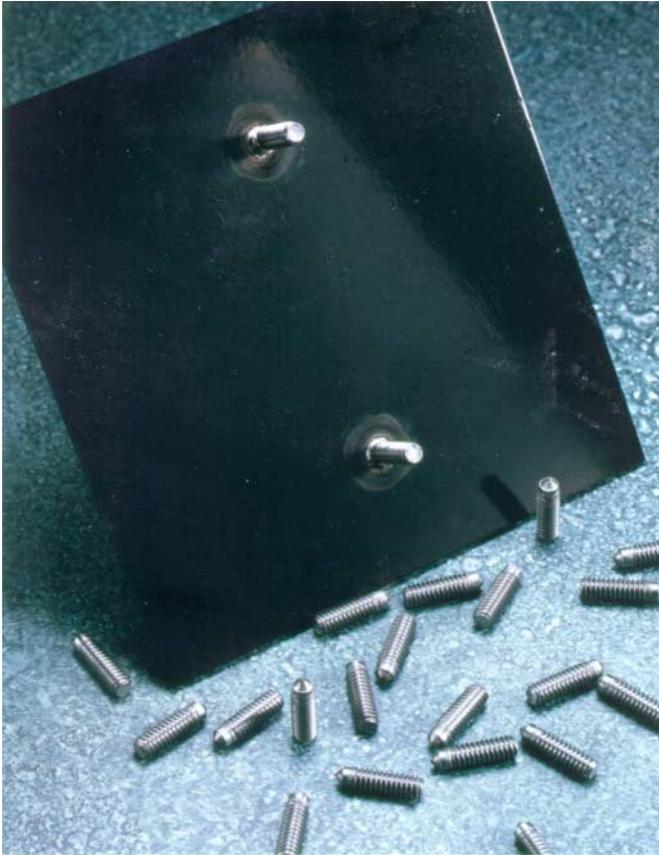


# Hammer Weld® Stud



## Image's Hammer Weld® Studs

### Penetrate Rusty, Scaly, or Painted Surfaces With Ease

Image Industries, Inc., a leader in stud welding, introduces new Hammer Weld® Studs that will penetrate rusty, scaly, or painted surfaces and ensure a secure weld. The studs provide a durable and efficient alternative to traditional welding methods, because they eliminate the need to grind or prepare the surface before welding. These studs are presently available in 1/4-20 steel. Other sizes and materials can be custom manufactured allowing them to meet specific application needs. They offer the strength and endurance needed for rough or coated surfaces.

No longer will you have to grind the surface clean before welding, and then re-coat it after welding, expending a great deal of production time and money. Hammer Weld Studs make it possible to avoid all these time-consuming procedures by offering a quick, permanent and worry-free solution for hard-to-weld surfaces. The studs can be used with Image's ARC welding equipment, which offers a unique feature called Hammer Mode, automating the welding process even more.

With Image's equipment, Hammer Weld Studs can be rapidly welded into place by inserting the stud into the welding gun, and positioning it against the desired work surface. The Hammer Mode control cycle then uses the stud to peck through mill scale. The control repeats this pecking method until it finds ground and welds the stud onto the surface. The heat generated by the arc burns away any paint in the weld zone.

To further improve the process, the hammer weld stud can be combined with shielding gas (which can be integrated into Image's equipment) to provide maximum weld integrity which is free from contaminates.

The Hammer Weld Stud remains secure, and no further surface maintenance, such as painting around the stud, is required.



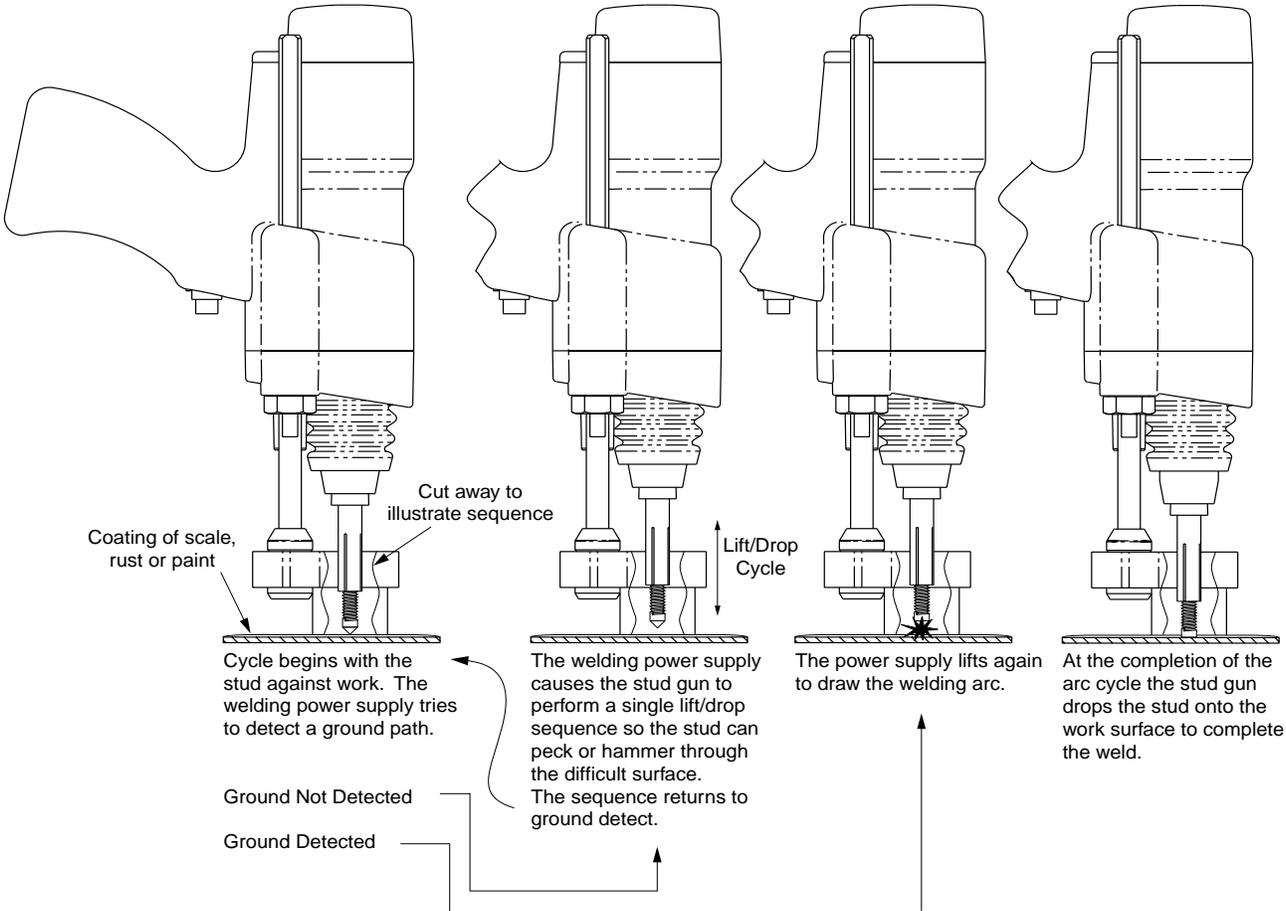
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## Hammer Sequence



## Strength Properties of 1/4-20 Hammer Weld Studs

Material Tensile	60,000 PSI
Fastener Ultimate Tensile	1,909 lbs
Max Torque (repeat install application)	39 in·lb
Max Torque (permanent install)	47 in·lb
Min Yield Shear	661 lbs

The above values are calculated based on sharp threads. Threads on all Image fasteners are rolled, therefore they are not sharp. Actual strength characteristics of a rolled fastener will exceed those of a fastener with sharp threads.

## Typical Stud Gun Accessories to weld 1/4-20 Hammer Weld Studs

	<u>Part Number</u>
1/4" Chuck	C25
Brass Spark Shield (for short cycle unshielded welding)	SSB
Medium Foot for Spark Shield	FTM20

Note: Image can custom manufacture a wide variety of studs. Each stud's design and manufacture should be tailored to the specific application. The data provided here is for a common size Hammer weld stud.

Material data as provided by our suppliers