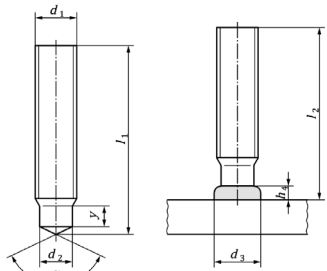


 (Delivery without ceramic ferrule)	Type		Material		Suitable for stud feeding	
					Manual	
	RD Threaded studs with reduced shaft (with shielding gas)		Mild steel 4.8 (suitable for welding)		 e.g.	

d ₁	l ₂ ²⁾	d ₂ ^{±0.1}	d ₃ ¹⁾	y+2P	h ₄ ¹⁾	α± 7°
M6	see table	4.7	7.0	4.0	2.5	140°
M8		6.2	9.0	4.0	2.5	
M10		7.9	11.5	5.0	3.0	
M12		9.5	13.5	6.0	4.0	
M16		13.2	18.0	7.5	5.0	
M20		16.5	23.0	9.0	6.0	
M24		20.0	28.0	12.0	7.0	



		Diameter				
		M6	M8	M10	M12	M16
		Order No.	Order No.	Order No.	Order No.	Order No.
Length l_2	10 mm	51-06-010*	--	--	--	--
	12 mm	--	51-08-012*	51-10-012*	--	--
	15 mm	51-06-015*	51-08-015*	51-10-015*	--	--
	20 mm	51-06-020*	51-08-020*	51-10-020	51-12-020*	--
	25 mm	51-06-025*	51-08-025*	51-10-025	51-12-025*	--
	30 mm	51-06-030*	51-08-030*	51-10-030	51-12-030*	51-16-030*
	35 mm	51-06-035*	51-08-035*	51-10-035*	51-12-035*	51-16-035*
	40 mm	51-06-040*	51-08-040*	51-10-040*	51-12-040*	51-16-040*
	45 mm	51-06-045*	51-08-045*	51-10-045*	51-12-045*	51-16-045*
	50 mm	51-06-050*	51-08-050*	51-10-050*	51-12-050*	51-16-050*
	55 mm	--	--	51-10-055*	51-12-055*	51-16-055*
	60 mm	--	--	51-10-060*	51-12-060*	51-16-060*
Chuck		83-51-006	83-51-008	83-51-010	83-51-012	83-51-016
     						

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) The dimensions of stud collars are guidance values and may be generally achieved in welding position PA according to ISO 6947. The weld collars are subject to variations regarding evenness and shape.
- 2) The nominal length l_2 (length after welding) is a design value. By proper control of the welding it is possible to keep variations in l_2 within ± 1 mm.