

NELSON STUD WELDING

SPECIFICATION: Metric **TBL** Internally Threaded Studs

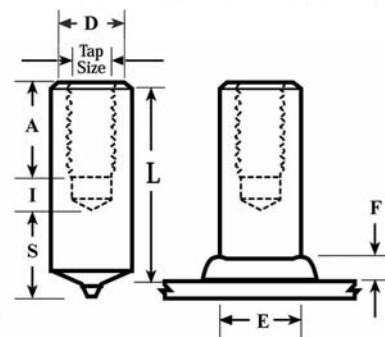
Nelson's internally threaded metric TBL studs are intended to be used on heavy base materials and serve as a means of attaching or anchoring components to a structure. When maximizing the stud diameter to tap ratio, the stud can also serve as a stand off post.

Standard TBL studs have internal metric ISO 6g threads.

The "D" dimension on fine threads is approximately 15 – 20 % less than for course threads. The "E" dimension is predicated on stud diameter, not tap size. Secondary bottom tapping or flat bottom drilling is available as a special order with significant price additions.

Reduced base studs are available but depth of tap drill point should not pass below shoulder of reduced diameter shoulder so that stud strength is not compromised.

For similar function imperial studs, see Nelson **CKL Collar studs**, **NBL Unthreaded studs**, **S6L Sprinkler studs**, and **SBL Shoulder studs**



When ordering, specify **Type**, **Diameter**, **Before Weld Length**, **Tap Size**, **Material**, **Quantity**, and **Part Number**

Example: TBL M8 x 22.00mm, with 8mm Deep Tap; Mild Steel; 10,000 pieces; #101103481

Stud Diameter	Maximum Tap Size C	Minimum Values				Burn Off	Weld Flash		Flash Clearance	Required Standard Accessories			
		D	A	I	S		E	F		Ferrule	Grip	Chuck	Foot
6	M4 x 0.70	6.00	6.00	3.00	4.00	2.00	9.10	3.00	11.10	100101067	501001007	500001267	502001137
8	M5 x 0.80	8.00	8.00	3.00	4.00	3.00	11.00	4.00	12.50	100101007	501001006	500001009	502001137
10	M6 x 1.00	10.00	9.00	4.00	4.00	3.00	13.00	4.00	14.50	100101037	501001008	500001269	502001137
12	M8 x 1.25	12.00	12.00	5.00	5.00	3.00	16.00	4.50	17.50	100101027	501001009	500001206	502001137
16	M10 x 1.50	16.00	15.00	6.00	6.00	4.00	21.00	6.00	22.50	100101187	501001014	500001016	502001138
19	M12 x 1.75	19.00	18.00	7.00	6.00	5.00	27.00	7.00	28.50	100101152	501001014	500001018	502001002
20	M12 x 1.75	19.00	18.00	7.00	6.00	5.00	26.00	8.00	27.50	100101195	501001014	500001272	502001002
22	M16 x 2.00	22.00	24.00	8.00	7.00	6.00	28.00	9.00	30.50	100101140	501001015	500001019	502001003
24	M16 x 2.00	22.00	24.00	8.00	7.00	6.00	35.00	10.00	36.50	100101197	501001016	500001274	502001003

In the table above, E represents the weld diameter; F, the weld height; I, the imperfect thread depth; and S, the depth of the solid weld base.

MATERIALS: TBL and PBL studs are available in Low Carbon Mild Steel and 18-8 Stainless Steel. 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 metric threads meet ISO 6g.

FLUX: All standard Nelson internally threaded studs have a solid flux load.

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