

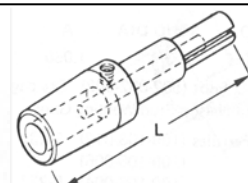
NELSON STUD WELDING

ACCESSORY SPECIFICATION: Stud Weld Gun Imperial Dimension Chucks

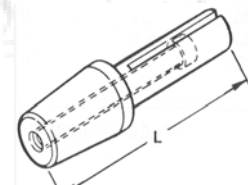
Below is a list of standard imperial chucks for use in welding Nelson studs. The chucks are listed with both imperial and metric dimensions so that the difference in size between two chucks can be easily compared. This will indicate if the stud will be tight or loose in an alternative chuck. The lengths given are the overall chuck lengths.

Chucks for use with Standard Stud Weld Guns

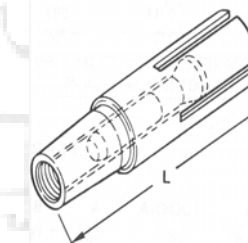
| Chuck Description | Stud Diameter | | Length (inches) | Chuck Part Number | Type |
|------------------------|-----------------------------|-----------------------|-----------------|-------------------|------|
| | Imperial Dimension (inches) | Metric Dimension (mm) | | | |
| #4 | 0.112 | 2.84 | 2-5/8 | 500001135 | 1 |
| 1/8" and 11ga. | 0.125 | 3.17 | 2-5/8 | 500005001 | |
| #6 and 10ga. | 0.134 | 3.40 | 2-5/8 | 500001002 | |
| 5/32 | 0.156 | 3.96 | 2-5/8 | 500001003 | |
| #8 and 8ga. | 0.164 | 4.17 | 2-5/8 | 500001006 | |
| 3/16" and #10 | 0.187 | 4.76 | 2-5/8 | 500001005 | |
| 7/32 and 1/4-20 pitch | 0.218 | 5.54 | 2-5/8 | 500001004 | |
| 1/4 | 0.250 | 6.35 | 2-1/4 | 500001007 | 2 |
| 5/16-18 pitch | 0.275 | 6.98 | 2-1/4 | 500001008 | |
| 5/16 | 0.312 | 7.92 | 2-1/4 | 500001009 | |
| 3/8-16 pitch | 0.330 | 8.38 | 2-1/4 | 500001010 | |
| 3/8 | 0.375 | 9.53 | 2-1/4 | 500001011 | |
| 7/16 | 0.437 | 11.10 | 2-1/4 | 500001012 | |
| 1/2-13 pitch | 0.448 | 11.38 | 2-1/4 | 500001013 | |
| 1/2 | 0.500 | 12.70 | 2-1/2 | 500001014 | 3 |
| 9/16 and 5/8-11 pitch | 0.562 | 14.27 | 2-1/2 | 500001015 | |
| 5/8 | 0.625 | 15.87 | 3 | 500001016 | |
| 3/4-10 pitch and 11/16 | 0.680 | 17.27 | 3 | 500001245 | |
| 3/4 | 0.750 | 19.05 | 3 | 500001018 | |
| 7/8 | 0.875 | 22.23 | 3 | 500001019 | 4 |
| 1 | 1.000 | 25.40 | 3-5/8 | 500001085 | |
| A 1 Body | | | | 500001110 | |
| B 1 Sleeve | | | | 500000111 | |
| 1-1/8 | 1.125 | 28.57 | 3-5/8 | 500001086 | |
| A 1- 1/8 Body | | | | 500001113 | |
| B 1- 1/8 Sleeve | | | | 500001114 | |
| 1-1/4 | 1.250 | 31.75 | 3-5/8 | 500001088 | |
| A 1-1/4 Body | | | | 500001117 | |
| B 1-1/4 Sleeve | | | | 500001118 | |
| 1-3/8 | 1.375 | 34.93 | 3-5/8 | 500001091 | 5 |
| A 1-3/8 Body | | | | 500001121 | |
| B 1-3/8 Sleeve | | | | 500001120 | |
| 1-1/2 | 1.500 | 38.10 | 3-5/8 | 500001093 | |
| A 1-1/2 Body | | | | 500001123 | |
| B 1-1/2 Sleeve | | | | 500001124 | |
| 1-5/8 | 1.625 | 41.27 | 3-5/8 | 500001424 | |
| A 1-5/8 Body | | | | 500001425 | |
| B 1-5/8 Sleeve | | | | 500001426 | |
| 1-3/4 | 1.750 | 44.45 | 3-5/8 | 500001095 | |
| A 1-3/4 Body | | | | 500001115 | |
| B 1-3/4 Sleeve | | | | 500001116 | |



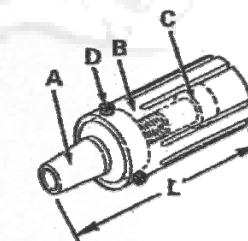
Standard Length Adjustable Depth Chuck
L = 2.625"
Type 1



Standard Length Adjustable Depth Chuck
L = 2.500"
Type 2

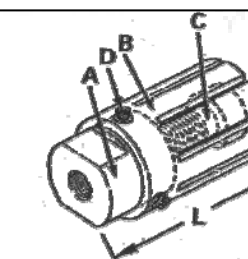


Standard Length Adjustable Depth Chuck
L = 3.000"
Type 3



Standard Length Adjustable Depth Chuck
L = 3.000"
Type 4

Type 5
1/2-20 Thread Mounting



Standard Length Adjustable Depth Chuck
L = 3.000"

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**Type 1 – 4
#2 Morse Taper Mounting**

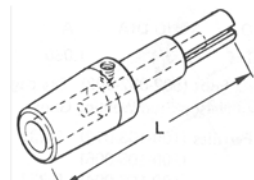
NELSON STUD WELDING

ACCESSARY SPECIFICATION: Stud Weld Gun Metric Chucks

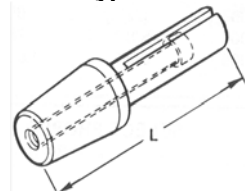
Below is a list of standard metric chucks to be used when welding Nelson studs. The chucks are listed with both metric and imperial dimensions so that the difference in size between two chucks can be easily compared. This will indicate if the stud will be tight or loose in an alternative chuck. The lengths given are the overall chuck lengths.

Standard Metric Chucks for use with Standard Stud Weld Guns

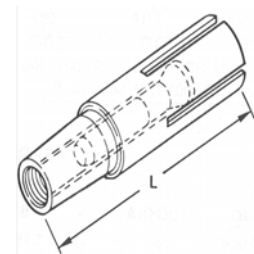
| Stud Diameter | | Length (inches) | Chuck Part Number | Type |
|----------------------|-----------------------------|-----------------|-------------------|------|
| Metric Diameter (mm) | Imperial Dimension (inches) | | | |
| 2 | 0.079 | 2-5/8 | 500001342 | 1 |
| 3 | 0.118 | 2-5/8 | 500001135 | |
| 4 | 0.157 | 2-5/8 | 500001003 | |
| 5 | 0.198 | 2-5/8 | 500001427 | |
| 6 | 0.236 | 2-1/4 | 500001267 | 2 |
| 8 | 0.315 | 2-1/4 | 500001009 | |
| 9 | 0.354 | 2-1/2 | 500001434 | |
| 10 | 0.394 | 2-1/4 | 500001269 | |
| 12 | 0.472 | 2-1/2 | 500001206 | 3 |
| 14 | 0.551 | 2-1/2 | 500001391 | |
| 16 | 0.630 | 3 | 500001016 | |
| 18 | 0.708 | 2-1/2 | 500001271 | |
| 19 | 0.748 | 3 | 500001018 | |
| 20 | 0.787 | 2-1/2 | 500001272 | |
| 22 | 0.866 | 2-1/2 | 500001019 | |
| 24 | .944 | 3-5/8 | 500001085 | |
| A24 Body | | | 500001110 | 4 |
| A24 Sleeve | | | 500000111 | |
| 25 | 0.984 | 3-1/4 | 500001085 | |
| A 25 Body | | | 500001110 | 5 |
| B 25 Sleeve | | | 500001111 | |
| 22 (one piece) | .866 | 3-1/2 | 500001485 | |
| 29 | 1.142 | 3-5/8 | 500001481 | 5 |
| A 29 Body | | | 500001113 | |
| B 29 sleeve | | | 500001482 | |
| 32 | 1.260 | 3-1/2 | 500001483 | |
| A 32 Body | | | 500001117 | |
| B 32 Sleeve | | | 500001484 | |
| 35 | 1.378 | 3-5/8 | 500001091 | |
| A35 Body | | | 500001121 | |
| A35 Sleeve | | | 500001120 | |
| 40* | 1.575 | 3-5/8 | 500001433 | 5 |
| A 40 Body | | | 500001425 | |
| B 40 Sleeve | | | 500001426 | |



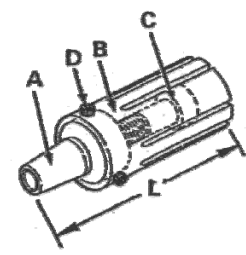
Standard Length Adjustable Depth Chuck
L = 2.625"
Type 1



Standard Length Adjustable Depth Chuck
L = 2.500"
Type 2



Standard Length Adjustable Depth Chuck
L = 3.000"
Type 3



Standard Length Adjustable Depth Chuck
L = 3.000"
Type 4

**Type 5
1/2-20 Thread Mounting**

Standard Length Adjustable Depth Chuck
L = 3.000"

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Nelson long style chucks are typically used when more accessory length is needed. This occurs when short studs are welded through fixtures, templates, or through holes in materials like wood, plastic, or steel. Often, long style studs are used when ferrule tubing holds ferrules, during welding, in place of standard ferrule grips.

3-7/8" Long Style Chucks with Adjustable Depth Stop

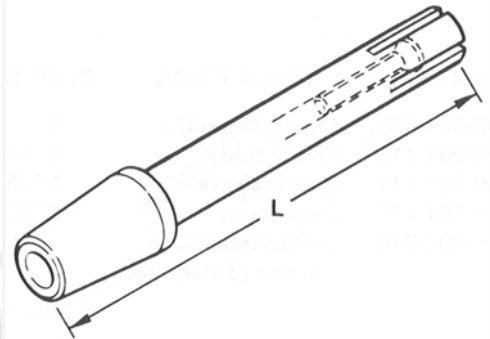
| Chuck Description | Stud Diameter | | Chuck Part Number |
|-------------------|-----------------------------|-----------------------|-------------------|
| | Imperial Dimension (inches) | Metric Dimension (mm) | |
| #8 | 0.164 | 4.17 | 500001221 |
| #10 | 0.187 | 4.76 | 500001220 |
| 1/4 | 0.250 | 6.35 | 500001028 |
| 5/16 | 0.312 | 7.92 | 500001029 |
| 3/8 | 0.375 | 9.53 | 500001030 |
| 7/16 | 0.437 | 11.10 | 500001031 |
| 1/2 | 0.500 | 12.70 | 500001032 |

*3-7/8" Long Straight Style Chucks
Fixed chuck depth is 1/2"*

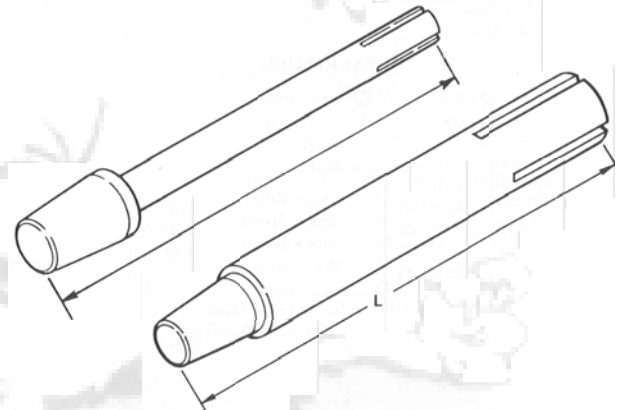
| Chuck Description | Stud Diameter | | Chuck Part Number |
|-------------------|-----------------------------|-----------------------|-------------------|
| | Imperial Dimension (inches) | Metric Dimension (mm) | |
| #8 | 0.164 | 4.17 | 500001021 |
| #10 | 0.187 | 4.76 | 500001022 |

*4-3/4" Long Straight Style Chucks
Fixed chuck depth is 1/2"*

| Chuck Description | Stud Diameter | | Chuck Part Number |
|-------------------|-----------------------------|-----------------------|-------------------|
| | Imperial Dimension (inches) | Metric Dimension (mm) | |
| 1/4 | 0.250 | 6.35 | 500001039 |
| 5/16 | 0.312 | 7.92 | 500001040 |
| 3/8 | 0.375 | 9.53 | 500001041 |
| 7/16 | 0.437 | 11.10 | 500001042 |
| 1/2 | 0.500 | 12.70 | 500001043 |
| 5/8 | 0.625 | 15.87 | 500001044 |
| 3/4 | 0.750 | 19.05 | 500001045 |



3-7/8" Long Length Straight Style Adjustable Depth Chuck

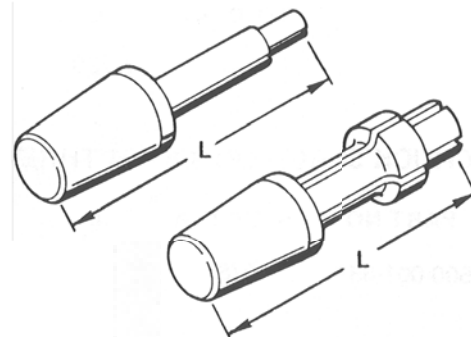


4-3/4" Long Length Fixed Chuck Depth (1/2") Chucks

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Male Style 2-1/2" Long Chucks for Welding Internally Tapped Studs

| Chuck Description | Length of Extension | Chuck Part Number |
|-------------------|---------------------|-------------------|
| #10-24 | 0.218 | 500003003 |
| #10-24 | 0.375 | 500003004 |
| #10-32 | 0.375 | 500003005 |
| 1/4-20 | 0.375 | 500003008 |
| 5/16-18 | 0.375 | 500003010 |
| 3/8-16 | 0.375 | 500003014 |
| 7/16-14 | 0.218 | 500003016 |
| 1/2-13 | 0.500 | 500003017 |
| 5/8-11 | 0.625 | 500003018 |
| 3/4-10 | 0.625 | 500003019 |



Male Style Chucks

Male Style Chucks for Welding Studs with Unthreaded Holes

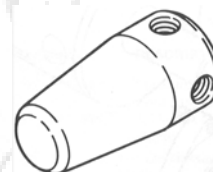
| Chuck Description (Hole Diameter) | Length of Extension | Chuck Part Number |
|-----------------------------------|---------------------|-------------------|
| 3/16 | 3/16 | 500003007 |
| 3/16 | 7/32 | 500003042 |
| 3/16 | 3/8 | 500003006 |
| 1/4 | 7/32 | 500003012 |
| 1/4 | 1/4 | 500003009 |
| 1/4 | 5/16 | 500003053 |
| 3/8 | 3/8 | 500003058 |

*Chuck Adapter for Male Style Chucks
#2 Morse Taper with Internal Hole and Set Screws*

| Chuck Description | Chuck Part Number |
|--------------------|-------------------|
| 1/4" diameter hole | 521001014 |
| 3/8" diameter hole | 521001023 |

Male Chucks for use with Chuck Adapters

| Chuck Description (Hole Diameter) | Length of Extension | Chuck Part Number | Adapter Part Number |
|-----------------------------------|---------------------|-------------------|---------------------|
| 0.080 | 0.066 | 500003001 | 521001014 |
| 0.140 | 1/8 | 500001002 | 521001030 |
| 1/8 | 1/4 | 500003028 | 521001023 |
| 3/16 | 3/8 | 500003021 | 521001023 |
| 1/4 | No Shoulder | 500003045 | 521001014 |



Adapter for Male Style Chucks
#521001014 and #521001023

Chuck Extensions

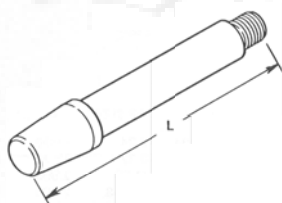
#2 Morse Taper and External Thread

| Chuck Description (Thread size, Overall Length) | Length of Threads | Chuck Part Number |
|---|-------------------|-------------------|
| 3/8-24 x 3.750 | 0.375 | 521001016 |
| 1/2-20 x 1.500 | 0.750 | 521001004 |

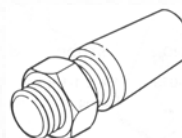
Chuck Extensions – Adds 1/2" to Length of Chuck Assembly

1/2-20 External and Internal Thread with Lock Nut

| Chuck Description (Overall Length) | Length of Threads | Chuck Part Number |
|------------------------------------|-------------------|-------------------|
| 3/4 hex x (2 x Overall Length) | 0.750 | 521001005 |



Chuck Extension
#521001016



Chuck Extension
#521001004

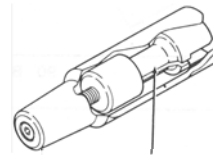
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Rectangular Chucks
Morse Taper Mounting

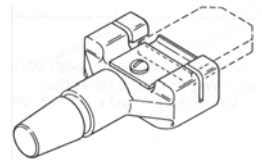
| Chuck Description | Chuck Part Number |
|-------------------|-------------------|
| 1/8 x 3/8 | 500005003 |
| 1/8 x 5/8 | 500005014 |
| 1/8 x 3/4 | 500005021 |
| 1/8 x 7/8 | 500005005 |
| 1/8 x 1 | 500005006 |
| 1/8 x 1-1/2 | 500005059 |
| 3/16 x 3/4 | 500005007 |
| 3/16 x 7/8 | 500005008 |
| 3/16 x 1 | 500005009 |
| 3/16 x 1-1/4 | 500005011 |
| 1/4 x 1/2 | 500005092 |
| 1/4 x 3/4 | 500005010 |
| 1/4 x 1 | 500005012 |
| 1/4 x 1-1/4 | 500005019 |
| 3/8 x 1 | 500005101 |

90° Bent Stud Style Chucks
1/2-20 Internal Thread Mounting

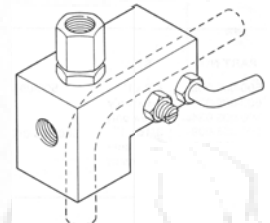
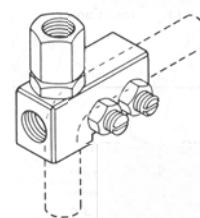
| Chuck Description (Stud Diameter) | Chuck Part Number |
|-----------------------------------|------------------------|
| 1/8 | 500008001 or 500008002 |
| 3/16 | 500008004 |
| 1/4 | 500008005 |
| 5/16 | 500008006 |
| 3/8 | 500008007 |
| 7/16 | 500008009 |
| 1/2 | 500008010 |
| 9/16 | 500008011 |
| 5/8 | 500008012 |
| 3/4 | 500008013 |
| 7/8 | 500008014 |



500-005-0033 INSERT 1/8 x 5/8"
Rectangular 1/8 x 5/8" Chuck with Insert



Rectangular Spring Chuck with Morse Taper Mounting



90° Bent Style Chucks with 1/2-20 Internal Thread Mounting

Left: Chuck for studs 1/8 through 7/16"
Right: Chuck for studs 1/2 through 7/8"

Internal Morse Taper Adapter with Internal Threads

| Thread | Length | Part Number |
|--------|--------|-------------|
| 1/2-20 | 1-7/8 | 751004029 |

Square Chucks

1/2-20 Internal Thread Mounting

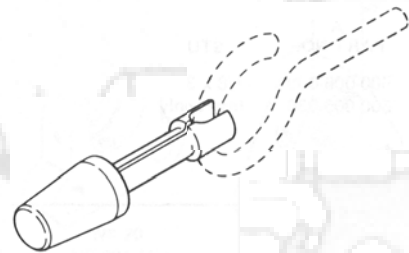
| Chuck Description | Chuck Part Number |
|-------------------|-------------------|
| 3/4 | 500007035 |
| 7/8 | 500007037 |
| 1-1/8 | 500007039 |

Eyebolt Chucks
Morse Taper Mounting

| Chuck Description | Chuck Part Number |
|-------------------|-------------------|
| 3/16 | 500011002 |
| 1/4 | 500011003 |
| 5/16 | 500011004 |
| 3/8 | 500011005 |
| 7/16 | 500011006 |
| 1/2 | 500011007 |

45° Bent Stud Chucks
1/2-20 Internal Thread Mounting

| Chuck Description | Chuck Part Number |
|-------------------|-------------------|
| 3/8 | 500010002 |
| 1/2 | 500010008 |
| 5/8 | 500010010 |
| 3/4 | 500010016 |
| 7/8 | 500010037 |



Eyebolt Style Chucks

Nelson Side Gripping chucks have two ball detents and a screw lever to grip the studs. Chuck adapter offset, #500014088, and other parts are needed to mount these chucks on the stud welding gun.

Side Gripping Chuck Assemblies

| Assembly Description | Chuck Assembly Number |
|----------------------|-----------------------|
| 1/4 | 500014103 |
| 3/8 | 500014102 |
| 1/2 | 500014095 |
| 5/8 | 500014096 |
| 3/4 | 500014097 |
| 7/8 | 500014101 |

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NELSON STUD WELDING

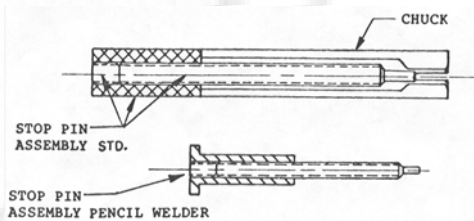
ACCESSORY SPECIFICATION: Capacitor Discharge Weld Gun Chucks

Standard and Metric Capacitor Discharge Stud Welding Chucks for use with NCD-60, NCD-100, and NCD-150 Stud Welding Guns

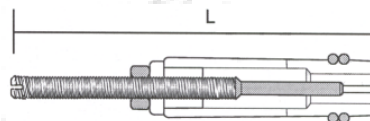
| Chuck Description | Stud Diameter | | Length | Chuck Part Number |
|-----------------------|-----------------------------|-----------------------|--------|-------------------|
| | Imperial Dimension (inches) | Metric Dimension (mm) | | |
| 13ga. | 0.095 | 2.41 | 2-3/8 | 500001374 |
| 12ga. | 0.109 | 2.77 | 2-3/8 | 500001363 |
| 0.118 and #4 threaded | 0.112 | 2.84 | 2-3/8 | 500001355 |
| 1/8 and #5 threaded | 0.125 | 3.17 | 2-3/8 | 500001390 |
| 10ga. and #6 threaded | 0.134 | 3.40 | 2-3/8 | 500001356 |
| M4 | 0.157 | 3.99 | 2-3/8 | 500001361 |
| #8 threaded | 0.164 | 4.17 | 2-3/8 | 500001357 |
| 3/16 Annular Ring | 0.178 | 4.75 | 2-3/8 | 500001373 |
| #10 threaded | 0.190 | 4.83 | 2-3/8 | 500001366 |
| M5 | 0.197 | 5.00 | 2-3/8 | 500001358 |
| M6 | 0.236 | 6.00 | 2-3/8 | 500001362 |
| 1/4 | 0.250 | 6.35 | 2-3/8 | 500001359 |
| 5/16 and M8 | 0.312 | 7.92 | 2-3/8 | 500001360 |
| 3/8 | 0.375 | 9.53 | 2-3/8 | 500001369 |

Stud Stop Pin Assembly for NCD-60, NCD-100, and NCD-150 Stud Welding Guns

| Stud Length (inches) | Part Number |
|----------------------|-------------|
| 1/4 to 5/8 | 500017017 |
| 3/4 to 1-1/8 | 500017018 |
| 1-1/4 to 1-5/8 | 500017019 |
| 1-3/4 to 2-1/8 | 500017020 |



NCD-60, NCD-100, and NCD-150 Chuck



CD-Lite-G and CD-Lite-C Chuck

Standard Capacitor Discharge Stud Welding Chucks for use with CD Lite-G and CD Lite-C Stud Welding Guns for welding 1/4 – 1-1/2" long studs

| Chuck Description | Stud Diameter | | Length* | Chuck Assembly Part Number |
|-------------------|-----------------------------|-----------------------|---------|----------------------------|
| | Imperial Dimension (inches) | Metric Dimension (mm) | | |
| #4 | 0.112 | 2.84 | 1-3/4 | 520322 |
| #6 | 0.134 | 3.40 | 1-3/4 | 520323 |
| #8 | 0.164 | 4.17 | 1-3/4 | 520324 |
| #10 | 0.190 | 4.83 | 1-3/4 | 520325 |
| 1/4 | 0.250 | 6.35 | 1-3/4 | 520326 |
| 5/16 | 0.312 | 7.92 | 1-3/4 | 520327 |

Standard Capacitor Discharge Stud Welding Chucks for use with CD Lite-G and CD Lite-C Stud Welding Guns for welding 6.0 – 40.0mm long studs

| Chuck Description | Stud Diameter | | Length* | Chuck Assembly Part Number |
|-------------------|-----------------------------|-----------------------|---------|----------------------------|
| | Imperial Dimension (inches) | Metric Dimension (mm) | | |
| 3.0 | 0.118 | 3.0 | 45.0 | 215500 |
| 4.0 | 0.157 | 4.0 | 45.0 | 215501 |
| 5.0 | 0.198 | 5.0 | 45.0 | 215502 |
| 6.0 | 0.236 | 6.0 | 45.0 | 215503 |
| 8.0 | 0.315 | 8.0 | 45.0 | 215504 |

* Welding of studs longer than 1-1/2" (40.0 mm), or through a template, requires special accessories

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