

NELSON STUD WELDING

SPECIFICATION: CKA Aluminum Collar Studs

Nelson CKA aluminum collar studs are available in thread sizes of 1/4-20 through 1/2-13. They are used for attaching parts to aluminum structures. They are welded using ceramic ferrules in conjunction with argon as a shielding gas. The collar on CKL studs is useful in mounting applications where a standoff is needed.

The shielding gas is introduced to the weld area through a gas foot assembly, #751020000, which is used for all diameters of CKA studs. Gas hose #515001001 and gas regulator #514001001 are needed to deliver and control the gas flow from a pressurized cylinder.

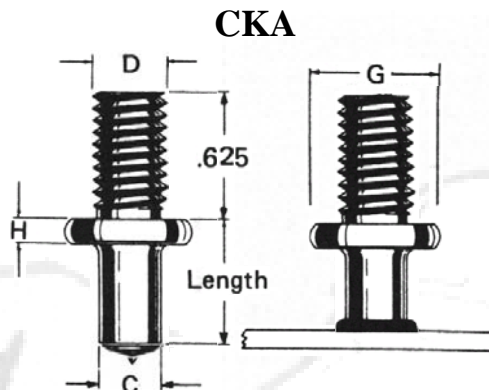
An aluminum Tranquil-Arc® plunge dampener kit is also needed as an accessory on the gun to control the rate of the stud's return in to the molten weld metal at the end of the weld cycle.

Studs are available in before weld lengths greater than the specified minimum length to a maximum of 4-1/8".

For similar function studs, please refer to Nelson **HBA Threaded Full Base studs** and **TBA Internally Threaded studs**.

When ordering, specify Type, Base Diameter, Base Length, Thread Size, Extension Length, Material, Quantity, and Part Number

Example: CKA 0.330 x 1.125, 3/8-16 x 3/4"; Aluminum; 10,000 pieces; #101015642



Thread Size	Stud Diameter D	C	Minimum Stud Length L	Maximum B	G	H	Burn Off	Flash Clearance	Required Standard Accessories	
									Ferrule	Chuck
1/4-20	1/4	0.215	1.250	0.406	1.250	0.093	0.125	0.469	100101047	500001007
5/16-18	5/16	0.275	1.250	0.468	1.250	0.093	0.156	0.531	100101048	500001009
3/8-16	3/8	0.330	1.250	0.603	1.250	0.093	0.187	0.656	100101049	500001011
7/16-14	7/16	0.387	1.250	0.656	1.250	0.093	0.218	0.750	100101050	500001012
1/2-13	1/2	0.448	1.250	0.750	1.250	0.093	0.250	0.843	100101051	500001014

MATERIALS: CKA Studs are available in 5356-H32 Aluminum. For specific grade information and physical and chemical properties, as well as information on heat treating, please see **General Material Specifications**.

THREADS: Standard external threads are UNC-2A.

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