

Spot Weld Accessibility

Choosing appropriate locations for spot welds is extremely important and can greatly affect cycle time, gun configuration, and maintenance or repair of assemblies. The distance a gun moves from one weld to the next should be considered when placing welds. Closer placement can result in faster gun movement and optimized cycle time. Weld gun clearance should be maximized to permit proper access for standard gun designs, otherwise equipment costs can be increased. Generous access holes will help for weld gun tip access and will provide a clear view for weld inspection. However, assembly strength must be considered when designing and locating access holes. Poor access to welds means that non-destructive testing may not be possible.

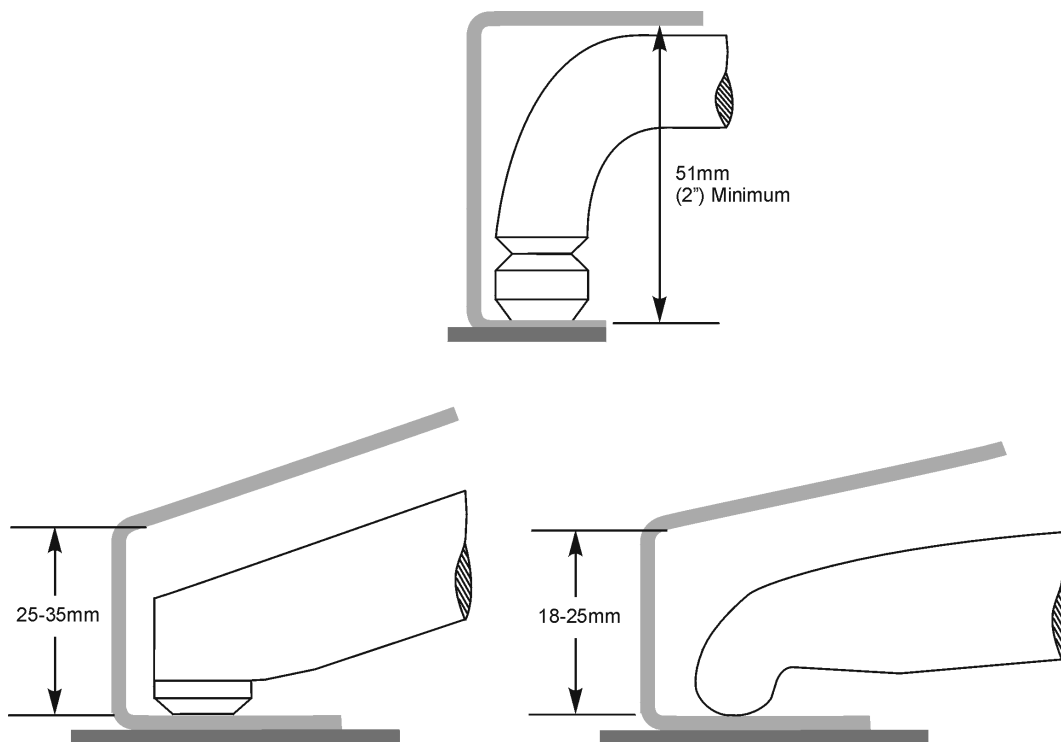


Figure 1-29. Weld Accessibility

Minimum Contour Radius

Spot Welding on curved surfaces can be difficult if the electrodes can not make adequate contact.

Governing Metal Thickness (mm)	Minimum Contour Radius for Welded Surface (mm)
1.5	160
1.7	200
2.5	230

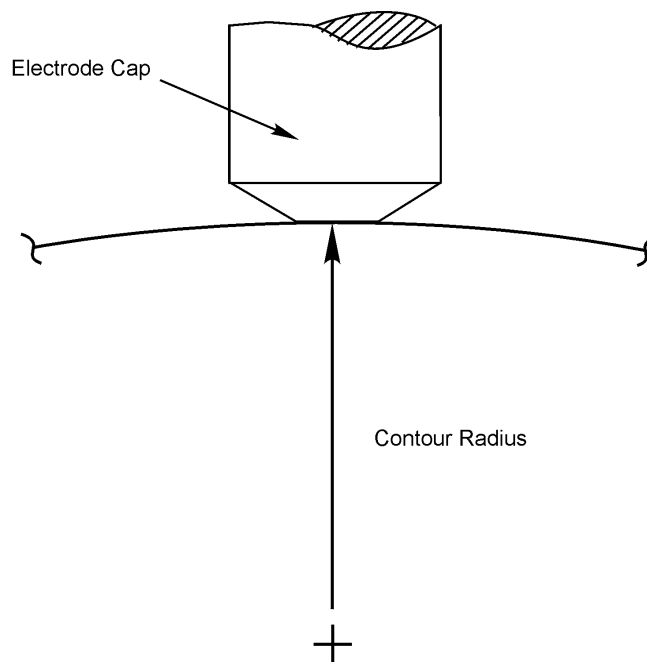


Figure 1-30. Minimum Contour Radius