

NELSON STUD WELDING

ACCESSORY SPECIFICATION: Feet

Standard feet are made of an insulating material. They are mounted on the two legs that extend from the gun body. A ferrule grip, ferrule holder, or spark shield is then installed on the foot.

The foot is adjusted and locked so that a portion of the stud extends beyond the ferrule or spark shield. This portion of the stud is available to be melted during the welding process to create the weld flash surrounding the welded stud. The foot and leg assembly is locked into position by set screws in the gun body that tighten against the legs.

When the gun is positioned to make a weld, the spark shield or ferrule contacts the base material and provide a reference for the lift and plunge of the stud during the weld cycle.

In order to properly fit the feet to the ferrule and ferrule grip, please consult the chart below.

Foot Size	Nominal Ferrule Size		Ferrule Neck Diameter	
	Minimum	Maximum	Minimum	Maximum
Small	1/8	1/2	0.281	0.650
Medium	5/8	3/4	0.785	1.030
Large	7/8	1	1.210	1.046

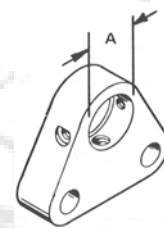
Different feet may be needed for various stud welding applications. Please consult the charts below for different feet styles.

Standard Closed Feet

Gun Description	Small A = 0.875	Medium A = 1.156	Large A = 1.750
NS-20	502001001	502001002	502001003
NS-20A-HD	502001001	502001002	502001003
NS-30	502001137	502001138	502001144
NS-40	502001137	502001138	502001144



NS-20 and NS-20A-HD
Small and Medium
Closed Feet



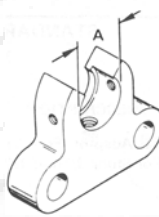
NS-30 and NS-40
Small and Medium
Closed Feet



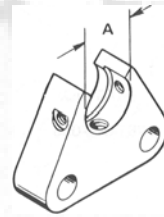
NS-20, NS-20A-HD,
NS-30, and NS-40
Large Closed Feet

Standard Split or Open Feet

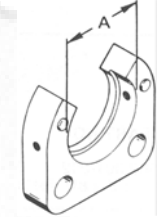
Gun Description	Small A = 0.875	Medium A = 1.156	Large A = 1.750
NS-20	502001001	502002002	N/A
NS-20A-HD	502001001	502002002	502002003
NS-30	502002045	502002046	N/A
NS-40	502002045	502002046	N/A



NS-20 and NS-20A-HD
Small and Medium
Open Feet



NS-30 and NS-40
Small and Medium
Open Feet



NS-20, NS-20A-HD,
NS-30, and NS-40
Large Open Feet

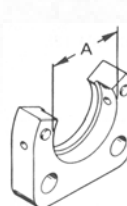
Gun Description	Standard Shear Connector Foot ¹	Shear Connector Bipod Foot ^{1,2}	Gas Adapter Feet ³
NS-20	N/A	N/A	751020000
NS-20A-HD	502002009	503000000	N/A
NS-30	N/A	503019000	751020000
NS-40	N/A	503019000	751020000

¹ Use with Shear Connector Ferrule grips.

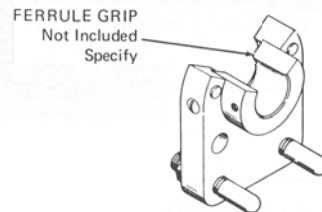
² NS-20A-HD: For ferrules 1/2" diameter and larger.

NS-30 and NS-40: For ferrules 3/8" diameter and smaller.

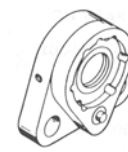
³ For studs 3/16 through 1/2".



NS-20A-HD
Standard Shear
Connector Foot



NS-20-HD, NS-30, and NS-40
Shear Connector Bipod Foot



NS-20, NS-30, and
NS-40 Gas Adapter
Foot

Visit our website www.NelsonStudWelding.com for a list of our standard stock products.