

	Type	Material	Suitable for stud feeding	
	IT Studs with internal thread	Steel 4.8 copper coated (suitable for welding)	Manual e.g.	Automation ¹⁾ e.g.

d_1 ± 0.1	D_6	l_1 ± 0.6	b_{min} $+2P$	d_2 ± 0.2	d_4 ± 0.08	l_3 ± 0.05	h_1	α $\pm 2^\circ$	
5	M3	see table	5	6.5	0.75	0.80	0.7-1.4	174°	
6 ²⁾	M3 ²⁾		6	7.5					
6	M4			9	0.85	0.8-1.4			
7.1	M5								
8	M6								

	Diameter					
	M3 / Ø 5 mm	M3 / Ø 6 mm	M4 / Ø 6 mm	M5 / Ø 7,1 mm	M6 / Ø 8 mm	
	Order No.	Order No.	Order No.	Order No.	Order No.	
Length l_1	8 mm ²⁾	31-35-008	31-36-008*	31-46-008	--	--
	10 mm	31-35-010	31-36-010*	31-46-010	31-57-010	31-68-010*
	12 mm	31-35-012	31-36-012*	31-46-012	31-57-012	31-68-012*
	15 mm	31-35-015*	31-36-015*	31-46-015	31-57-015	31-68-015*
	16 mm	31-35-016*	31-36-016*	31-46-016	31-57-016*	31-68-016*
	20 mm	31-35-020*	31-36-020*	31-46-020*	31-57-020	31-68-020*
	25 mm	31-35-025*	31-36-025*	31-46-025*	31-57-025	31-68-025*
	30 mm	31-35-030*	31-36-030*	31-46-030*	31-57-030	31-68-030*
	35 mm	--	--	31-46-035*	--	--
	Chuck	82-50-905	82-50-906	82-50-906	82-50-971	82-50-908
	Chuck	84-50-005	84-50-006	84-50-006	84-50-071	84-50-008

Further accessories see accessories catalogue

* Minimum order quantity, delivery time and price upon request.

Custom dimensions are not listed in the table – HBS manufactures customised welding elements. On request we can provide pricing.

1) For automation: Diameter: 5 to 8 mm
Stud length: 8 to 40 mm (other lengths on request)
For more details, see accessories catalogue.

2) Similar to DIN EN ISO 13918