TUFFALOY FAST FOLLOW-UP HOLDERS





Current flow follows dashed arrow through the outer body, two split contact rings, tapered tip socket, and to the electrode.

U.S. Pat. No. 3,632,958 Canada Pat. No. 902,189

TUFFALOY fast follow-up (low inertia) holders solve the problem of maintaining adequate weld pressure on rapidly collapsing projection welds-with fewer set-up problems and reduced maintenance.

These holders can be set to deliver fast follow-up forces ranging from 140 to 1300 pounds, a range covering 90% of all projection welding operations. They are compact, water cooled, and easy to maintain.

Plus features of the TUFFALOY fast follow-up holder include: (1) wider range of pressures than any competitive make (2) no flexible shunt (a common cause of holder failure) (3) use of standard, unmodified die springs, so if you need a spring of different strength, it's easily available (4) spring forces available are clearly indicated, so it's easy to set up for a specific force (5) three shank sizes, or it can be platen-mounted-the only fast follow-up holder that can (6) extremely low height permits use where larger units can not be used.

TUFFALOY fast follow-up holders can be used to limit the weld pressure of any spot welding machine regardless of cylinder size or air pressure. This is better than reducing air pressure, which slows the return stroke and retards production.



For every one-eighth of an inch that a fast follow-up is compressed when setting up, a known amount of force is provided, to quickly follow up any reduction in work thickness. Example: at position B, a type MH spring would delivery 310 lb, at C, 440 lb, etc.

FAST FOLLOW-UP FORCE CHART (LBS.)								
1/8-in. Compression	1/4-in. Compression	3/8-in. Compression	1/2-in. Compression					
140	200	250	300					
310	440 840	560 1070	680 1300					
	1/8-in. Compression 140 310 600	Image: Non-State State St	I/8-in. 1/4-in. 3/8-in. Compression Compression Compression 140 200 250 310 440 560 600 840 1070					

Mounting Style	300 LBS MAX. (M SPRING)		680 LBS. MAX. (MH SPRING)		1300 LBS. MAX. (H SPRING)	
	Descrip- tion	Part No.	Descrip- tion	Part No.	Descrip- tion	Part No.
1" Shank 1-1/4" Shank 1-1/2" Shank Platen-Mtd.	4620 4623 4626 4629	350-4620 350-4623 350-4626 350-4629	4621 4624 4627 4630	350-4621 350-4624 350-4627 350-4630	4622 4625 4628 4631	350-4622 350-4625 350-4628 350-4631



7" SOUARE

