

NELSON STUD WELDING

SPECIFICATION: TFNC, TFNS, TFNA Flanged Unthreaded Capacitor Discharge Studs

TFNC, TFNS, TFNA

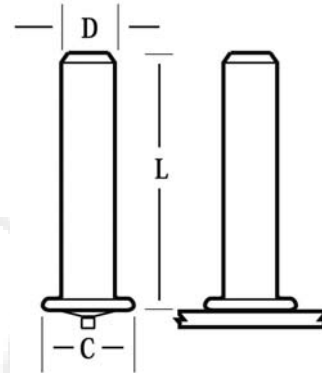
These unthreaded studs are designed to be welded to thin sheet material by the initial “gap” or “contact” method of stud welding using tip ignition according to the capacitor discharge (CD) weld process. These applications generally provide a weld bond strength that is greater than the strength of the thin base material to which they are welded.

Flanged unthreaded capacitor discharge studs are commonly used as locator or stop points. They may also be tapped with internal threads, or have smaller diameter externally threaded extensions

These studs have a flanged weld base that is about 1/16” greater than the nominal stud diameter. The flange increases the weld bond area for greater reliability, and come in lengths up to 1-1/4”.

For superior welding results, mild steel studs are copper flash plated, stainless studs are passivated, and aluminum studs are acid etched.

For similar function studs, see Nelson **ANC Unthreaded Stored Arc®** studs and **AXC “Fir Tree”** studs.



When ordering, specify Type, Description, Material, Quantity, and Part Number

Example: TFNC 3/16 x 1-1/2”; Mild Steel; 10,000 pieces; #101218902

Stud Diameter D	Flange Diameter C	Minimum Length L	Required Standard Accessories	
			Chuck* Series 650 Style Gun	Chuck Assembly CD-Lite Gun
3/16	0.250	0.250	500001358	215503
1/4	0.312	0.375	500001359	215504
5/16	0.375	0.375	500001360	520327

* A back-up pin or stud stop is required for use with these chucks. The list below shows part numbers and corresponding stud lengths for each pin length.

Back-up Pin Part Number	For Stud Lengths (inches)
500001017	1/4 to 5/8
500001018	3/4 to 1-1/8
500001019	1-1/4 to 1-5/8
500001020	1-3/4 to 2-1/8

MATERIALS: Studs are available in Low Carbon Mild Steel (TFNC), 18-8 Stainless Steel (TFNS), and 5356 Aluminum (TFNA). Some other materials may be available by special order. For specific grade information and physical and chemical properties, conforming standards, and information on stud plating and heat treating, please see [General Material Specifications](#).

THREADS: Standard external threads are UNC-2A, or UNF-2A for #10-32.

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