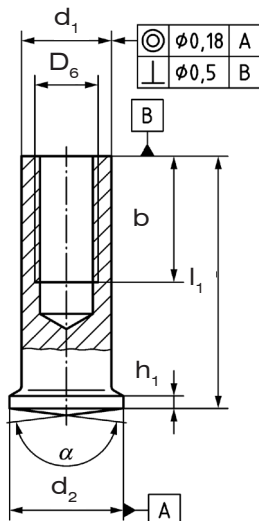


WELDING STUDS SHORT CYCLE

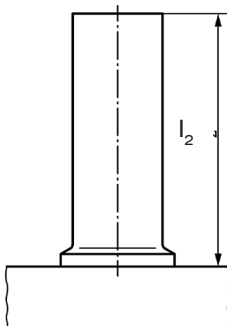
We supply at short notice threaded and no-thread studs, shear connectors and short cycle studs from our extensive stock and also manufacture special studs to suit your specific requirements in a high standard of quality.

IS

before welding



after welding



| D_6 | $l_{1min} +0,6$ | $b_{min} +2P$ | $d_2 \pm 0,2$ | $d_1 \pm 0,1$ | h_1 | $\alpha \pm 2^\circ$ ^a |
|-------|-----------------|---------------|---------------|---------------|-------------|-----------------------------------|
| M3 | 10 | 5 | 6,0 | 5,0 | 0,7 bis 1,4 | 166 ° |
| M4 | 10 | 6 | 7,0 | 6,0 | 0,7 bis 1,4 | 166 ° |
| M5 | 10 | 6 | 9 | 7,1 | 0,8 bis 1,4 | 166 ° |
| M5 | 15 | 7,5 | 9 | 8,0 | 0,8 bis 1,4 | 166 ° |
| M6 | 15 | 9 | 9 | 8,0 | 0,8 bis 1,4 | 166 ° |

^a For applications on sheets ≥ 2 mm thick and welding times > 60 ms, the angle α may be reduced to up to 152° .