

INTERNATIONAL
STANDARD

ISO
6550-2

First edition
1994-12-15

**Road vehicles — Sheath-type glow-plugs
with conical seating and their cylinder head
housing —**

Part 2:

M12 × 1,25 glow-plugs

*Véhicules routiers — Bougies de préchauffage à fourreau et à siège
conique, et leur logement dans la culasse —*

Partie 2: Bougies M12 × 1,25



Reference number
ISO 6550-2:1994(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 voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 6550-2 was prepared by Technical Committee ISO/TC 22, *Road vehicles*, Subcommittee SC 1, *Ignition equipment*.

This first edition of ISO 6550-2, together with ISO 6550-1, cancel and replace ISO 6550:1989, which has been split into three parts, part 3 covering M10 glow-plugs.

ISO 6550 consists of the following parts, under the general title *Road vehicles — Sheath-type glow-plugs with conical seating and their cylinder head housing*:

- Part 1: *M14 x 1,25 glow-plugs*
- Part 2: *M12 x 1,25 glow-plugs*
- Part 3: *M10 glow-plugs*

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International Organization for Standardization
Case Postale 56 • CH-1211 Genève 20 • Switzerland

Printed in Switzerland

Road vehicles — Sheath-type glow-plugs with conical seating and their cylinder head housing —

Part 2: M12 × 1,25 glow-plugs

1 Scope

This part of ISO 6550 specifies the main characteristics of M12 × 1,25 sheath-type glow-plugs with conical seating and their cylinder head housing, for use with diesel (compression-ignition) engines.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 6550. 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 6550 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 2705:1991, *Road vehicles — M12 × 1,25 spark-plugs with flat seating and their cylinder head housing*.

ISO 8092-1:—¹⁾, *Road vehicles — Connections for on-board electric harnesses — Part 1: Single-pole connector tabs — Dimensions and specific requirements*.

3 Dimensions and tolerances

3.1 Glow-plugs

Sheath-type glow-plug dimensions and tolerances are given in figure 1.

3.2 Cylinder head housing

The dimensions and tolerances of the cylinder head housing for sheath-type glow-plugs are given in figure 2.

3.3 Dimension limits of thread

The threads of M12 × 1,25 glow-plugs and the corresponding tapped holes in the cylinder head shall conform to the threads specified for M12 × 1,25 spark-plugs in ISO 2705.

4 Installation tightening torque

The installation torque values shall be as given in table 1. The values apply to new sheath-type glow-plugs without lubricant on the threads. If threads are lubricated, the torque value shall be reduced by approximately one-third to avoid overstressing.

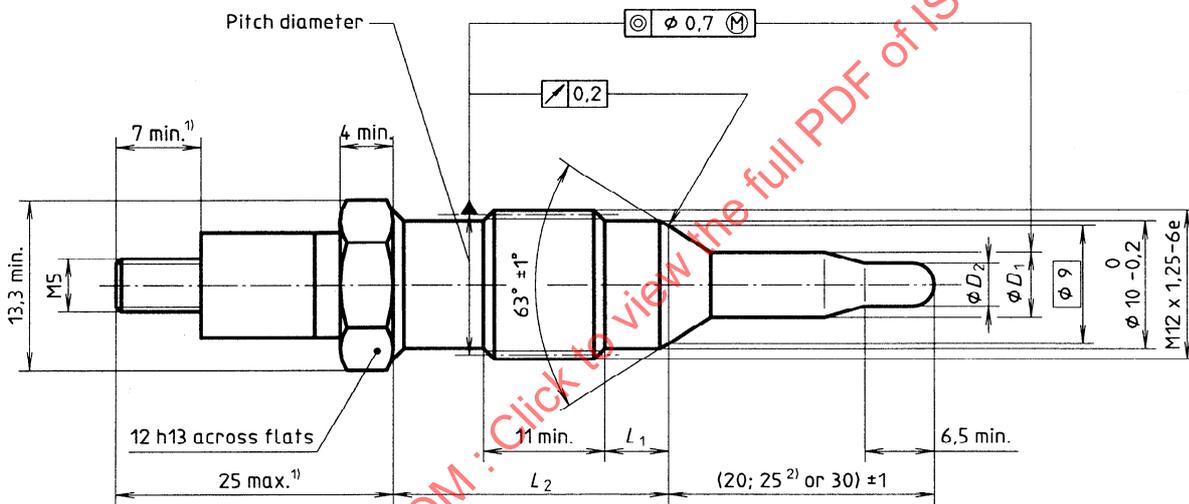
1) To be published. (Revision of ISO 8092-1:1989)

Table 1 — Installation tightening torque

Values in newton metres

Tightening torque	
Cast iron and aluminium cylinder heads	M5 terminal thread ¹⁾
15 to 25	4
NOTE — Engine manufacturers may specify different torques for the first glow-plug installation.	
1) Differing specifications apply to the admissible tightening torque according to the nut used.	

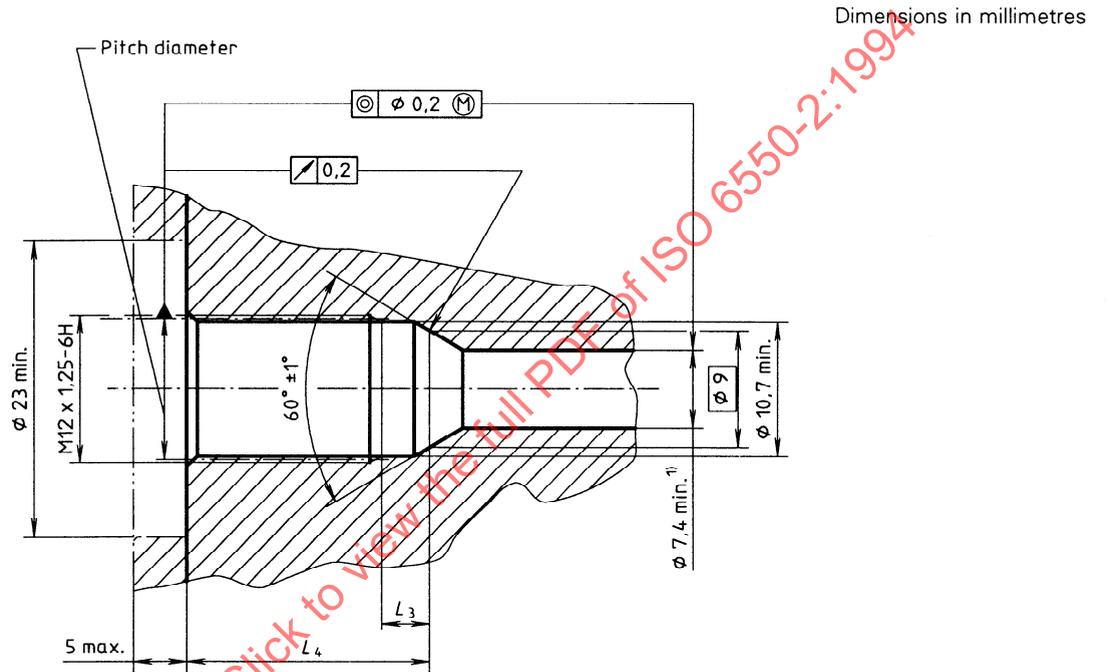
Dimensions in millimetres



- 1) For flat tab terminations of sizes 6,3 and 9,5, the 7 mm min. and 25 mm max. dimensions shall change to 12 mm min. and 30 mm max. respectively. Tab dimensions of these 6,3 mm and 9,5 mm sizes are given in ISO 8092-1.
- 2) The length of 25 mm is preferred.

Glow-plug type	L_1 $\begin{matrix} +1 \\ 0 \end{matrix}$	L_2 ± 1	D_1 $\begin{matrix} 0 \\ -0,3 \end{matrix}$	D_2 $\begin{matrix} 0 \\ -0,2 \end{matrix}$
M12 A1	6	26	6,1	—
M12 A2			5,1	—
M12 A3			5,1	4,1
M12 B	3	20	6,1	—

Figure 1 — M12 × 1,25 sheath-type glow-plug with conical seating



1) The determination of the exact dimension above the minimum is left to the manufacturer. The clearance between the sheath heating element and the cylinder head shall be kept to a minimum.

Glow-plug type	L_3	L_4 max.
M12 A	$5 \begin{smallmatrix} 0 \\ -1 \end{smallmatrix}$	23
M12 B	$2 \begin{smallmatrix} 0 \\ -0,3 \end{smallmatrix}$	17

Figure 2 — Cylinder head housing for glow-plug

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