



AUTOMATION AND ENGINEERING SPECIALISTS

WELD ELECTRODE  
DRESSING SYSTEM

## COMMON HOLDER TECHNOLOGY FOR ELECTRODE DRESSING SYSTEMS

### RSW Electrode Dressing System

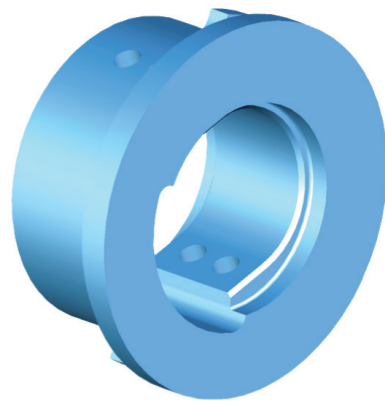
This is a holder system with a common inner core that allows inserts matching to ISO, RWMA and Japanese Electrode Norm profiles to be secured in place.

Utilising separate upper and lower inserts allows an easy mix and match function to customer requirement where differential profiles are used for optimised weld function.

Tolerance and performance are vested specifically in the unique design of the inserts.



Japanese Standard 4Lok Screw Retention



German Standard Bayonet Snaplok Fitting

## DIMENSIONS

All holders are size conformant for fit to the various machines which have the appropriate matching design.

## ORDER INFORMATION

PRODUCT	ORDER CODE	DESCRIPTION
German Standard Holder	H-G-1	No rotation signal
Japanese Standard Holder	H-K-1	No rotation signal
German Standard Holder 1 Sig	H-G-1/1	Single rotation signal
German Standard Holder 2 Sig	H-G-1/2	Double rotation signal
Retek/Semtorq Holder	H-RET-Q-1	Retek Semtorq Dressers

Holders are manufactured from Aircraft grade aluminium, hardened, hard anodised coated and laser marked for identification.

## EXAMPLE CUTTERS FOR ISO F16/RWMA B 5/8"/JAP D16

### Depro Cutter Code 6R8 CW CCWSR

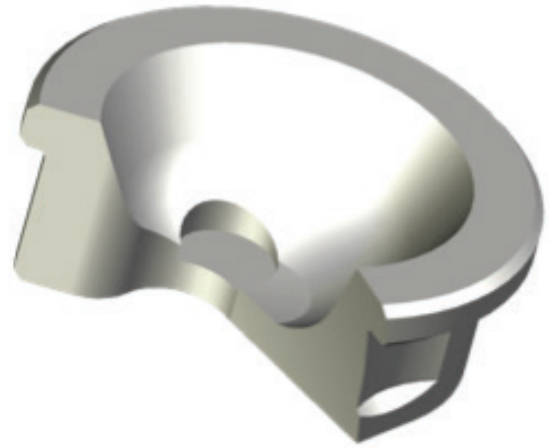
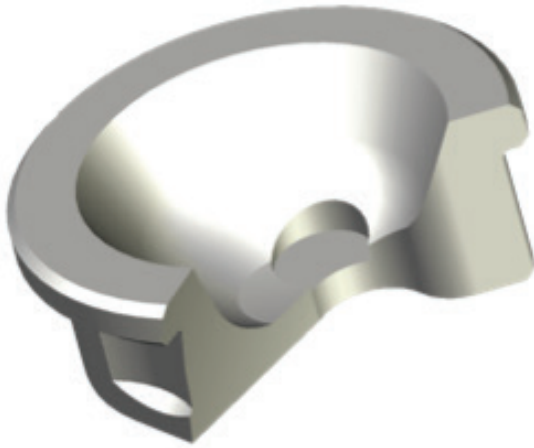
For electrode orientation from 90° approach up to and including a 15° angle offset approach.



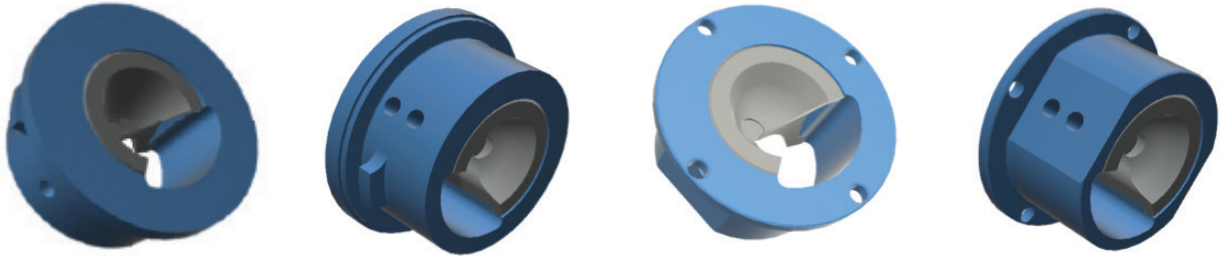
6R8CCWSR



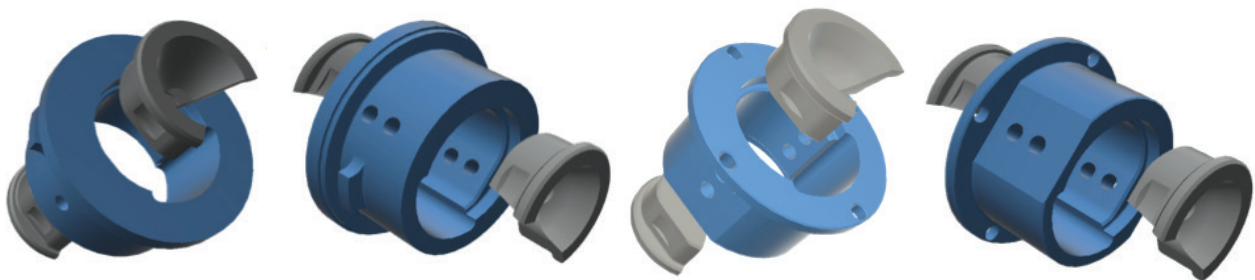
6R8CWSR



## HOLDER INSERT TECHNOLOGY ASSEMBLED



## HOLDER INSERT TECHNOLOGY DISASSEMBLED



Cutter inserts when assembled, regardless of electrode profile, all conform to a combined tolerance base thickness of 4mm.

Servo weld gun positioning and programming is consistent across all styles, making implementation of replacements relatively straightforward and repeatable.

Accurate placement is achieved due to the unique placement design of the holder and insert securing capture and position within the holder.

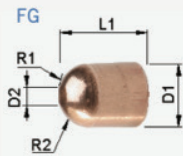
CW & CCW Cutters are incapable of incorrect insertion due to design configuration, thus eliminating incorrect operation and compromised performance.

Inserts materials are available in PMS/HSS material or carbide, dependent on application.

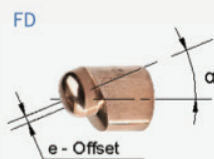
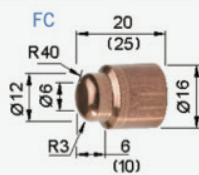
All holders and inserts are designed to fit and perform to the highest quality and provide long lasting, lowest cost of ownership of any such dressing holder and cutter system available.

Inserts are available for the electrodes shown below, plus any special applications arising for aluminium, PHS or Usibor, demanding specific solutions.

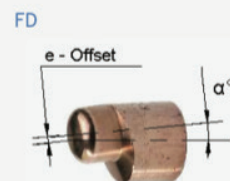
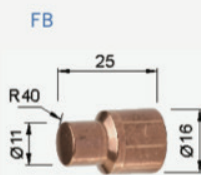
**Female Spot Welding Electrode Caps**



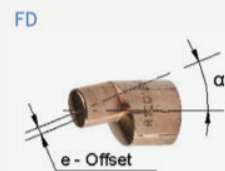
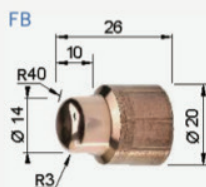
Code	D1	D2	D3	L1	L2	R1	R2	1/x
FG13*02	ø13	5	10	15	8,5	50	6,5	1/10
FG16*04	ø13	6	10	20	9	40	8	1/9,6
FG16*05	ø13	5,5	12	17	10,5	40	8	1/10
FG16*07	ø13	5,5	12	20	10,5	40	8	1/10
FG16*20	ø13	6	12,6	23	10	40	8	1/9,6
FG16*34	ø13	5,5	12	22	10,5	40	8	1/10
FG16*42	ø13	6	12	22	10,5	40	8	1/10



Code	α angle	e offset
FC16*02	0°	0
FC16*03	0°	2
FD16*82	5°	1,5
FD16*83	10°	1,2
FD16*94	15°	0,8
FD16*84	18°	0

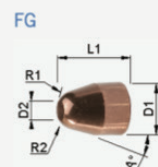
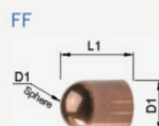
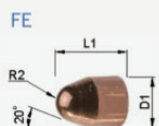
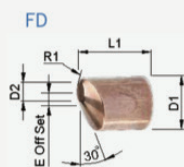
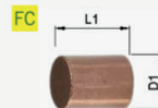
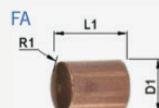
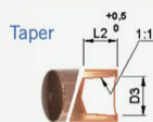


Code	α angle	e offset
FB20*11	0°	0
FD20*16	0°	3
FD20*22	5°	2,2
FD20*20	10°	1,3
FD20*17	15°	0,8



Code	α angle	e offset
FB16*20	0°	0
FD16*14	0°	3
FD16*50	10°	1,3
FD16*19	15°	0,6

**Female Spot Welding Electrode Caps DIN / ISO 5821**



D1	ø13	ø16	ø20
D2	5	6	8
D3	10	12	15
L1	18	20	22
L2	8	10,5	11,5
R1	32	40	50
R2	5	6	8
A°	--	15°	22,5°
E	3	4	6

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