

DIN EN ISO 7285:2021-04 (E)

Pneumatic cylinders for mechanized multiple spot welding (ISO 7285:1995)

	Contents	Page
European foreword	4	
Foreword	5	
1 Scope	6	
2 Normative reference	6	
3 Nominal characteristics	6	
3.1 Nominal strokes	6	
3.2 Nominal forces	6	
4 Fixing the cylinder	6	
5 Dimensions	6	
5.1 Outside dimensions	6	
5.2 Bore diameter	6	
6 Operating specifications	7	
6.1 Nominal force	7	
6.2 Return force	7	
6.3 Maximum supply pressure	7	
7 Construction	7	
7.1 Point of application of the reaction	7	
7.2 Piston rod	7	
7.3 Rotation	7	
7.4 Seals	7	
7.5 Perpendicularity -- Parallelism between the mounting point and the attachment	7	
7.6 Leakage	7	
7.7 Behaviour under pressure	7	
7.8 Electrode holder attachment	7	
7.9 Endurance	7	
7.10 Finish	7	
8 Marking	7	
8.1 Identification of the cylinders	7	
8.2 Rating plate	8	
9 Delivery conditions	8	
10 Inspection and type tests	8	
10.1 Visual inspection	8	
10.2 Dimensional inspection	8	
10.3 Inspection of the electrical insulation of the electrode holder attachment	9	
10.4 Pressure type test	9	
10.5 Leak type test	9	
10.6 Separation force type test	9	
10.7 Nominal force type test	9	
10.8 Endurance type test	9	
10.8.1 Test set-up	9	
10.8.2 Air supply	11	

10.8.3	Stroke of the cylinder and number of cycles	11
10.8.4	Welding current	11
10.8.5	Leakage	11
10.8.6	Measurement of play after the endurance test	11
Annex A (normative) Methods of mounting the cylinders		12
Annex B (normative) Electrode holder attachment		14
B.1	Internal electrode holder attachment	14
B.2	External electrode holder attachment	15
Annex C (normative) Mounting methods -- Dimensions		16
C.1	Mounting method A -- Rear simple mounting at right angles	16
C.2	Mounting method B -- Forward flange mounting	18
C.3	Mounting method C -- Rear male-jointed mounting	20
C.4	Mounting method D -- Rear threaded stem mounting	22
C.5	Mounting method E -- Rear double mounting at right angles	24
C.6	Mounting method F -- Collar mounting	26
C.7	Mounting method G -- Gudgeon mounting for pinching	28
C.8	Mounting method H -- Eye mounting for pinching	30
Annex D (informative) Bibliography		32