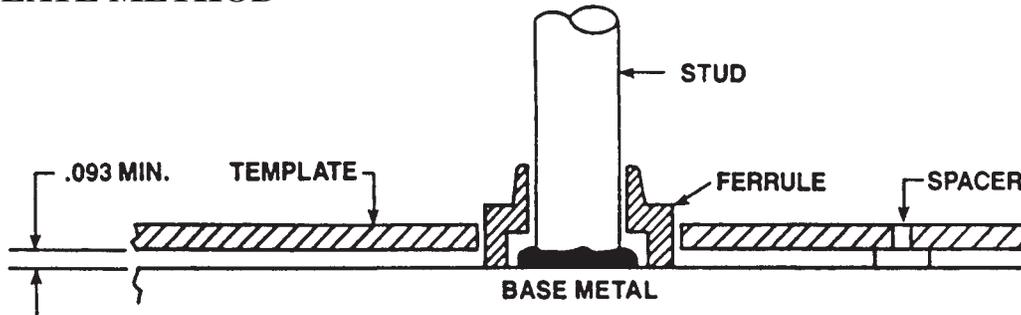


ARC STUD LOCATION TEMPLATE & BUSHING DESIGN

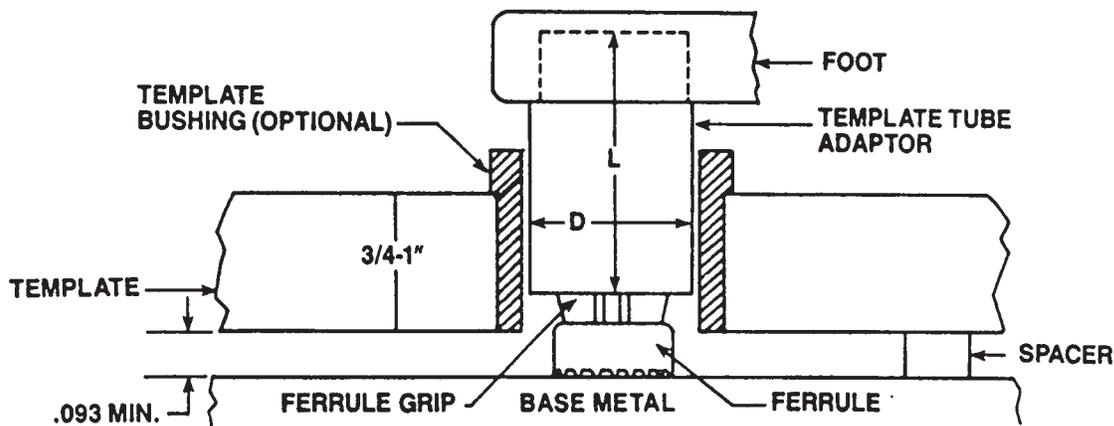
TEMPLATE METHOD



This method of templating is recommended by MIDWEST FASTENERS for use with ferrules. The template is usually a steel plate 3/32" to 3/16" thick. Spacers are required to allow the gases to escape during the welding cycle. The ferrule can be held by a standard ferrule grip or where clearance is prohibitive a tube type set-up can be used. The recommended hole sizes on the template to locate the

ferrules should equal the maximum outside diameter of the ferrule plus 1/32". Holes may be drilled or bored at required locations. See stud specification sheets for ferrule details. For further assistance contact the MIDWEST FASTENERS Customer Service Department.

BUSHING METHOD



This method of templating is recommended by MIDWEST FASTENERS for use with all arc stud styles. The design makes it possible to accurately hold angular alignment of the studs as well as stud location. The template should be made of ebonite or masonite of a thickness sufficient to afford good alignment. Template bushings may be used to insure greater accuracy and extend the life of the template. Standard ferrule grips are used with the tube adaptor. This permits standardization of templates since it is only necessary to change the ferrule grip to weld studs of different diameters. The hole diameter of the

bushing or template should be approximately .010 larger than the maximum outside diameter of the template tube adaptor.

STUD Size	D	L
1/2" and under	1.250	2.000
5/8" and 3/4"	1.562	2.500
7/8" and larger	2.125	2.500



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