
International Standard



865

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

Slots in platens for projection welding machines

Rainures des plateaux des machines à souder par bossages

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Descriptors : welding, welding equipment, T-slots, dimensions.

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

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.

International Standard ISO 865 was developed by Technical Committee ISO/TC 44, *Welding and allied processes*, and was circulated to the member bodies in November 1979.

It has been approved by the member bodies of the following countries :

Belgium	India	Poland
Bulgaria	Ireland	Portugal
Canada	Italy	Romania
China	Japan	Spain
Czechoslovakia	Korea, Rep. of	Sweden
France	New Zealand	USSR
Germany, F. R.	Norway	

The member bodies of the following countries expressed disapproval of the document on technical grounds :

Finland
United Kingdom

This International Standard cancels and replaces ISO Recommendation R 865-1968, of which it constitutes a technical revision.

Slots in platens for projection welding machines

1 Scope and field of application

This International Standard specifies requirements for dimensions, pitch and location of T-slots on platens for projection welding machines.

2 Reference

ISO 299, *Machine tool tables — T-slots and corresponding bolts*.

3 Dimensions on T-slots

The dimensions of T-slots in the platens of resistance welding machines shall be in accordance with the indications given in the table.

NOTE — When, in special circumstances, it is necessary to depart from the slot size given in the table, the dimensions shall be in accordance with those given in ISO 299.

4 Pitch, number and location of the T-slots

The pitch of T-slots shall be $63 \pm 0,5$ mm. The tolerance of the total dimension between any two T-slots (regardless of the number of slots between) shall be $\pm 0,5$ mm.

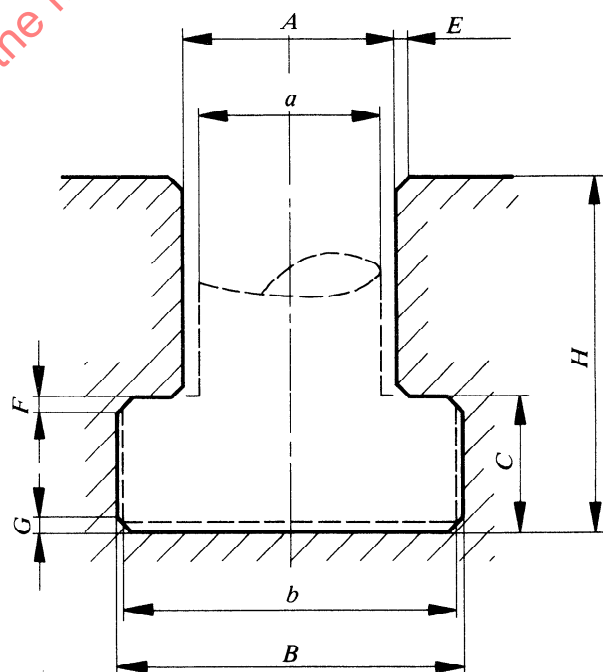
The number of T-slots shall be even. However, for small machines (i.e. with a maximum force of 5 kN), it is permissible to use platens with an odd number of slots where the central slot is located in the centre line of the platen.

The lower slot shall be positioned at 90° relative to the upper slot. Whenever possible, it is recommended that the upper slots should be parallel to the throat.

5 Designation

The relevant number of slots in a platen shall be specified after the reference ISO 865, for example the designation of a platen with 4 T-slots is:

Platen ISO 865-4



Table

Dimensions in millimetres

Electrode force	A	B	C	H	a*	b*	E max.	F max.	G max.
< 5 kN	12 H12	19 ⁺² / ₀	9 ⁺¹ / ₀	21 ⁺² / ₀	10	18	1	0,6	1
> 5 kN	14 H12	23 ⁺² / ₀	11 ⁺¹ / ₀	24 ⁺² / ₀	12	22	1,6	0,6	1,6

* For information only.