

1



Studs with internal thread type IT

Type	Material	Suitable for stud feeding	
		Manual	Automation ¹⁾
IT Studs with internal thread	A2-50	e.g.	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		6	7.5					
7.1	M5		6	7.5					
8	M6		9	9	0.85	0.8-1.4			

Length l_1	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.
6 mm ²⁾	32-35-006	--	--	--	--
8 mm ²⁾	32-35-008	32-36-008*	32-46-008	--	--
10 mm	32-35-010	32-36-010*	32-46-010	32-57-010	32-68-010*
12 mm	32-35-012	32-36-012*	32-46-012	32-57-012	32-68-012*
15 mm	32-35-015*	32-36-015*	32-46-015	32-57-015	32-68-015*
16 mm	32-35-016*	32-36-016*	32-46-016	32-57-016*	32-68-016*
20 mm	32-35-020	32-36-020*	32-46-020	32-57-020	32-68-020*
25 mm	32-35-025*	--	32-46-025*	32-57-025*	32-68-025*
30 mm	32-35-030*	--	32-46-030*	32-57-030*	32-68-030*
35 mm	--	--	32-46-035*	--	--
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	84-50-908

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