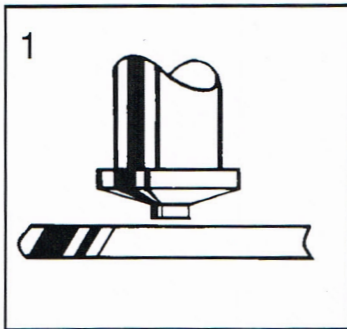
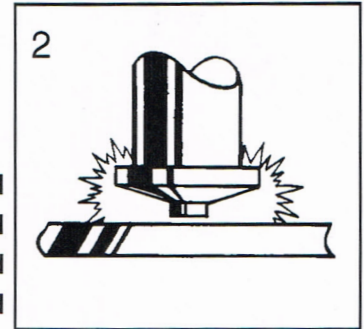


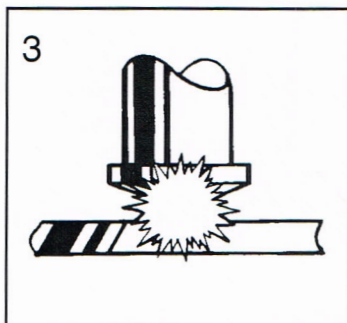
CD**CAPACITOR DISCHARGE****THE PROCESS****CAPACITOR DISCHARGE**

Stud against work

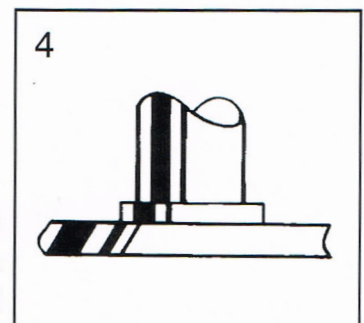
Stored energy discharged
through special
weld "timing" tip and stud
starts downward



Capacitor Discharge (CD) Stud Welding is also a semi-automatic arc welding process. However, with CD welding small diameter fasteners ($1/4$ " and under) are end welded to extremely thin gauge parent metal. The CD process operates on the principle of capacitor stored energy which is instantaneously discharged by the equipment system through a special weld "timing" tip. Since the entire weld cycle is completed in several milliseconds, welds can be made to thin sheet without pronounced distortion, burn-through or discoloration. CD welding permits stud welding of dissimilar metals.

Stud forced into
molten metal

Metal solidifies and
weld is completed in
a split second

**STUD WELDING PRODUCTS, INC.**

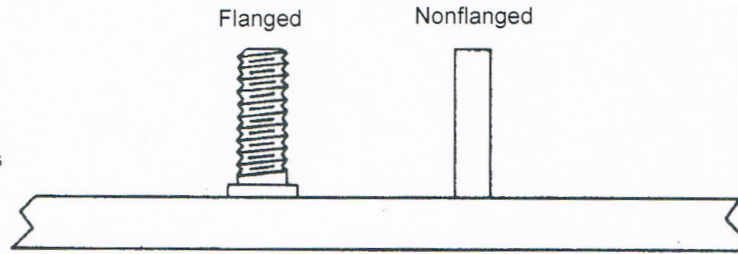
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CD CAPACITOR DISCHARGE

WHY CD STUDS ARE BETTER

No drilling and tapping.
 No cleanup.
 No broken tools.
 Won't vibrate loose.
 No fillet.
 Very fast, 5-6 milliseconds



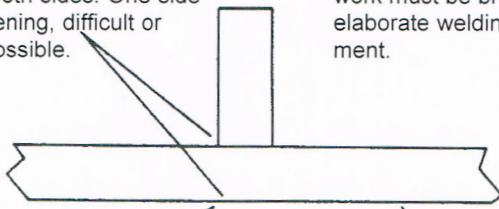
Fastens to most any thickness parent metal from .025" up.

Reverse side can be painted, polished, vinyl-clad or otherwise finished before welding.

Reverse side can be painted, polished, vinyl-clad or otherwise finished before welding.

... than resistance welding

Contact usually required on both sides. One-side fastening, difficult or impossible.



Leaves dimple or burnmarks, requires grinding or polishing.

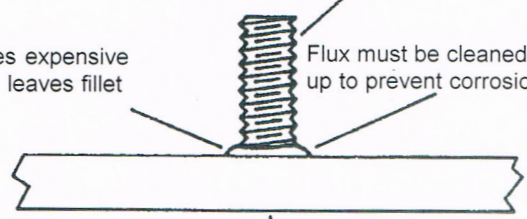
Requires extensive setup, work must be brought to elaborate welding equipment.

Base metal cannot be coated or painted prior to welding.

...than silver soldering or brazing

Work must be clamped in place.

Requires expensive solder, leaves fillet



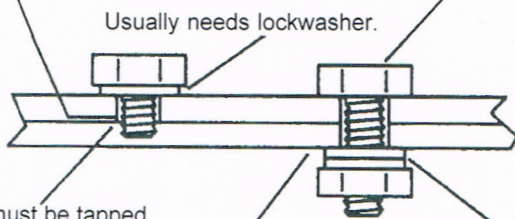
High heat can ruin sensitive components and mar finish.

Needs expensive equipment.

Slow operation.

...than nuts and bolts

Hole must be drilled, can weaken workpiece.



Hole must be tapped, messy cleanup.

Pierces work, mars reverse-side finish.

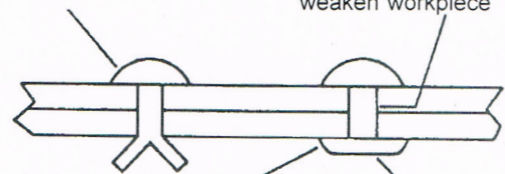
Usually needs lockwasher.

Installation can be a 2-man operation

Needs nut. May need lockwasher or gasket. Can vibrate loose. Permits leaks.

...than rivets

Heads mar reverse-side finish.



Must pass through work, limited to thin metals.

Hole must be drilled, can weaken workpiece

Must be peened over. Can vibrate loose, permit leaks.

Installation can be a 2-man operation

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CAPACITOR DISCHARGE

GENERAL SPECIFICATIONS

CAPACITOR DISCHARGE

MATERIAL: Standard in low carbon steel, 18-8 stainless, and 1100, 6061, and 5000 series aluminum. Brass and other grades of stainless steel are also available.

PLATING: Copper plating is standard. Nickel, zinc, and other platings are available.

ANNEALING: All low carbon steel and stainless steel studs are annealed where required.

THREADS: UNC-2A is standard for external threads prior to plating and UNC-2B for internal threads. Metric and other thread sizes are available.

WELD BASE: Flanged, small-flanged, and non-flanges are available.

STUD LENGTH: CD studs have no appreciable length reduction after welding.

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CD

STUD LOAD/TORQUE STRENGTHS

Stud Material	Stud Size	Maximum Fastening Torque (Inch lbs.)*	Ultimate Tensile Load (lbs.)	Maximum Shear Load (lbs.)
Low-Carbon, Copper-Flashed Steel	6-32	6	500	375
	8-32	12	765	575
	10-24	14	960	720
	1/4-20	43	1750	1300
	5/16-18	72	2900	2200
	3/8-16	106	4300	3250
Stainless Steel	6-32	10	790	590
	8-32	20	1260	940
	10-24	23	1530	1150
	1/4-20	75	2880	2160
	5/16-18	126	3750	5350
	3/8-16	106	4850	7150
Aluminum Alloy 1100	6-32	2.5	200	125
	8-32	5	295	185
	10-24	6.5	380	235
	1/4-20	21.5	670	415
	5/16-18	36	1125	695
	3/8-16	53	1660	1000
Aluminum Alloy 6061	6-32	6.5	350	160
	8-32	13	560	229
	10-24	19	670	310
	1/4-20	40	1240	679
	5/16-18	70.5	2025	1210
	3/8-16	100	2985	1750
Brass 70-30 (260) 65-35 (268)	6-32	8	600	390
	8-32	16	860	560
	10-24	18.5	1040	680
	1/4-20	61	1950	1275
	5/16-18	102	3280	2140
	3/8-16	150	4800	3160

*These values should develop fastener tension to slightly less than yield point.

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CD STUD LOAD/TORQUE STRENGTHS (METRIC STUDS)

Stud Material	Stud Size	Yield Load (lbs.)	Ultimate Load (lbs.)	Yield Torque (Inch lbs.)	Ultimate Torque (Inch lbs.)*
Mild Steel	M3	269	423	6	10
	M4	469	737	15	23
	M5	759	1193	30	47
	M6	1076	1691	51	80
	M8	1960	3080	123	194
	M10	3106	4881	245	384
Stainless Steel	M3	231	577	5	14
	M4	402	1005	13	32
	M5	651	1626	26	32
	M6	922	2306	44	109
	M8	1680	4200	106	265
	M10	2662	6656	210	524
Aluminum 1100	M3	154	161	4	4
	M4	268	281	8	9
	M5	434	455	17	18
	M6	615	646	29	31
Aluminum 5356/5154	M3	223	307	5	7
	M4	389	536	12	17
	M5	629	867	25	34
	M6	892	1230	42	58
	M8	1624	2240	102	141

*Torque figures based on the assumption that excessive deformation of the tread has not taken relationship between torque/tension out of its proportional range.

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CD STUD/BASE METAL

COMBINATION WELDING CAPABILITIES

Base Weld Surface Material	Stud Material			
	Mild Steel 1008, 1010	Stainless 304, 305	Aluminum 1100, 6061	Brass 70-30, 65-35
Mild Steel 1006 through 1030	Excellent	Excellent	—	Excellent
Medium Carbon Steel 1030 through 1050	Good*	Good*	—	Good*
Galvanized Sheet Duct Or Decking	Excellent	Excellent	—	—
Stainless Steel 405, 410, 430, and 330 Series, except 303	Excellent	Excellent	—	Excellent
Lead Free Brass, Electrolytic Copper, Lead-Free Rolled Copper	Excellent	Excellent	—	Excellent
Most Aluminum Alloys of the 1100, 3000, 5000, and 6000 Series**	—	—	Excellent	—
Die-Cast Zinc Alloys	Good*	Good*	Excellent	Good*

*Good: Generally full strength results, depending upon the combination of stud sized and base metal.

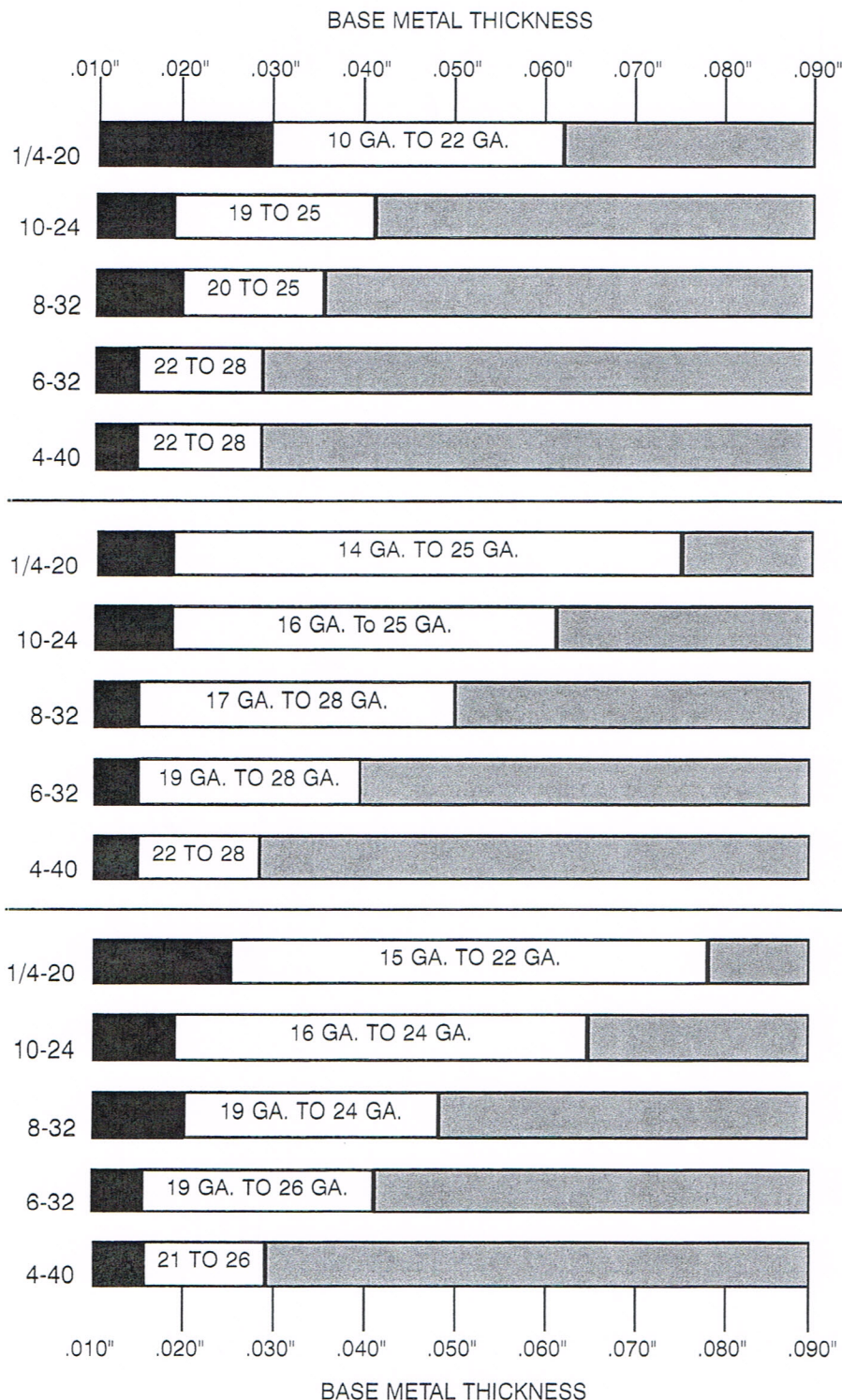
**Other materials, such as 7000 Series aluminum, titanium allys, Inconel, etc. can be welded under specified conditions.

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CD HOW TO FIND THE OPTIMUM COMBINATION OF STUD SIZED AND BASE METAL THICKNESS IN ORDER TO PREVENT REVERSE-SIDE MARKING.



Unacceptable
 Acceptable
 Excellent

MILD STEEL
BASE METAL: Mild Steel
STUD: Mild Steel, Flanged or Small Flanged

STAINLESS STEEL
BASE METAL: Stainless Steel
STUD: Stainless Steel, Flanged or Small Flanged

ALUMINUM
BASE METAL: Aluminum
STUD: Aluminum, Flanged or Small Flanged

NOTE: Stud tip size can influence the degree of reverse-side marking.

CD STUDS WEIGHT CHARTS

<i>ESTIMATED WEIGHTS OF THREADED STUDS IN POUNDS PER 1000 PIECES</i>						
LENGTH	4-40	6-32	8-32	10-24	1/4-20	5/16-18
1/4	.69	1.00	1.39	1.79	3.08	4.90
3/8	.94	1.38	1.93	2.50	4.37	6.98
1/2	1.18	1.76	2.49	3.21	5.66	9.06
5/8	1.43	2.13	3.04	3.93	6.95	11.13
3/4	1.67	2.51	3.60	4.64	8.24	13.21
7/8	1.92	2.89	4.15	5.35	9.52	15.29
1	2.16	3.26	4.71	6.07	10.81	17.36
1-1/4	2.65	4.02	5.82	7.50	13.39	21.52
1-1/2	3.15	4.77	6.93	8.92	15.96	25.67
1-3/4	3.64	5.52	8.04	10.35	18.54	29.83
2	4.13	6.27	9.15	11.78	21.12	33.98
2-1/4	4.62	7.03	10.26	13.21	23.69	38.14
2-1/2	5.11	7.78	11.37	14.63	27.27	42.29
EACH ADD'L INCH	1.96	3.01	4.44	5.71	10.31	16.62

<i>ESTIMATED WEIGHTS OF NON-THREADED STUDS IN POUNDS PER 1000 PIECES</i>						
LENGTH	3/32	1/8	5-32	3/16	1/4	5/16
1/4	.68	1.06	1.59	2.24	3.87	5.97
3/8	.92	1.50	2.27	3.21	5.61	8.68
1/2	1.16	1.93	2.94	4.19	7.35	11.39
5/8	1.40	2.37	3.62	5.16	9.09	14.11
3/4	1.64	2.80	4.30	6.14	10.84	16.82
7/8	1.88	3.24	4.98	7.12	12.56	19.53
1	2.12	3.67	5.65	8.09	14.32	22.25
1-1/4	2.60	4.54	7.01	10.04	17.81	27.67
1-1/2	3.08	5.41	8.36	11.99	21.69	33.10
1-3/4	3.56	6.28	9.72	13.95	24.78	38.52
2	4.04	7.15	11.07	15.90	28.25	43.95
2-1/4	4.52	8.02	12.43	17.85	31.75	49.37
2-1/2	5.00	8.89	13.78	19.80	35.23	54.80
EACH ADD'L INCH	1.96	3.48	5.42	7.81	13.94	21.70

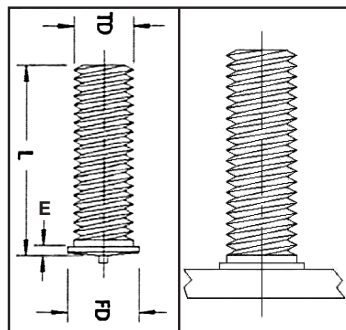
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FL FLANGED

CD Flanged UN-2A Stud



TYPE CD STUD
FULLY THREADED CAPACITOR
DISCHARGE STUD - FLANGED
NO FERRULE NEEDED

TD	FD	E (MS & SS)	E (aluminum)	Length Tolerance
4 40	.197/.177	.040/.030	.050/.040	0.015/-0.005
6 32	.228/.208	.040/.030	.050/.040	0.015/-0.005
8 32	.260/.240	.040/.030	.050/.040	0.015/-0.005
10 24	.260/.240	.045/.035	.050/.040	0.015/-0.005
10 32	.260/.240	.045/.035	.050/.040	0.015/-0.005
14 20	.322/.302	.050/.040	.050/.040	0.015/-0.005
516 18	0.380	.050/.040	//////////	0.015/-0.005
38 16	0.437	0.065	//////////	0.015/-0.005

E = flanged thickness, FD = flanged dia., TD = thread dia., ND = nominal dia.

L Length	#4 40	#6 32	#8 32	#10 24	1/4 20	5/16 18	3/8 16
1/4	FL-- 440 14	FL-- 632 14	FL-- 832 14	FL-- 1024 14	FL-- 1420 14	FL-- 51618 14	FL-- 3816 14
3/8	FL-- 440 38	FL-- 632 38	FL-- 832 38	FL-- 1024 38	FL-- 1420 38	FL-- 51618 38	FL-- 3816 38
1/2	FL-- 440 12	FL-- 632 12	FL-- 832 12	FL-- 1024 12	FL-- 1420 12	FL-- 51618 12	FL-- 3816 12
5/8	FL-- 440 58	FL-- 632 58	FL-- 832 58	FL-- 1024 58	FL-- 1420 58	FL-- 51618 58	FL-- 3816 58
3/4	FL-- 440 34	FL-- 632 34	FL-- 832 34	FL-- 1024 34	FL-- 1420 34	FL-- 51618 34	FL-- 3816 34
7/8	FL-- 440 78	FL-- 632 78	FL-- 832 78	FL-- 1024 78	FL-- 1420 78	FL-- 51618 78	FL-- 3816 78
1	FL-- 440 1	FL-- 632 1	FL-- 832 1	FL-- 1024 1	FL-- 1420 1	FL-- 51618 1	FL-- 3816 1
1 1/4	FL-- 440 114	FL-- 632 114	FL-- 832 114	FL-- 1024 114	FL-- 1420 114	FL-- 51618 114	FL-- 3816 114
1 1/2	FL-- 440 112	FL-- 632 112	FL-- 832 112	FL-- 1024 112	FL-- 1420 112	FL-- 51618 112	FL-- 3816 112
1 3/4	FL-- 440 134	FL-- 632 134	FL-- 832 134	FL-- 1024 134	FL-- 1420 134	FL-- 51618 134	FL-- 3816 134

*-- (insert material type)

Material: Mild Steel (MS), Stainless Steel (SS), Aluminum (AL), and Brass (BR)

Plating: All mild steel studs are copper plating (nickle plating upon request)

Annealing: all studs are annealed where required.

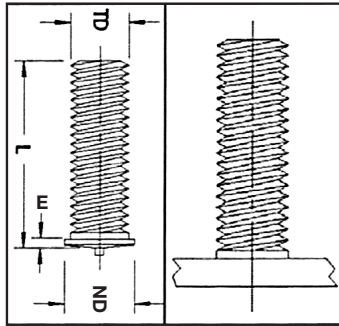
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NFL NON-FLANGED

CD Non-Flanged UN-2A Stud



TYPE NFL STUD
FULLY THREADED CAPACITOR
DISCHARGE STUD - NON FLANGED
NO FERRULE NEEDED

TD	ND	E	E (aluminum)	Length Tolerance
4 40	0.111	0.035	.050/.040	0.015/-0.005
6 32	0.137	0.035	.050/.040	0.015/-0.005
8 32	0.163	0.350	.050/.040	0.015/-0.005
10 24	0.189	0.040	.050/.040	0.015/-0.005
10 32	0.189	0.040	.050/.040	0.015/-0.005
14 20	0.249	0.045	.050/.040	0.015/-0.005
516 18	0.311	0.050	//////////	0.015/-0.005
38 16	0.374	0.065	//////////	0.015/-0.005

E = flanged thickness, FD = flanged dia., TD = thread dia., ND = nominal dia.

L Length	#4 40	#6 32	#8 32	#10 24	1/4 20	5/16 18	3/8 16
1/4	NFL-- 440 14	NFL-- 632 14	NFL-- 832 14	NFL-- 1024 14	NFL-- 1420 14	NFL-- 51618 14	NFL-- 3816 14
3/8	NFL-- 440 38	NFL-- 632 38	NFL-- 832 38	NFL-- 1024 38	NFL-- 1420 38	NFL-- 51618 38	NFL-- 3816 38
1/2	NFL-- 440 12	NFL-- 632 12	NFL-- 832 12	NFL-- 1024 12	NFL-- 1420 12	NFL-- 51618 12	NFL-- 3816 12
5/8	NFL-- 440 58	NFL-- 632 58	NFL-- 832 58	NFL-- 1024 58	NFL-- 1420 58	NFL-- 51618 58	NFL-- 3816 58
3/4	NFL-- 440 34	NFL-- 632 34	NFL-- 832 34	NFL-- 1024 34	NFL-- 1420 34	NFL-- 51618 34	NFL-- 3816 34
7/8	NFL-- 440 78	NFL-- 632 78	NFL-- 832 78	NFL-- 1024 78	NFL-- 1420 78	NFL-- 51618 78	NFL-- 3816 78
1	NFL-- 440 1	NFL-- 632 1	NFL-- 832 1	NFL-- 1024 1	NFL-- 1420 1	NFL-- 51618 1	NFL-- 3816 1
1 1/4	NFL-- 440 114	NFL-- 632 114	NFL-- 832 114	NFL-- 1024 114	NFL-- 1420 114	NFL-- 51618 114	NFL-- 3816 114
1 1/2	NFL-- 440 112	NFL-- 632 112	NFL-- 832 112	NFL-- 1024 112	NFL-- 1420 112	NFL-- 51618 112	NFL-- 3816 112
1 3/4	NFL-- 440 134	NFL-- 632 134	NFL-- 832 134	NFL-- 1024 134	NFL-- 1420 134	NFL-- 51618 134	NFL-- 3816 134

*-- (insert material type)

Material: Mild Steel (MS), Stainless Steel (SS), Aluminum (AL), and Brass (BR)

Plating: All mild steel studs are copper plating (nickle plating upon request)

Annealing: all studs are annealed where required.

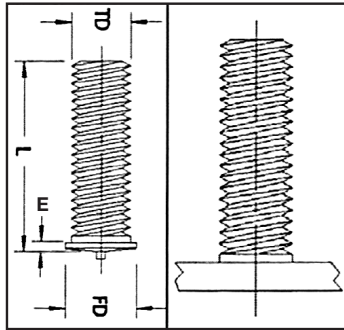
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NFL CD METRIC NON-FLANGED

CD Flanged UN-2A Stud



TYPE CD STUD
FULLY THREADED CAPACITOR
DISCHARGE STUD - FLANGED
NO FERRULE NEEDED

TD	ND (+/- .13 MM)	E	E (aluminum)	Length Tolerance
m3	2.980	1.0/.8	1.2/1.0	*+.4/-.1
m4	3.980	1.0/.8	1.2/1.0	*+.4/-.1
m5	4.980	1.1/.9	1.3/1.0	*+.4/-.1
m6	5.970	1.3/1.1	1.3/1.0	*+.4/-.1
m8	7.970	1.4/1.2	1.4/1.1	*+.4/-.1
m10	9.960	1.8/1.5	//////////	*+.4/-.1

E = flanged thickness, FD = flanged dia., TD = thread dia., ND = nominal dia.

L Length	M3	M4	M5	M6	M8	M10
6	NFL-- 3 6	NFL-- 4 6	NFL-- 5 6	NFL-- 6 6	NFL-- 8 6	NFL-- 10 6
8	NFL-- 3 8	NFL-- 4 8	NFL-- 5 8	NFL-- 6 8	NFL-- 8 8	NFL-- 10 8
10	NFL-- 3 10	NFL-- 4 10	NFL-- 5 10	NFL-- 6 10	NFL-- 8 10	NFL-- 10 10
12	NFL-- 3 12	NFL-- 4 12	NFL-- 5 12	NFL-- 6 12	NFL-- 8 12	NFL-- 10 12
15	NFL-- 3 15	NFL-- 4 15	NFL-- 5 15	NFL-- 6 15	NFL-- 8 15	NFL-- 10 15
16	NFL-- 3 16	NFL-- 4 16	NFL-- 5 16	NFL-- 6 16	NFL-- 8 16	NFL-- 10 16
20	NFL-- 3 20	NFL-- 4 20	NFL-- 5 20	NFL-- 6 20	NFL-- 8 20	NFL-- 10 20
25	NFL-- 3 25	NFL-- 4 25	NFL-- 5 25	NFL-- 6 25	NFL-- 8 25	NFL-- 10 25
30	NFL-- 3 30	NFL-- 4 30	NFL-- 5 30	NFL-- 6 30	NFL-- 8 30	NFL-- 10 30
35	NFL-- 3 35	NFL-- 4 35	NFL-- 5 35	NFL-- 6 35	NFL-- 8 35	NFL-- 10 35
40	NFL-- 3 40	NFL-- 4 40	NFL-- 5 40	NFL-- 6 40	NFL-- 8 40	NFL-- 10 40
45	NFL-- 3 45	NFL-- 4 45	NFL-- 5 45	NFL-- 6 45	NFL-- 8 45	NFL-- 10 45
50	NFL-- 3 50	NFL-- 4 50	NFL-- 5 50	NFL-- 6 50	NFL-- 8 50	NFL-- 10 50
55	NFL-- 3 55	NFL-- 4 55	NFL-- 5 55	NFL-- 6 55	NFL-- 8 55	NFL-- 10 55
60	NFL-- 3 60	NFL-- 4 60	NFL-- 5 60	NFL-- 6 60	NFL-- 8 60	NFL-- 10 60

*-- (insert material type)

Material: Mild Steel (MS), Stainless Steel (SS) and Aluminum (AL)

Plating: All mild steel studs are copper plating (nickle plating upon request)

Annealing: all studs are annealed where required.

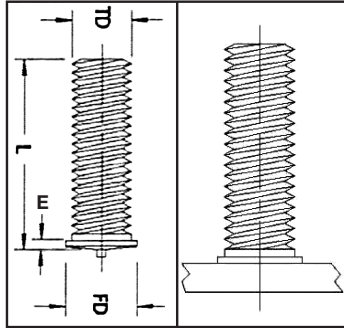
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FL CD MINI FLANGED

CD Mini Flanged Mild UN-2A Stud



TYPE CD STUD
FULLY THREADED CAPACITOR
DISCHARGE STUD - FLANGED
NO FERRULE NEEDED

TD	FD	E	Length Tolerance
4 40	0.142	0.035	0.015/-0.005
6 32	0.168	0.035	0.015/-0.005
8 32	0.194	0.04	0.015/-0.005
10 24	0.22	0.04	0.015/-0.005
10 32	0.22	0.04	0.015/-0.005
14 20	0.28	0.045	0.015/-0.005
516 18	0.355	0.05	0.015/-0.005
38 16	0.418	0.065	0.015/-0.005

E = flanged thickness, FD = flanged dia., TD = thread dia., ND = nominal dia.

L Length	4.40	6 32	8 32	10 32	10 24	1/4 20	5/16 18	3/8 16
1/4	FL--M 440 14	FL--M 632 14	FL--M 832 14	FL--M 1032 14	FL--M 1024 14	FL--M 1420 14	FL--M 51618 14	FL--M 3816 14
3/8	FL--M 440 38	FL--M 632 38	FL--M 832 38	FL--M 1032 38	FL--M 1024 38	FL--M 1420 38	FL--M 51618 38	FL--M 3816 38
1/2	FL--M 440 12	FL--M 632 12	FL--M 832 12	FL--M 1032 12	FL--M 1024 12	FL--M 1420 12	FL--M 51618 12	FL--M 3816 12
5/8	FL--M 440 58	FL--M 632 58	FL--M 832 58	FL--M 1032 58	FL--M 1024 58	FL--M 1420 58	FL--M 51618 58	FL--M 3816 58
3/4	FL--M 440 34	FL--M 632 34	FL--M 832 34	FL--M 1032 34	FL--M 1024 34	FL--M 1420 34	FL--M 51618 34	FL--M 3816 34
7/8	FL--M 440 78	FL--M 632 78	FL--M 832 78	FL--M 1032 78	FL--M 1024 78	FL--M 1420 78	FL--M 51618 78	FL--M 3816 78
1	FL--M 440 1	FL--M 632 1	FL--M 832 1	FL--M 1032 1	FL--M 1024 1	FL--M 1420 1	FL--M 51618 1	FL--M 3816 1
1 1/4	FL--M 440 114	FL--M 632 114	FL--M 832 114	FL--M 1032 114	FL--M 1024 114	FL--M 1420 114	FL--M 51618 114	FL--M 3816 114
1 1/2	FL--M 440 112	FL--M 632 112	FL--M 832 112	FL--M 1032 112	FL--M 1024 112	FL--M 1420 112	FL--M 51618 112	FL--M 3816 112
1 3/4	FL--M 440 134	FL--M 632 134	FL--M 832 134	FL--M 1032 134	FL--M 1024 134	FL--M 1420 134	FL--M 51618 134	FL--M 3816 134
2	FL--M 440 2	FL--M 632 2	FL--M 832 2	FL--M 1032 2	FL--M 1024 2	FL--M 1420 2	FL--M 51618 2	FL--M 3816 2
2 1/4	FL--M 440 214	FL--M 632 214	FL--M 832 214	FL--M 1032 214	FL--M 1024 214	FL--M 1420 214	FL--M 51618 214	FL--M 3816 214
2 1/2	FL--M 440 212	FL--M 632 212	FL--M 832 212	FL--M 1032 212	FL--M 1024 212	FL--M 1420 212	FL--M 51618 212	FL--M 3816 212
3	FL--M 440 3	FL--M 632 3	FL--M 832 3	FL--M 1032 3	FL--M 1024 3	FL--M 1420 3	FL--M 51618 3	FL--M 3816 3

*-- (insert material type)

Material: Mild Steel (MS), Stainless Steel (SS) and Aluminum (AL)

Plating: All mild steel studs are copper plating (nickle plating upon request)

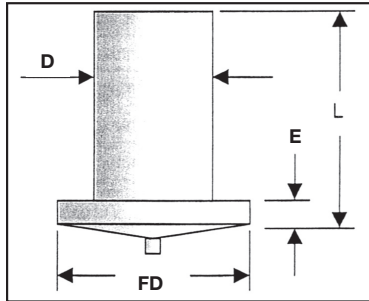
Annealing: all studs are annealed where required.

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FL CD FLANGED WELD PIN (NO THREAD)



D	FD +/- .010	E (MS & SS) +/- .005	E (aluminum)	Length Tolerance
1/8	0.218	0.035	0.045	0.015/-0.005
3/16	0.250	0.04	0.045	0.015/-0.005
1/4	0.325	0.045	0.055	0.015/-0.005
5/16	N/A	0.06	N/A	0.015/-0.005
3/8	N/A	0.065	N/A	0.015/-0.005

E = flanged thickness, FD = flanged dia., TD = thread dia., ND = nominal dia.

L Length	1/8	3/16	1/4	5/16	3/8
1/4	FL-- 18 14	FL-- 316 14	FL-- 14 14	FL-- 516 14	FL-- 38 14
3/8	FL-- 18 38	FL-- 316 38	FL-- 14 38	FL-- 516 38	FL-- 38 38
1/2	FL-- 18 12	FL-- 316 12	FL-- 14 12	FL-- 516 12	FL-- 38 12
5/8	FL-- 18 58	FL-- 316 58	FL-- 14 58	FL-- 516 58	FL-- 38 58
3/4	FL-- 18 34	FL-- 316 34	FL-- 14 34	FL-- 516 34	FL-- 38 34
7/8	FL-- 18 78	FL-- 316 78	FL-- 14 78	FL-- 516 78	FL-- 38 78
1	FL-- 18 1	FL-- 316 1	FL-- 14 1	FL-- 516 1	FL-- 38 1
1 1/4	FL-- 18 114	FL-- 316 114	FL-- 14 114	FL-- 516 114	FL-- 38 114
1 1/2	FL-- 18 112	FL-- 316 112	FL-- 14 112	FL-- 516 112	FL-- 38 112
1 3/4	FL-- 18 134	FL-- 316 134	FL-- 14 134	FL-- 516 134	FL-- 38 134
2	FL-- 28 2	FL-- 316 2	FL-- 14 2	FL-- 516 2	FL-- 38 2
2 1/4	FL-- 18 214	FL-- 316 214	FL-- 14 214	FL-- 516 214	FL-- 38 214
2 1/2	FL-- 18 212	FL-- 316 212	FL-- 14 212	FL-- 516 212	FL-- 38 212
3	FL-- 38 3	FL-- 316 3	FL-- 14 3	FL-- 516 3	FL-- 38 3

*-- (insert material type)

HOW TO ORDER

Specify base diameter, before weld (BW) length, type of material.

Example

3/8 x 1-1/2" (BW) No Thread (NT), stainless steel

Material: Mild Steel (MS), Stainless Steel (SS) and Aluminum (AL)

Plating: All mild steel studs are copper plating (nickle plating upon request)

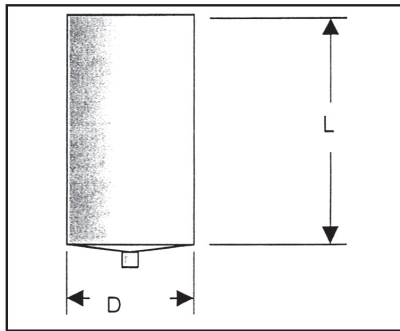
Annealing: all studs are annealed where required.

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NFL CD NON-FLANGED WELD PIN (NO THREAD)



D	Length Tolerance
1/8	0.015/-0.005
3/16	0.015/-0.005
1/4	0.015/-0.005
5/16	0.015/-0.005
3/8	0.015/-0.005

L Length	1/8	3/16	1/4	5/16	3/8
1/4	NFL-- 18 14	NFL-- 316 14	NFL-- 14 14	NFL-- 516 14	NFL-- 38 14
3/8	NFL-- 18 38	NFL-- 316 38	NFL-- 14 38	NFL-- 516 38	NFL-- 38 38
1/2	NFL-- 18 12	NFL-- 316 12	NFL-- 14 12	NFL-- 516 12	NFL-- 38 12
5/8	NFL-- 18 58	NFL-- 316 58	NFL-- 14 58	NFL-- 516 58	NFL-- 38 58
3/4	NFL-- 18 34	NFL-- 316 34	NFL-- 14 34	NFL-- 516 34	NFL-- 38 34
7/8	NFL-- 18 78	NFL-- 316 78	NFL-- 14 78	NFL-- 516 78	NFL-- 38 78
1	NFL-- 18 1	NFL-- 316 1	NFL-- 14 1	NFL-- 516 1	NFL-- 38 1
1 1/4	NFL-- 18 114	NFL-- 316 114	NFL-- 14 114	NFL-- 516 114	NFL-- 38 114
1 1/2	NFL-- 18 112	NFL-- 316 112	NFL-- 14 112	NFL-- 516 112	NFL-- 38 112
1 3/4	NFL-- 18 134	NFL-- 316 134	NFL-- 14 134	NFL-- 516 134	NFL-- 38 134
2	NFL-- 18 2	NFL-- 316 2	NFL-- 14 2	NFL-- 516 2	NFL-- 38 2
2 1/4	NFL-- 18 214	NFL-- 316 214	NFL-- 14 214	NFL-- 516 214	NFL-- 38 214
2 1/2	NFL-- 18 212	NFL-- 316 212	NFL-- 14 212	NFL-- 516 212	NFL-- 38 212
3	NFL-- 18 3	NFL-- 316 3	NFL-- 14 3	NFL-- 516 3	NFL-- 38 3

*-- (insert material type)

HOW TO ORDER

Specify base diameter, before weld (BW) length, type of material.

Example

3/8 x 1-1/2" (BW) No Thread (NT), stainless steel

Material: Mild Steel (MS), Stainless Steel (SS) and Aluminum (AL)

Plating: All mild steel studs are copper plating (nickle plating upon request)

Annealing: all studs are annealed where required.

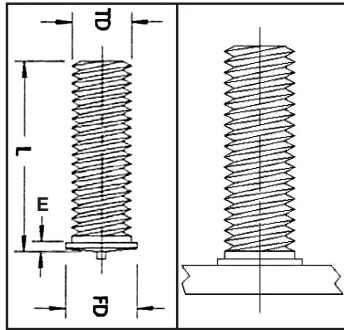
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FL CD METRIC FLANGED

CD Flanged UN-2A Stud



TD	FD	E	E (aluminum)	Length Tolerance
M3-.5	5.3/4.7	1.0/.8	1.2/1.0	*+.4/-.1
M4-.7	6.3/5.7	1.0/.8	1.2/1.0	*+.4/-.1
M5-.8	7.3/6.7	1.1/.9	1.3/1.0	*+.4/-.1
M6-1	8.3/7.7	1.3/1.1	1.3/1.0	*+.4/-.1
M8-1.25	10.8/10.2	1.4/1.2	1.4/1.1	*+.4/-.1
M10-1.5	11.9/11.7	1.8/1.5	//////////	*+.4/-.1

E = flanged thickness, FD = flanged dia., TD = thread dia., ND = nominal dia.

L Length	M3	M4	M5	M6	M8	M10
6	FL-- 3 6	FL-- 4 6	FL-- 5 6	FL-- 6 6	FL-- 8 6	FL-- 10 6
8	FL-- 3 8	FL-- 4 8	FL-- 5 8	FL-- 6 8	FL-- 8 8	FL-- 10 8
10	FL-- 3 10	FL-- 4 10	FL-- 5 10	FL-- 6 10	FL-- 8 10	FL-- 10 10
12	FL-- 3 12	FL-- 4 12	FL-- 5 12	FL-- 6 12	FL-- 8 12	FL-- 10 12
15	FL-- 3 15	FL-- 4 15	FL-- 5 15	FL-- 6 15	FL-- 8 15	FL-- 10 15
16	FL-- 3 16	FL-- 4 16	FL-- 5 16	FL-- 6 16	FL-- 8 16	FL-- 10 16
20	FL-- 3 20	FL-- 4 20	FL-- 5 20	FL-- 6 20	FL-- 8 20	FL-- 10 20
25	FL-- 3 25	FL-- 4 25	FL-- 5 25	FL-- 6 25	FL-- 8 25	FL-- 10 25
30	FL-- 3 30	FL-- 4 30	FL-- 5 30	FL-- 6 30	FL-- 8 30	FL-- 10 30
35	FL-- 3 35	FL-- 4 35	FL-- 5 35	FL-- 6 35	FL-- 8 35	FL-- 10 35
40	FL-- 3 40	FL-- 4 40	FL-- 5 40	FL-- 6 40	FL-- 8 40	FL-- 10 40
45	FL-- 3 45	FL-- 4 45	FL-- 5 45	FL-- 6 45	FL-- 8 45	FL-- 10 45
50	FL-- 3 50	FL-- 4 50	FL-- 5 50	FL-- 6 50	FL-- 8 50	FL-- 10 50
55	FL-- 3 55	FL-- 4 55	FL-- 5 55	FL-- 6 55	FL-- 8 55	FL-- 10 55
60	FL-- 3 60	FL-- 4 60	FL-- 5 60	FL-- 6 60	FL-- 8 60	FL-- 10 60

*-- (insert material type)

Material: Mild Steel (MS), Stainless Steel (SS) and Aluminum (AL)

Plating: All mild steel studs are copper plating (nickle plating upon request)

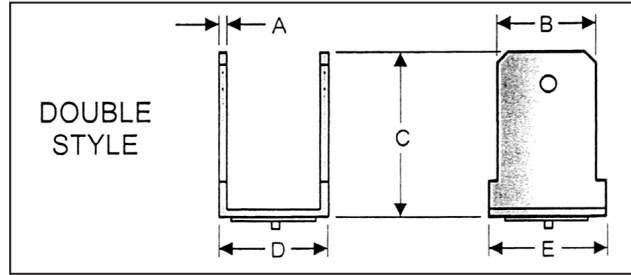
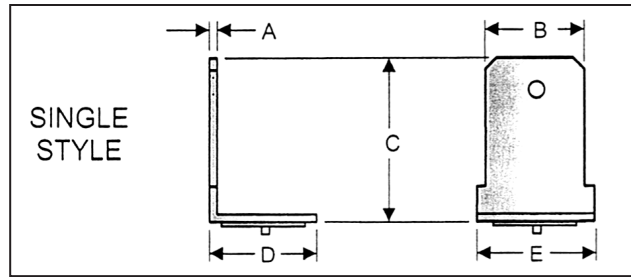
Annealing: all studs are annealed where required.

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NFL CD GROUND STUDS



Style	MATERIAL	PART NUMBER	A	B	C	D	E
SS	Mild Steel (cooper plate)	30-10-063	0.032" (0.8mm)	0.24" (6.3mm)	0.47" (12mm)	0.38" (9.8mm)	0.31" (8mm)
SS	Stainless Steel	30-20-063	0.032" (0.8mm)	0.24" (6.3mm)	0.47" (12mm)	0.38" (9.8mm)	0.31" (8mm)
SS	Aluminum Alloy	30-40-063	0.032" (0.8mm)	0.24" (6.3mm)	0.47" (12mm)	0.38" (9.8mm)	0.31" (8mm)
DS	Mild Steel (cooper plate)	30-12-063	0.032" (0.8mm)	0.24" (6.3mm)	0.47" (12mm)	0.42" (10.9mm)	0.31" (8mm)
DS	Stainless Steel	30-22-063	0.032" (0.8mm)	0.24" (6.3mm)	0.47" (12mm)	0.42" (10.9mm)	0.31" (8mm)
DS	Aluminum Alloy	30-42-063	0.032" (0.8mm)	0.24" (6.3mm)	0.47" (12mm)	0.42" (10.9mm)	0.31" (8mm)

Material: Mild Steel (MS), Stainless Steel (SS) and Aluminum (AL)

Plating: All mild steel studs are copper plating (nickle plating upon request)

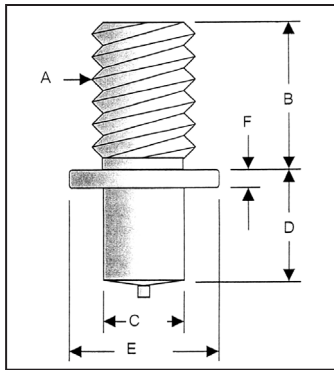
Annealing: all studs are annealed where required.

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CS CD COLLAR STUDS



A (Thread)	C	E	F
1/4-20 UNC	0.215	1/2"	1/8"
5/16-18 UNC	0.275	5/8"	1/8"
3/8-16 UNC	0.330	5/8"	1/8"

HOW TO ORDER

Specify base diameter, before weld (BW) length to the top of the collar, thread size and length, type of material.

Example

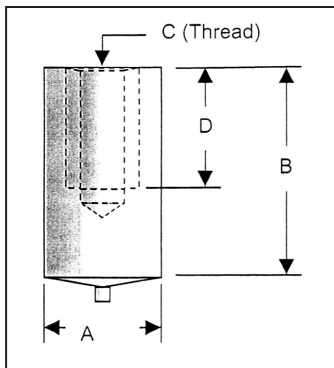
.330 x 1-1/2"(BW) with a 3/8-16 x 3/4" thread extension, collar stud (CK), mild steel

Material: Mild Steel (MS), Stainless Steel (SS) and Aluminum (AL)

Plating: All mild steel studs are copper plating (nickle plating upon request)

Annealing: all studs are annealed where required.

NFL CD TAPPED PADS



A	B	C	D
3/16	3/8" min. 1-1/2" max.	6-32 UNC max.	1/4" min. 3/8" max.
1/4	3/8" min. 1-1/2" max.	8-32 UNC max.	1/4" min. 3/8" max.
5/16	3/8" min. 1-1/2" max.	10-32 UNC max.	1/4" min. 1/2" max.
3/8	3/8" min. 1-1/2" max.v	1/4-20 UNC max.	1/4" min. 3/4" max.

*Tap depth reaches its full strength at 1.5 times thread diameter.

HOW TO ORDER

Specify base diameter, finished length before weld (BW) length, tap size, tap depth and type of material.

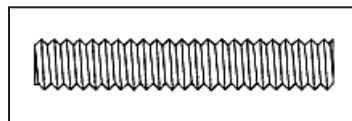
Example

5/8 x 1-1/4" (BW) Tapped Stud (TS) with a 3/8-16 x 7/16 tap, mild steel

Material: Mild Steel (MS), Stainless Steel (SS) and Aluminum (AL)

Plating: All mild steel studs are copper plating (nickle plating upon request)

Annealing: all studs are annealed where required.



Also available, Threaded rod cut of length.

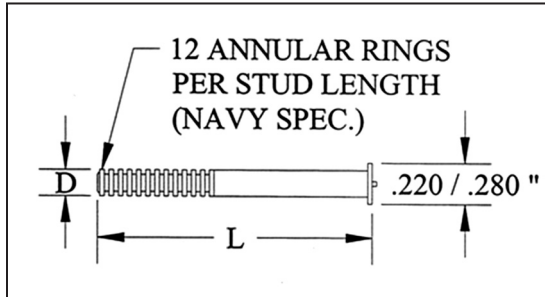
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AR ANNULAR RING (NAVY)

Mild Steel



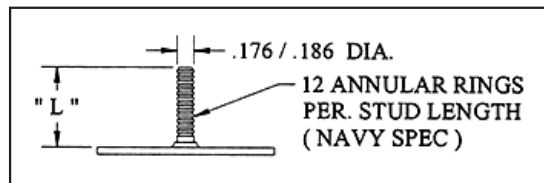
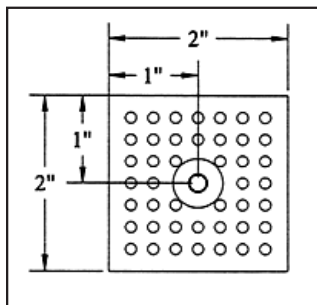
L Length	D	Wgt/M	Part No.
7/8	.175/ .180	6.4	NS-0875
1-2/8	.175/ .180	12.9	NS-1875
2-7/8	.175/ .180	20.0	NS-2875

*Special lengths are available upon request. All steel studs are copper plated

Aluminum

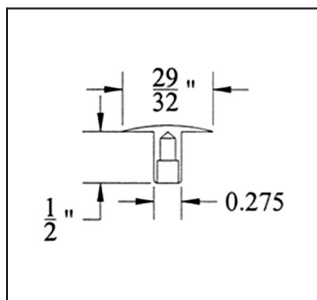
L Length	D	Wgt/M	Part No.
7/8	.175/ .180	2.2	ALNS-0875
1-7/8	.175/ .180	4.7	ALNS-1875
2-7/8	.175/ .180	7.5	ALNS-2875

*Special lengths are available upon request. All steel studs are copper plated



Insul-hangers

Annular Ring Insul-hangers are manufactured in aluminum and steel.
Standard lengths: 7/8" and 1 7/8"
Available in longer lengths and stainless steel upon request.



Mushroom caps

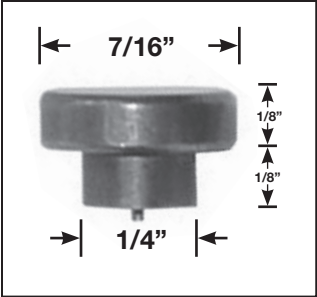
Annular Ring Drive on Caps are available in aluminum.

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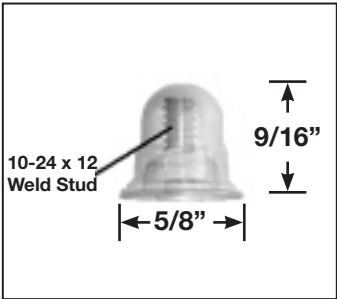
KH KEYHOLE STUDS



Material	Part#
Stainless Steel	KHSS 716181418

Other sizes available, call for part numbers

DC DOME CAP NUTS



Material	Part#
Mild Steel Zinc Plated	KD102410N0E0Q22
Mild Steel Nickel Plated	KD102410NOEQ
Mild Steel Nickel Plate w/ Rubber Seal	KD102410W0ESW

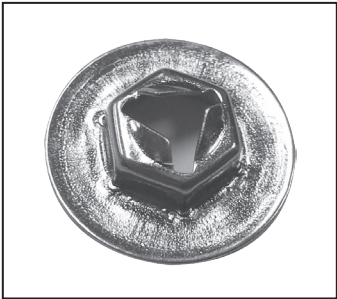
OD OPEN DOME CAP NUTS



Material	Part#
Mild Steel Zinc Plated	KD102410NOEQZZ

Other sizes available, call for part numbers

SN SPEED NUTS

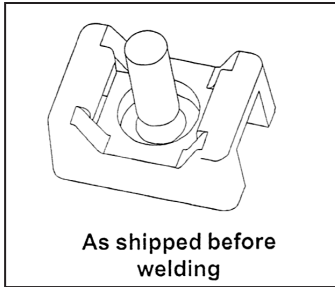


Material	Part#
Mild Steel Zinc Plated	P N Z

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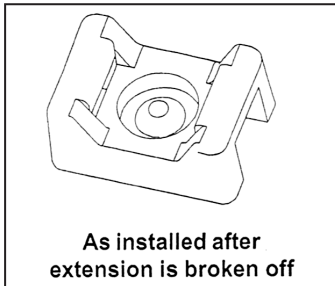
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WT WIRE TIE DOWN STUD



Nylon Wire Tie Mechanical Dimensions

	Inch	mm
Height	0.390	9.90
Length	0.875	22.22
Width	0.625	15.87
Slot Height	0.090	2.29
Slot Width	0.325	8.26



Nylon 6/6 Temperature Index

Temperature Index			
Minimum Thickness	Electrical (°C)	Mechanical w/o Impact (°C)	Hot Wire Ignition (sec)
0.028	125	65	11.8
0.058	125	85	15.0

Nylon 6/6 NBS Smoke Generation

Sample Thickness	UL Flammability	Energy Source	Specific Optical Density	
			at Maximum Smoke Accumulation	at 2 Minutes
1/16"	94 V-2	Radiant (2.5 watts/sq cm)	13	0
1/16"	94 V-2	Radiant Plus Flaming Gas Jets	26	1

Nylon 6/6 Properties

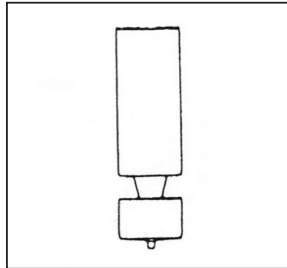
Property	ASTM Method	Test Condition	Units	Nylon 6/6
Tensile Strength	D638	+73° F; 50% RH	kpsi	11.2
Elongation at Break	D638	+73° F; 50% RH	%	>= 300
Yield Strength	D638	+73° F; 50% RH	kpsi	8.5
Shear Strength	D732	Dry as Molded (DAM)	kpsi	9.6
Deformation under load	D621	2,000 psi; +122°F; DAM	%	1.4
IZOD Impact	D256	+73° F; 50% RH	ft lb/in	2.1
Tensile Impact Strength	D1822	+73° F; Long Specimen; DAM	ft lb/in	240
Melting Point	D789	Fisher-Johns	°F	491
Thermal Linear Expansion	D696	DAM	in/in/°F	TBD
Thermal Conductivity	--	DAM Conche-Fitch	BTU-in/h•ft•°F	1.7
Brittleness Temperature	D746	50% RH	°F	-85
Oxygen Index	D2863	DAM	%O	28
Oxygen Index	D2864	50% RH	%O	31
UL Flammability	UL 94	DAM	--	V-2
UL Flammability	UL 95	50% RH	--	V-2

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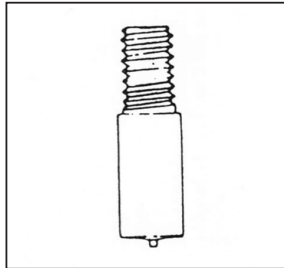
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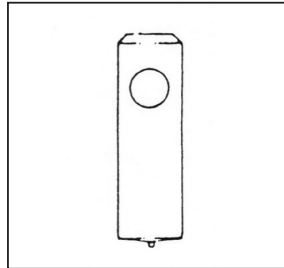
CD MISCELLANEOUS



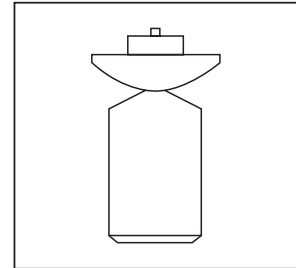
Break-off Pin



Shoulder Pin



Pierced Pin



Name-Plate Pin



Hex Nut



Flat Washer



Lock Washer



Acorn Nut



FirTree Stud



Pain Clearing Stud

Call for more possibilities.

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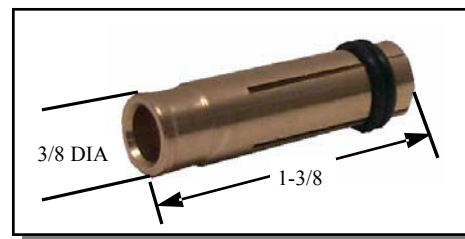
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CAPACITOR DISCHARGE ACCESSORIES

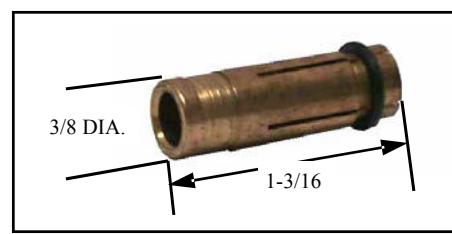
"B" COLLETS

STUD DIA.	PART NO.	PRICE
3 MM	CDB 003M	
14 GA	CDB 008	
12 GA & #4	CDB 010	
1/8 GA & #5	CDB 012	
10 GA & #6	CDB 013	
4 MM	CDB 004M	
#8	CDB 015	
#10	CDB 018	
5 MM	CDB 005M	
6 MM	CDB 006M	
.215	CDB021	
1/4	CDB 025	
5/16	CDB 031	
3/8	CDB 037	



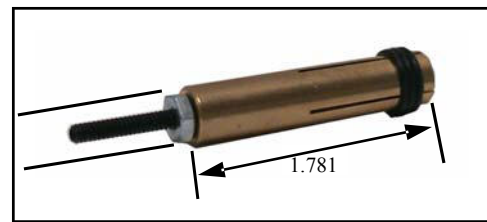
"B" COLLETS AGM STYLE

STUD DIA.	PART NO.	PRICE
14 GA	CDB 008A	
12 GA	CDB 010A	
#6	CDB 013A	
#8	CDB 015A	
#10	CDB 018A	
1/4	CDB 025A	



SOYER COLLETS

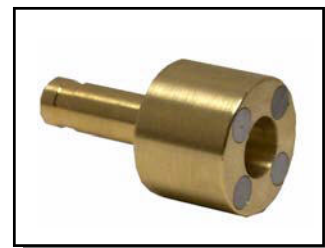
STUD DIA.	PART NO.	PRICE
#6	CDBS 013	
4 MM	CDBS 004M	
#8	CDBS 015	
#10	CDBS 018	
5 MM	CDBS 005M	
6 MM	CDBS 006M	
1/4	CDBS 025	
5/16	CDBS 031	
3/8	CDBS 037	



CAPACITOR DISCHARGE ACCESSORIES

ONE PIECE CONTACT/MAGNETIC CHUCK

PART NO.	PRICE
039 613	



MAGNETIC CHUCK

PART NO.	DESCRIPTION	PRICE
035 301	COMPLETE ASSY	
017 633	MAGNET ONLY	
029 615	CONDUCTOR PLATE	
039 609	INSUL. TUBE	
039 610	INSUL. DISC	
SCREW	10 32 X 7/8	



"B" COLLETS PROTECTOR

STUD SIZE	PART NO.	PRICE
14 GA X 12 GA	028 837	
10 GA	028 838	
BODY ONLY	028 836	
12 GA INSERT	028 834	
10 GA INSERT	028 835	



"B" STOP

STUD	STOP	PART NO.	PRICE
1/4	1 1/4	033 781	
3/8	1 1/8	033 782	
1/2	1"	033 783	
5/8	7/8	033 784	
3/4	3/4	033 785	
7/8	5/8	033 775	
1"	1/2	033 776	
1 1/8	3/8	033 777	
1 1/4	1/4	033 778	
1 3/8 (BUTTON STOP)	1/8	033 779	
UNIVERSAL		033 780	



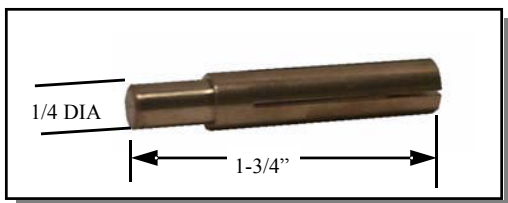
SHORT BUTTON STOP



UNIVERSAL "B" STOP

CAPACITOR DISCHARGE ACCESSORIES

COLLETS INSERTS FOR WELD STUDS



STUD DIA. X DEPTH	PART NO.	PRICE
#4 X 1/4	CI 010 025	
#4 X 3/8	CI 010 037	
#4 X 1/2	CI 010 050	
#4 X 1"	CI 010 100	
#6X 1/4	CI 013 025	
#6 X 3/8	CI 013 037	
#6 X 1/2	CI 013 050	
#6 X 5/8	CI 013 062	
#6 X 3/4	CI 013 075	
#6X 1"	CI 013 100	
10GA X 1/2	CI 014 050	
10GA X 3/4	CI 014 075	
10GA X 1	CI 014 100	
#8X 1/4	CI 015 025	
#8 X 3/8	CI 015 037	
#8 X 1/2	CI 015 050	
#8 X 5/8	CI 015 062	
#8 X 3/4	CI 015 075	
#8X 1"	CI 015 100	
#10 X 1/4	CI 018 025	
#10 X 3/8	CI 018 037	
#10 X 1/2	CI 018 050	
#10 X 5/8	CI 018 062	
#10 X 3/4	CI 018 075	
#10X 1"	CI 018 100	
1/4 X 1/4	CI 025 025	
1/4 X 3/8	CI 025 037	
1/4 X 1/2	CI 025 050	
1/4 X 5/8	CI 025 062	
1/4 X 3/4	CI 025 075	
1/4 X 1"	CI 025 100	
5/16 X 3/8	CI 031 037	
5/16 X 1/2	CI 031 050	
5/16 X 5/8	CI 031 062	
5/16 X 3/4	CI 031 075	
5/16 X 1"	CI 031 100	
3/8 X 1/2	CI 037 050	
3/8 X 3/4	CI 037 075	
3/8 X 1"	CI 037 100	

COLLETS INSERTS FOR WELD PINS



STUD DIA. X DEPTH	PART NO.	PRICE
12GA X 1/2	CIP 010 050	
12GA X 3/4	CIP 010 075	
12GA X 1"	CIP 010 100	
10GA X 1/2	CIP 014 050	
10GA X 3/4	CIP 014 075	

STANDARD SPARK SHIELD



STUD RANGE	PART NO.	PRICE
14 GA - #6	033 764	

VENTED SPARK SHIELD



STUD RANGE	PART NO.	PRICE
14 GA - 10 GA	033 769	

TEMPLATE TUBE ADAPTOR



TEMPLATE I.D.	PART NO.	PRICE
1" DIA.	039 839	
1 1/4" DIA.	039 840	

2-3/8 LONG & KSM

LONG STYLE COLLETS



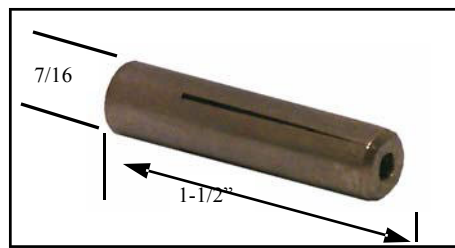
STUD SIZE	PART NO.	OTHER PART #	PRICE
#6	CDBN 013	500 001 356	
#8	CDBN 015	500 001 357	
#10	CDBN 018	500 001 366	
1/4	CDBN 025	500 001 359	
5/16	CDBN 031	500 001 360	
4 MM	CDBN 004M	500 001 361	
6 MM	CDBN 006M	500 001 362	
12 GA	CDBN 010	500 001 363	

LONG ADJ. STOPS FOR ABOVE

STUD LENGTH	PART NO.	PRICE
1/4 TO 5/8	500 017 017	
3/4 TO 1 1/8	500 017 018	
1 1/4 TO 1 5/8	500 017 019	
1 3/4 TO 2 1/8	500 017 020	



KSM / ERICO AIR COLLET



BOTTOM LOAD

STUD DIA	PART NO.	PRICE
#4 (.112)	016 412	
#6 (.138)	016 415	
#8 (.164)	016 416	
#10 (.189)	004 684	

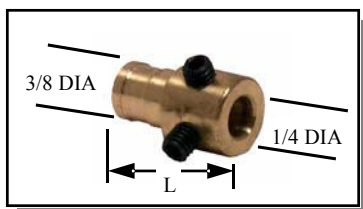
RAM FEED

STUD DIA	PART NO.	PRICE
#4 (.112)	025 016	
#6 (.138)	025 017	
#8 (.164)	025 018	
#10 (.189)	025 019	

NON STOCK ITEM / ALLOW 2 WEEKS FOR DELIVERY

ADAPTORS

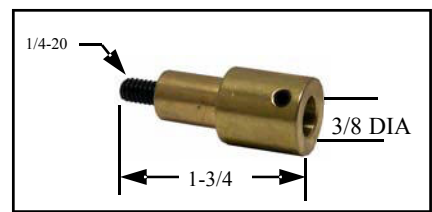
B CI ADAPTOR



PARTNO. PRICE

044 082 7/8 LONG
033 746 1 9/16 LONG

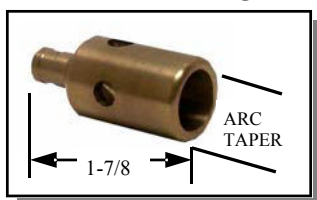
K B ADAPTORS



PART NO. PRICE

039 464

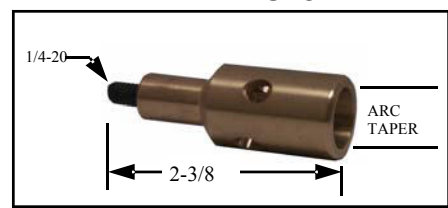
B N ADAPTOR



PART NO. PRICE

039 468

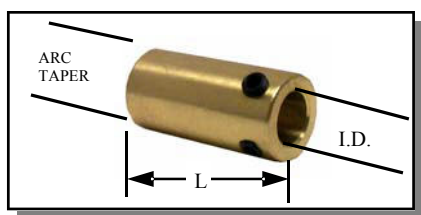
K N ADAPTORS



PART NO. PRICE

033 750

ADAPTORS



PART NO .I.D. PRICE

044 083 N B 3/8 ID
044 084 N C 1/4 ID

MISCELLANEOUS ADAPTORS

PART NO. DESCRIPTION PRICE

MT 0008 TEMPLATE TUBE
1/4 1/2 ARC STUDS

MT 0012 TEMPLATE TUBE
5/8 3/4 ARC STUDS

033 505L L TEC CHUCK
ADAPTOR

033 749 K CI ADAPTORS
751 458 049 NS 30 CHUCK ADAPTORS

PART NO. DESCRIPTION PRICE

033 505 Chuck Adaptor
033 506 Connector Stud

THREADED TAPERED ADAPTORS



PART NO. PRICE

MT 0003

WELD CABLE CONNECTORS

HEAVY DUTY HI TEMP CONNECTOR



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107 0006	4/O (M) HI TEMP	
107 0006 1	4/O (M) SLEEVE	
107 0006 2	4/O BRASS ONLY	

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107 0007	4/O (F) HI TEMP	
107 0007 1	4/O (F) SLEEVE	
107 0007 2	4/O BRASS ONLY	

107 0007 MF HI TEMP PIN (FITS (M) OR (F))
COPPER WRAP

LIGHT DUTY CONNECTOR



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107 0010	1/O (M) FIBER SHELL	
107 0011	1/O (F) FIBER SHELL	
107 0012	#4 (M) FIBER SHELL	

CONTROL CABLE CONNECTORS

CONTROL CABLE CONNECTOR



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107 0014	MALE 4 POLE CONNECTOR	
107 0015	FEMALE 4 POLE CONNECTOR	
107 0001	PANEL MOUNT CONNECTOR	

HUBBELL STYLE CONNECTOR



<u>ARC 2 WIRE (M)</u>	<u>PANEL MOUNT</u>	<u>P.W. HUBBELL (M)</u>
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<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107 0016	ARC 2 WIRE (M)	
107 0017	ARC 2 WIRE (F)	
107 0018	ARC 2 WIRE (PANEL MOUNT)	
107 0019	(M) RUBBER COVER	
107 0020	(F) RUBBER COVER	
107 0030	P.W. HUBBELL (M)	
107 0032	P.W. HUBBELL (F)	
107 0031	P.W. HUBBELL (PANEL MOUNT)	

PANEL MOUNT CAMLOK CONNECTORS



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
107 0003	MALE PANEL MOUNT	
107 0002	FEMALE PANEL MOUNT	

WELD CABLE LUGS



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
123 0003	#4 W/#10 HOLE	
123 0001	#1 W/#10 HOLE	
123 0006	#1 W/1/4 HOLE	
123 0002	#1 W/3/8 HOLE	
123 0008	1/O W/3/8 HOLE	
123 0009	1/O W/1/2/ HOLE	
123 0013	4/O W/3/8 HOLE	
123 0010	4/O W/1/2/ HOLE	

ACCESSORIES



<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>PRICE</u>
102 0041	ALLEN WRENCH SET	
102 0042	CHUCK EJECTOR KEY	