revision.

ISO 5183 consists of the following parts, under the general title *Resistance spot welding — Electrode adaptors, male taper 1 : 10*

- Part 1: Conical fixing, taper 1 : 10
- Part 2: Parallel shank fixing for end-thrust electrodes

# Resistance spot welding — Electrode adaptors, male taper 1 : 10

## Part 2 : Parallel shank fixing for end-thrust electrodes

### 1 Scope

This part of ISO 5183 specifies the dimensions and tolerances of resistance spot welding electrode adaptors where the fixing element for the cap (see ISO 5821) is a male taper and a parallel shaft is used to fix the adaptor to the electrode holder. The taper fits for fixing the electrode cap conform to ISO 1089.

### 2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 5183. 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 5183 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 1089 : 1980, *Electrode taper fits for spot welding equipment — Dimensions*.

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 8430-3 : 1988, *Resistance spot welding — Electrode holders — Part 3: Parallel shank fixing for end thrust*.

### 3 Dimensions

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

### 4 Designation

The designations of electrode adaptors which comply with this part of ISO 5183 shall comprise the following information in the order given :

- the description block (i.e. "spot welding electrode adaptor");
- a reference to this part of ISO 5183;
- the type of electrode adaptor;
- the diameter,  $d_1$ , in millimetres;
- the length,  $l_1$ , in millimetres;
- the material of which the electrode adaptor is made, in accordance with ISO 5182.

*Example:* A type C spot welding electrode adaptor (parallel shank fixing), of diameter  $d_1 = 16$  mm, length  $l_1 = 68$  mm and material type A 2/1, shall be designated as follows:

**Spot welding electrode adaptor**  
**ISO 5183-2 - C - 16 × 68 - A 2/1**

### 5 Materials

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

### 6 Marking

Electrode adaptors complying with this part of ISO 5183 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 5183, for example :

**C - 16 × 68 - A 2/1**