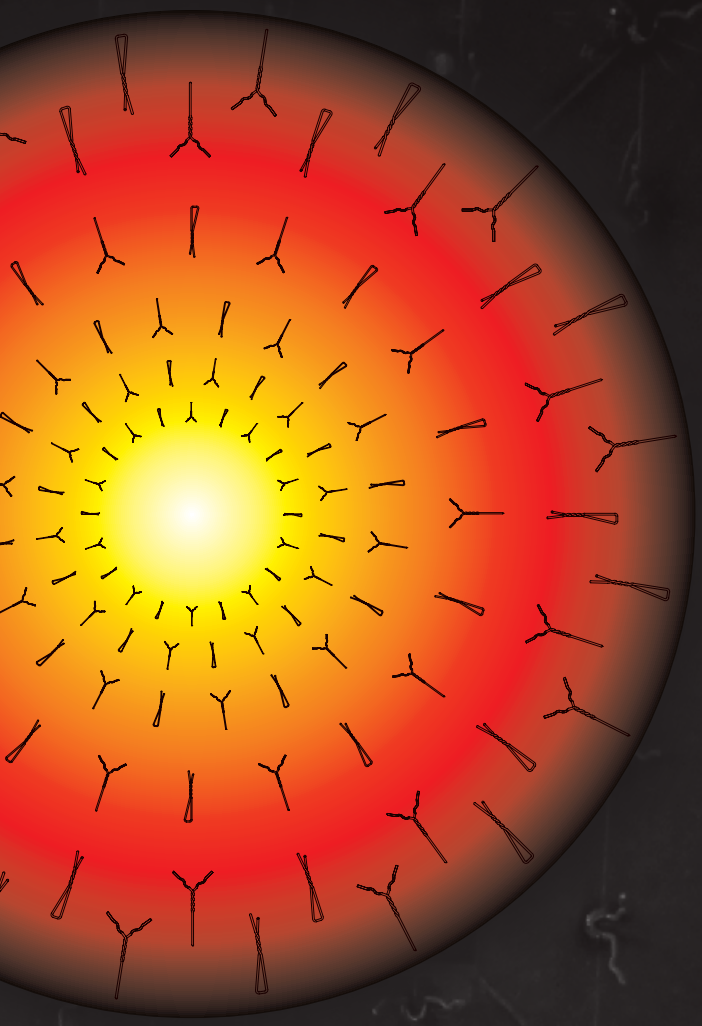
PRESSFORM

REFRACTORY ANCHORS CATALOGUE



CATALOGUE

VERSION NO. 05.2024

WELCOME

50 YEARS OF REFRACTORY INDUSTRY EXPERIENCE & INNOVATION

Pressform Engineering has over 50 years experience in the design, development and manufacture of Refractory Anchors for high temperature furnaces and kilns. In 1978, Pressform developed the **Rod Lock & Rota Lock Anchor** and has, since then, manufactured and supplied close to 50 million refractory anchors world-wide.

We have worked with Australia's leading companies in the cement, steel and petrochemical industries to develop and supply cost effective, industry-leading Refractory Anchors. We believe experience and innovation is paramount and our specialist team has developed a unique, comprehensive offering of quality Refractory Anchors for almost any application.

THE METAL MANUFACTURING EXPERTS

Pressform's service and delivery is second to none with Refractory Anchors made to order in our extensive manufacturing facility, with our manufacturing team on call to allow for fast turnaround and delivery.

Having our own manufacturing facility and expert team, lead by Metallurgist John Worner, allows us to offer custom design and development to your specification, ensuring not only that your job **is cost effective** but that your product is **efficiently designed** with the correct metals and alloys to achieve the highly specialised task at hand. We also work in conjunction with customers to find solutions to existing refractory problems – we can provide investigation, reporting, recommendations and specialised product development.

THE REVOLUTIONARY STUD WELDING SYSTEM

With our extensive experience and in depth knowledge of our customer's needs, we have developed the revolutionary **Pressform Stud Welding System**: a fast, efficient and fully transportable stud welding system for refractory anchor installation. Designed to save precious project time and allow you to work **10 times faster. Find out more in this catalogue or contact us to discuss how it can work for you.**

For enquiries and orders, please contact us directly:

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www.pressform.com.au

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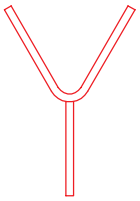

PF WNL ANCHOR
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PF SPLIT FLAT BAR Y-ANCHOR
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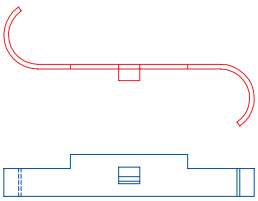
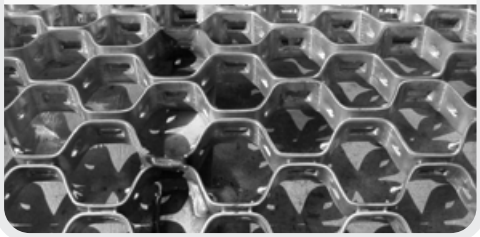
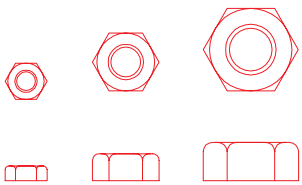


PF STUDS
PF-R028

PF HEXAGONAL MESH
PF-R024



PF NUTS
PF-R029



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PF WASHERS
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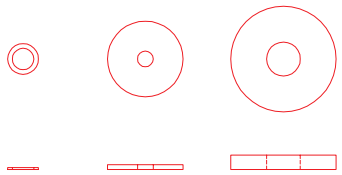

PF BLOCK ANCHORS
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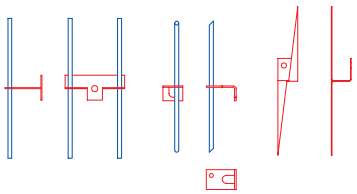

PF FIBRE ANCHOR
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PF HEXAGONAL CELL
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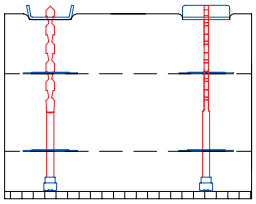
PF FIBRELOK ASSEMBLEY
PF-R032



PF CERAMIC CUP LOKS
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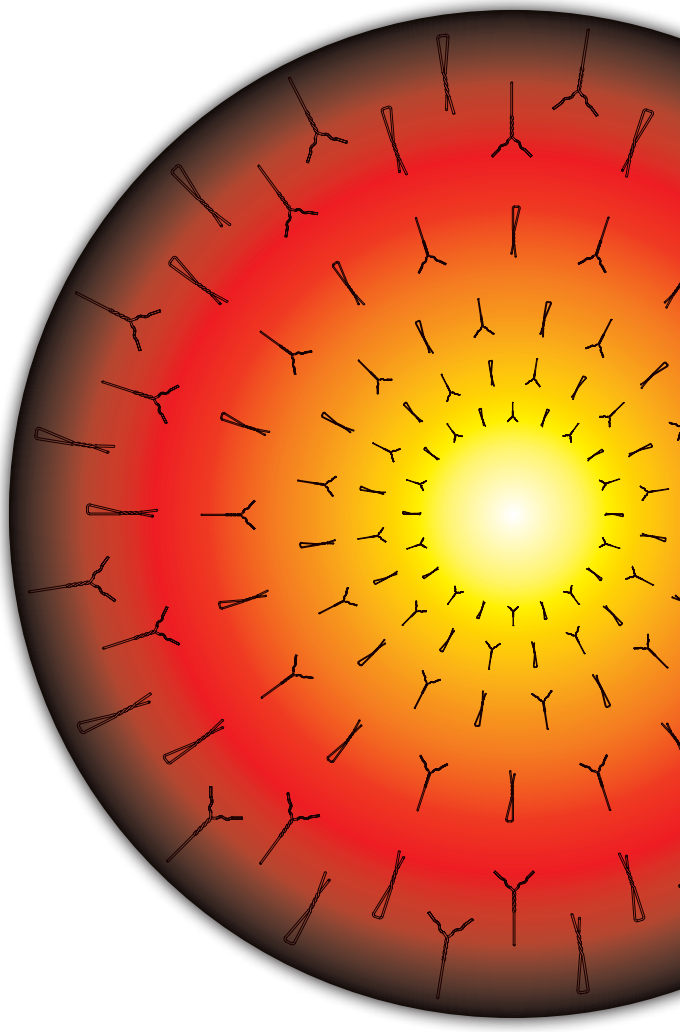
PF BI-METALLIC PIN
PF-R034



PRESSFORM ENGINEERING PTY LTD IS YOUR ONE STOP METAL MANUFACTURING SHOP.

We provide a total component solution from the smallest custom part to complex, welded structures up to 10 tonnes. We offer all forms of welding, laser cutting, rolling, CNC punching and perforating, bending, stamping, hot forming, CNC machining and profiling and we work consistently in all metals. We design, build and maintain all our tooling in our own factory which ensures our products are high quality and cost effective.

CAPABILITIES:

- Hydraulic Powered **Press 630 tonne** with deep draw die cushion capacity
- CNC **Turret** Press – 30 tonne
- CNC **Plasma** Cutting with nesting software
- 3Kw & 6Kw **Fibre Laser** Cutting Machines cutting up to 25mm thick
- **Press Brake 400 tonne x 4000mm long** Press Brake 150 tonne x 3600mm long
- Automatic scissor style Bandsaw with feed table and full capacity hydraulic overhead bundling
- Punching 0.5mm to 20mm thick
- **Bending** 2.5 to 150 tonne, fast mechanical and metered hydraulic
- Cropping 250mm x 10mm, 75mm x 20mm
- Forming & deep drawing
- CNC Plate **Rolling** 10mm x 1800mm wide to 32mm x 75mm, including cone sections
- Lifting Capacity 10 tonnes overhead cranes
- Complete Welding (GMAW, GTAW, MMAW, SAW) and **fabrication** capabilities
- **Robot Welding System** with 2000mm arm reach for stainless & mild steel welds
- **Stud Welding:** Including Stud Production and Testing
- CNC Milling: **Machining** Centres
- **CNC** Turning: Bar Feed **Lathes** (72mm max for bar feed)
- Tool Making and General Machining (Milling, Surface Grinding, Turning, Drilling and Threading)
- Painting: Electro Static Painting capabilities (2 pack, Enamel)
- Dual Head Semi-Automatic Welding capabilities
- Post production finishing services: Sand Blasting, **Rumbling**, Painting, Powder-coating, Galvanising, Anodising, Electroless Nickel, Zinc or Chrome Plated.

MATERIALS:

Manufacture from materials including austenitic & ferritic stainless steel alloys, nickel alloys, copper, brass, aluminium, and carbon steels (including forming, high tensile & boiler grade)

DELIVERY SERVICE:

Pressform Engineering provides a cost effective delivery service with our Hino Truck with 8.2 tonne load capacity & 7.6 x 2.5 metre tray.

We are pleased to offer advice on the manufacturing practicality of proposed products and to offer suggestions to improve both the function and commercial viability.

WELDING

Particular technical emphasis should be observed when welding any refractory anchor. Full strength optimum welds hold the refractory products to the furnace wall.

DISSIMILAR WELDING TECHNIQUES

A large portion of refractory anchor welding will be stainless nickel alloys to mild or carbon steel shells i.e. dissimilar metal welding.

CHOOSE WELDING CONSUMABLE WITH CARE

For the welding of common stainless alloys (austenitic) 310, 309, 321, 304 to mild or carbon steels use 310 or 309 consumable. Ensure that the consumable is not molybdenum containing thus avoiding possible embrittling phases forming.

When welding with 310 minimise possible *hot cracking* by controlling heat input and avoiding "globular" welds. Grade 310 undergoes rapid tensile strength increase as temperature drops from weld pool to ambient. Consequent high strength attained on surface-metal tears apart central hot metal producing cracks. Endeavour to keep cross sectional area linear/concave rather than convex. Grade 309 is preferred for reducing *hot cracking susceptibility*. Consult manufacturer's literature for particular nickel alloy consumables.

PREPARATION

In new or repaired kilns, atmospheres are often contaminated with iron and concrete particles-ensure weld surface is clear at time of arc strike.

Grind to bare metal all weld pool locations immediately prior to welding, minimise contamination of weld pool by shielding protection as practicable.

No moisture, over sprays, paint, fumes, dew, marking inks, lubricants, near the weld pool.

APPLICATION

Follow a proven weld procedure which closely reflects the application:

a) Prove and test a new procedure

b) Follow a previously documented procedure

CARE

The anchor being welded has been designed by the refractory designer to hold and anchor the chosen valuable monolithic castable segments. The designer will have assumed the weld strength equals or exceeds the anchor metal strength.

STUD WELDING

Many anchor designs can be modified to allow for Stud Welding. This method may be faster to apply but the forgoing advice is still imperative. The requirement for a near perfect surface for Stud application is in fact magnified.

STUD DESIGN

In general a stud minimum length is approximately 25-30mm. This will allow for the chuck to grip and plunge the stud. The end must have an appropriate chamfer and flat landing for the aluminium flux. A ball of Aluminium is often used, but for some alloys, it may be necessary to reduce the volume of aluminium. It is advisable to prove the procedure and stud design before committing to order the full complement of studs for the job. Pressform can assist with this experimentation.

METALLURGY

The common practice of applying grade 304 studs directly to carbon steel parent metals must be tempered by the knowledge that a reduced strength weld is achieved. Therefore be aware that stud size is such that the supported weight reflects the reduced weld strength. The designer will therefore disallow substitution of stud diameters different from that specified.

Please contact Pressform for a technical evaluation.

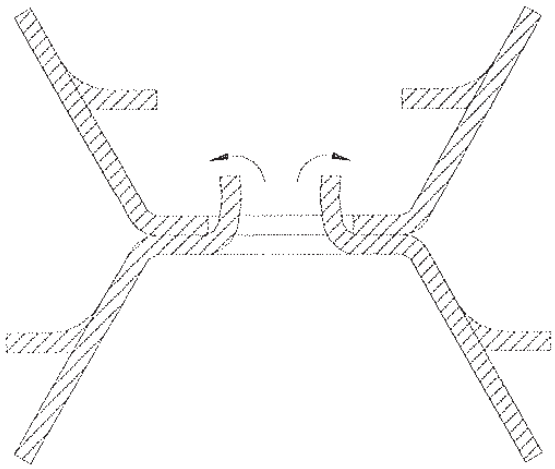
PROBLEMS

Technical advice is available from contractible metallurgists when required. We would be pleased to attend to any problems either from our own knowledge and experience, or coupled with expert reports.

HEXAGONAL MESH

Pressform's mesh tool was produced initially from listening to requests from engineers and processors.

We have endeavoured to optimise strength by maximising lug width and continuing the natural "form curl" direction when closing the lugs onto their mated link . In piercing the parent stainless or carbon steel strip, the tool punches through and the resultant "lug" or "tab" forms a curl thus:



It is likely that the outer edges will exhibit unavoidable micro surface cracks merely from the process of piercing. These will be compressed in the next process as the lug bend is continued to close the 2 strips together. We prefer to avoid a bend back or 180 degree reversal in the closing operation for fatigue considerations.

The amount of lug closure can be adjusted so that sheets can be flexed in the "easy" direction. This can assist installers where the mesh will lift up into or around a pre-determined curve diameter. For example if the customer wishes to encapsulate on air tube of X diameter (minimum of 320mm), the lug closure can be "set" accordingly.

However, where it is necessary for "hard direction" rolling, the mesh is closed tightly prior to the rolling or forming.

Our advice generally is to avoid "hard rolling" because the stresses introduced into the metal strips in the production processes are already considerable, although unavoidable. It seems desirable to avoid further strain if possible.

MATERIAL SELECTION

The high temperatures refractory anchor metals face, demand awareness that many metallurgical parameters come into consideration:-

CREEP, FATIGUE, GRAIN GROWTH, PHASE CHANGE, EMBRITLEMENT, ELEMENT MIGRATION, CRACK PROPAGATION, PRECIPITATION HARDENING, AGING, ELONGATION, CHEMICAL INGRESS, OXIDATION, REDUCTION, SULPHIDATION, TENSILE & COMPRESSIVE STRESSES.

Mild or carbon steels should not face a constant temperature greater than 150deg C. Some of the Chrome Moly Grades will have superior properties, and should be selected by a Design Engineer.

The Austenitic Stainless Alloys such as 304 & 321 are good general purpose alloys with Heat Resistance. Maximum Temperatures of 900-950deg C in oxidising conditions can be handled. The 309 based alloys may be 100 Deg more. The 310 and 253Ma alloys are often used up to 1100 deg C . At these temperatures be aware that the metals are at their limits and will be glowing pale yellow or brighter, and soft. Design creep and fatigue will be factors to be considered. The Furnace atmosphere is critical the presence of sulphur, halogens and reducing conditions change maximum temperature resistance.

Alloys that are high in nickel, or complex metallurgy's with additions of rare earth's or special elements may be nominated to perform in particular situations. New and interesting Alloys are constantly being developed.

Pressform will freely provide customers with advice and pass on experience relative to a new problem. The limit of Wrought or Cast Metals in anything other than an Inert Atmosphere is 1200 deg C. Beyond this a ceramic could be considered. The knowledge of the refractory designer is crucial to the aspects of furnace construction concerning heat containment.

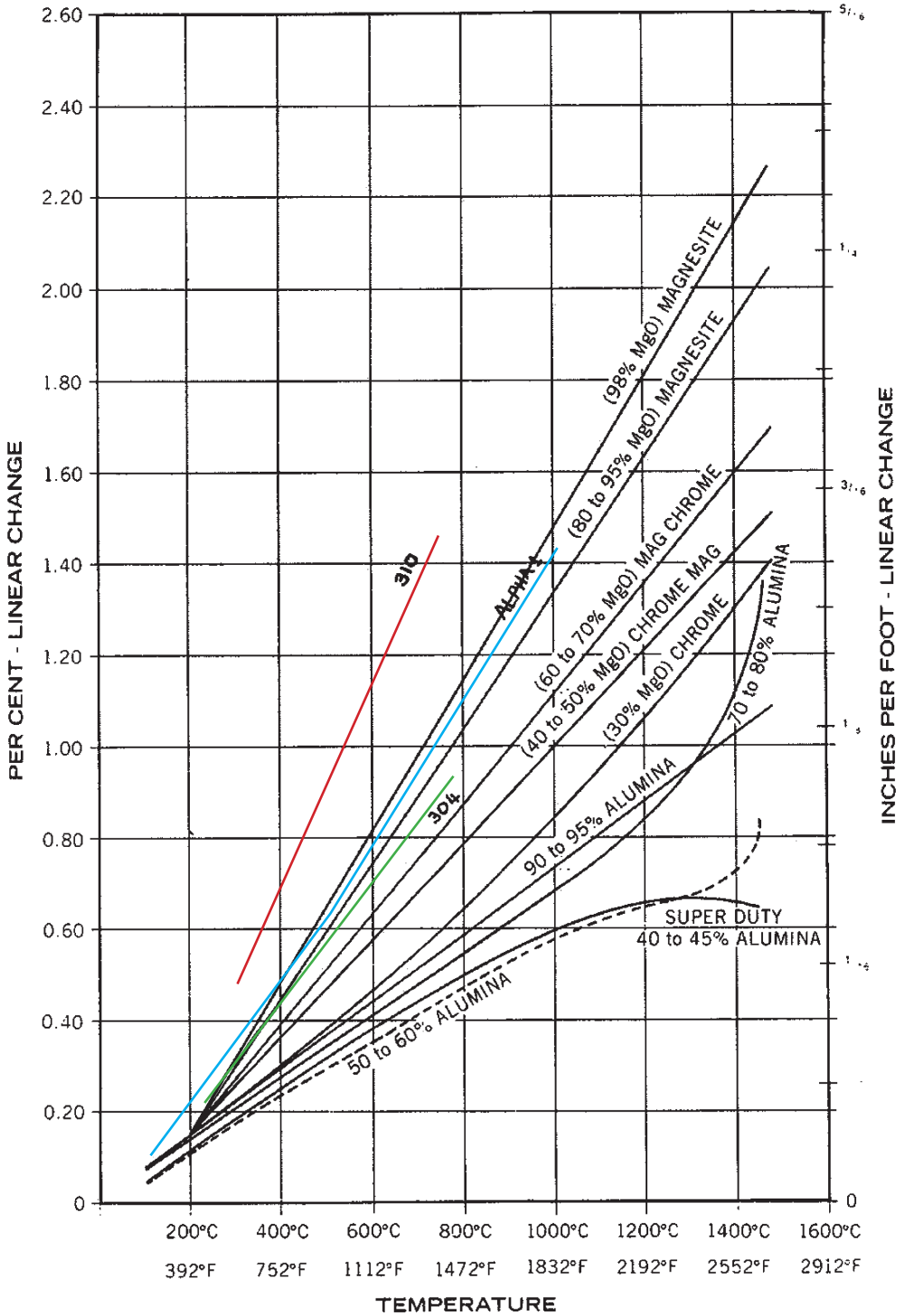
Pressform has a library of literature kindly supplied by various manufacturers to whom we can refer an enquiry for assistance. We are also in contact with R & D laboratories where investigations can be initiated.

Pressform is proud to provide this catalogue which is compiled to stimulate thought of what "could be" based on what "has been". We are pleased to make "specials".

REFRACTORY ANCHORS CATALOGUE

The thermal expansion of austenitic stainless steel grades 310 & 304 is shown here, illustrating a variance to that of some refractories. Consideration of a differential is relevant where capping or coating of wire anchor surfaces is contemplated.

THERMAL EXPANSION OF VARIOUS REFRACTORIES



GRADE	TYPICAL COMPOSITION (%)						Form & condition	Typical Mechanical Properties				Comments
	C	Mn	Ni	Cr	Mo	OTHER		Yield strength (o.2% offset), 1000 psi	Tensile Strength 1000 psi	Elongation in 2 in, %	Hardness, Brinell or Rockwell	
304	0.06		9.5	18.5			Sheet Annealed Cold Rolled	35 up to 160	85 up to 185	50 4	R_B80 up to R_C40	Versatile general purpose stainless steel with excellent welding and drawing properties
304L	0.025		9.5	18.6			Sheet Annealed	28	75	50	R_B70	Extra low carbon version of 304 for enhanced welding properties
308	0.04		10.25	20.75								Used in welding electrodes or filler wire
308L	0.03		10.25	20.75								Extra low carbon version of 308 used for welding filler wire
309	0.12		14.40	22.25			Sheet Annealed	45	90	45	R_B85	High tensile and creep strength at elevated temperatures. 309L is a low carbon version used for welding electrodes and filler wire
310	0.13		19.75	24.75			Sheet Annealed	45	95	45	R_B85	Excellent high temperature properties with good ductility and weldability - designed for cyclic elevated temperatures
310S	0.05		19.50	24.50								Low carbon version of grade 310
316	0.07		13.00	16.50	2.50		Sheet Annealed	40	90	50	R_B85	Molybdenum bearing grade better overall corrosion resistance than 304
316L	0.023		13.40	16.50	2.70		Sheet Annealed	32	75	50	R_B72	Low carbon version of 316 used where impossible to anneal after welding
321	0.07		10.25	17.75		Ti 0.45	Sheet Annealed	35	90	50	R_B80	Austenitic 18/8 stainless with the addition of titanium. Resistant to intergranular corrosion 425-870° C

430	0.06			17.20	0.90		Sheet Annealed Cold Rolled	45 up to 95	75 up to 110	25 10	R_B80 up to 225	Ferritic, Non Hardenable grade of stainless - good formability and mechanical properties.
410	0.13			12.25			Sheet Annealed Heat Treated	45 140	70 180	25 15	R_B80 R_C43	Machinable and hardenable grade of stainless steel
416	0.12			12.50		S 0.25						Highly Machinable and hardenable grade of stainless steel
420	0.31			13.00			Bar Annealed Heat Treated	50 195	95 230	25 8	R_B92 500	Heat treatable stainless Hardenable to 50R_C
431	0.15		2.00	15.75			Bar Annealed Hardened	95 150	125 195	25 15	260 400	Heat treatable Martensitic Nickel bearing grade. Excellent Tensile strength.
600 INCONEL	0.15 max	1.0 max	72.00 min	14.0 - 17.0		S 0.015max Si 0.5 max Cu 0.5max		35	91			Good oxidation resistance at high temperatures and resistance to chloride-ion stress corrosion, corrosion by high purity water and caustic corrosion
601 INCONEL	0.10 max	1.0 max	58.0 - 63.0	21.0 - 25.0		S 0.015 max Si 0.50 max Cu 1.0-1.7 Al 1.0-1.7		35	101			Nickel chrome alloy with the addition of aluminium for outstanding resistance to oxidation at high temperatures.
800HT INCOLOY	0.06- 0.10	1.50 max	30.0 - 35.0	19.0 - 23.0		S 0.015 max Si 1.0 max Cu 0.75 max Al 0.15-0.60 Ti 0.15-0.60		34	83			Excellent resistance to oxidation and carburization at high temperature. Higher creep-rupture strength at high temperature.
INCOLOY DS	0.10 max	0.8 - 1.5	34.5 - 41.0	17.0 - 19.0		S 0.03 max Cu 0.50 max Ti 0.20 max Si 1.9 - 2.6		32	88			Good high temperature strength and resistance to oxidation and carburization. Used for internal furnace parts.
253MA (ASTM S30815)	0.10 max		9.5	18.5		Sin N, Ce	Sheet Annealed	45	94	40	R_B95 max	Very good high temperature corrosion resistance. Good forming and welding characteristics

TABLE OF CONVERSION FACTORS (ARRANGED ALPHABETICALLY)

The figures 10^{1}, 10^{2}, 10^{3}, etc. denote 0.1, 0.01, 0.001, etc respectively. The figures 10^{1}, 10^{2}, 10^{3}, etc. denote 10, 100, 1000 etc.

MULTIPLY	BY	TO OBTAIN
Acres	4047	Square meters
British Thermal Units	0.2520	Kilogram-calories
B.T.U. / min.	0.01757	Kilowatts
Cubic feet	0.02832	Cubic metres
Cubic feet	7.48052	Gallons
Cubic feet	28.32	Litres
Cubic feet / minute	0.4720	Litres / sec.
Cubic inches	16.39	Cubic centimetres
Cubic inches	1.639×10^{-5}	Cubic metres
Cubic inches	1.639×10^{-2}	Litres
Cubic metres	61,023	Cubic inches
Cubic metres	264.2	Gallons
Cubic metres	1000	Litres
Feet / second	1.097	Kilometres / hr.
Feet / second	0.5921	Knots
Feet / second / second	0.3048	Metres / sec./sec.
Foot - pounds	3.241×10^{-4}	Kilogram - calories
Gallons	3.785×10^{-3}	Cubic metres
Hectares	2.471	Acres
Horse - power	10.70	Kilogram - calories/min
Horse - power	0.7457	Kilowatts
Horse - power (boiler)	9.803	Kilowatts
Inches	2.540	Centimetres
Gallons	3.785	Litres
Gallons, Imperial	4.5460	Litres
Kilograms	2.205	Pounds
Kilograms - calories	3086	Foot - pounds
Kilometres	3281	Feet
Kilometres	0.6214	Miles
Kilometres / hr.	54.68	Feet / min.
Kilometres / hr.	0.6214	Miles / hr.
Kilowatts	1.341	Horse - power
Kilowatts	14.34	Kilogram-calories/min.
Kilowatt - hours	860.5	Kilogram - calories
Litres	0.03531	Cubic feet
Litres	0.2642	Gallons
Miles / hour	1.609	Kilometres / hr.
Millimetres	0.03937	Inches
Metres	3.281	Feet
Metres	39.37	Inches
Metres	10^{-3}	Miles
Miles	1.609	Kilometres
Pounds sq. inch	703.1	Kilograms sq. metre
Square metres	2.471×10^{-4}	Acres
Square metres	10.76	Square feet
Square metres	3.861×10^{-7}	Square miles
Square metres	1550	Square inches
Square miles	640	Acres
Square yards	2.066×10^{-4}	Acres
Square feet	2.296×10^{-5}	Acres
Square feet	0.09290	Square metres
Square feet	3.587×10^{-8}	Square miles
Tons (metric)	2205	Pounds
Watts	1.341×10^{-3}	Horse - power
Watts	0.01434	Kilogram-calories/min.

STANDARD SERIES & SELECTED COMBINATIONS - UNIFIED SCREW THREADS

Nominal Size. Threads per Inch, and Series Designation	External Major Diameter Min	Internal Minor Diameter Max	Internal Major Diameter
1/4 - 56 UNS	0.2451	0.235	0.2500
5/16 - 27 UNS	0.3048	0.281	0.3125
5/16 - 36 UNS	0.3061	0.289	0.3125
5/16 - 40 UNS	0.3065	0.291	0.3125
5/16 - 48 UNS	0.3072	0.295	0.3125
3/8 - 18 UNS	0.3650	0.328	0.3750
3/8 - 27 UNS	0.3672	0.344	0.3750
3/8 - 40 UNS	0.3690	0.354	0.3750
0.390 - 27 UNS	0.3822	0.359	0.3900
7/16 - 18 UNS	0.4275	0.390	0.4375
7/16 - 24 UNS	0.4292	0.402	0.4375
1/2 - 12 UNS	0.4870	0.428	0.5000
1/2 - 14 UNS	0.4882	0.438	0.5000
1/2 - 18 UNS	0.4900	0.453	0.5000
1/2 - 24 UNS	0.4916	0.465	0.5000
1/2 - 27 UNS	0.4922	0.469	0.5000
9/16 - 14 UNS	0.5507	0.501	0.5625
9/16 - 27 UNS	0.5547	0.531	0.5625
5/8 - 14 UNS	0.6132	0.564	0.6250
5/8 - 27 UNS	0.6172	0.594	0.6250
3/4 - 14 UNS	0.7382	0.688	0.7500
3/4 - 18 UNS	0.7399	0.703	0.7500
3/4 - 24 UNS	0.7416	0.715	0.7500
3/4 - 27 UNS	0.7421	0.719	0.7500
7/8 - 10 UNS	0.8603	0.788	0.8750
7/8 - 18 UNS	0.8649	0.828	0.8750
7/8 - 24 UNS	0.8666	0.840	0.8750
7/8 - 27 UNS	0.8671	0.844	0.8750
1 - 10 UNS	0.9853	0.913	1.0000
1 - 14 UNS	0.9880	0.938	1.0000
1 - 18 UNS	0.9899	0.953	1.0000
1 - 24 UNS	0.9915	0.965	1.0000
1 - 27 UNS	0.9921	0.969	1.0000
1 1/8 - 10 UNS	1.1103	1.038	1.1250
1 1/8 - 14 UNS	1.1131	1.064	1.1250
1 1/8 - 24 UNS	1.1165	1.090	1.1250

COARSE - THREAD SERIES, UNC, UNRC - BASIC DIMENSIONS

Sizes No. or Inches	Basic Major Diam. , D Inches	Threads per Inch, n	Minor Diameter	
			Ext. Threads, c d_3 (Ref.) Inches	Int. Threads, d D_1 Inches
1/4	0.2500	20	0.1905	0.1959
5/16	0.3125	18	0.2464	0.2524
3/8	0.3750	16	0.3005	0.3073
7/16	0.4375	14	0.3525	0.3602
1/2	0.5000	13	0.4084	0.4167
9/16	0.5625	12	0.4633	0.4723
5/8	0.6250	11	0.5168	0.5266
3/4	0.7500	10	0.6309	0.6417
7/8	0.8750	9	0.7427	0.7547
1	1.0000	8	0.8512	0.8647
1 1/8	1.1250	7	0.9549	0.9704
1 1/4	1.2500	7	1.0799	1.0954
1 3/8	1.3750	6	1.1766	1.1946
1 1/2	1.5000	6	1.3016	1.3196
1 3/4	1.7500	5	1.5119	1.5335
2	2.0000	4 1/2	1.7353	1.7594

FINE - THREAD SERIES, UNF, UNRF - BASIC DIMENSIONS

Sizes No. or Inches	Basic Major Diam, D Inches	Threads per Inch, n	Minor Diameter	
			Ext. Threads, c d_3 (Ref.) Inches	Int. Threads, d D_1 Inches
1/4	0.2500	28	0.2074	0.2113
5/16	0.3125	24	0.2629	0.2674
3/8	0.3750	24	0.3254	0.3299
7/16	0.4375	20	0.3780	0.3834
1/2	0.5000	20	0.4405	0.4459
9/16	0.5625	18	0.4964	0.5024
5/8	0.6250	18	0.5589	0.5649
3/4	0.7500	16	0.6763	0.6823
7/8	0.8750	14	0.7900	0.7977
1	1.0000	12	0.9001	0.9098
1 1/8	1.1250	12	1.0258	1.0348
1 1/4	1.2500	12	1.1508	1.1598
1 3/8	1.3750	12	1.2758	1.2848
1 1/2	1.5000	12	1.4008	1.4098

I.S.O METRIC COARSE THREADS

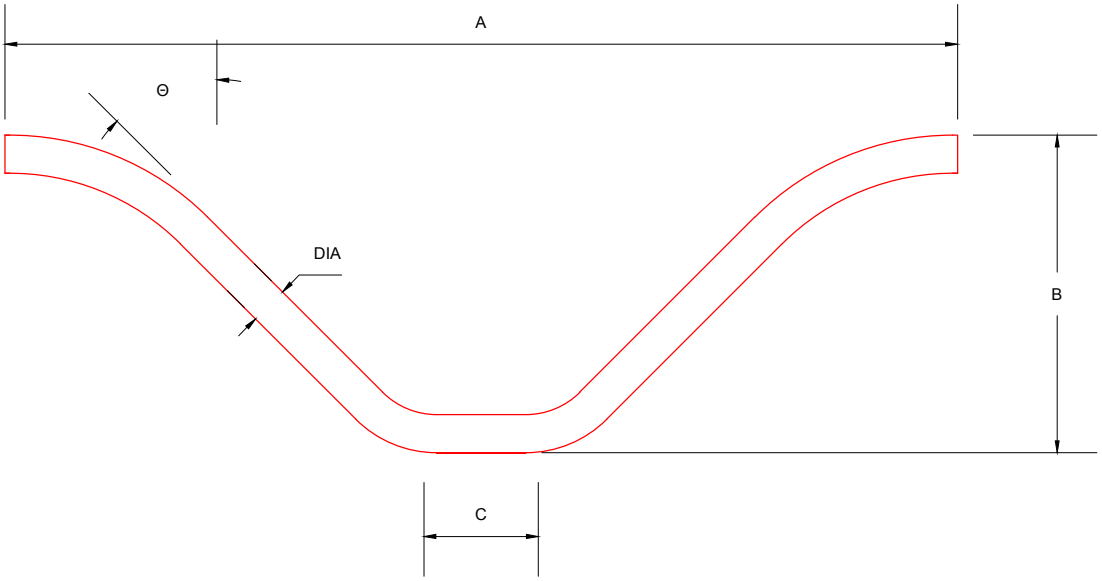
Note: All dimension in mm's

THREAD	O. Dia.	Pitch
M5	5.0	0.80
M6	6.0	1.00
M7	7.0	1.00
M8	8.0	1.25
M10	10.0	1.50
M12	12.0	1.75
M14	14.0	2.00
M16	16.0	2.00
M18	18.0	2.50
M20	20.0	2.50
M22	22.0	2.50
M24	24.0	3.00
M27	27.0	3.00
M30	30.0	3.50
M33	33.0	3.50
M36	36.0	4.00
M39	39.0	4.00
M42	42.0	4.50
M45	45.0	4.50
M48	48.0	5.00
M52	52.0	5.00

AMERICAN NATIONAL STANDARD TAPER PIPE THREADS

NPT (ANSI / ASME B1.20.1 - 1983, R1992)

Nominal Pipe Size	Outside Dia. of Pipe	Threads per inch,	Pitch of Thread	Handtight Engagement	
				Length, $L1$ In.	Diam., E1
1/16	0.3125	27	0.03704	0.160	0.28118
1/8	0.405	27	0.03704	0.1615	0.37360
1/4	0.540	18	0.05556	0.2278	0.49163
3/8	0.675	18	0.05556	0.240	0.62701
1/2	0.840	14	0.07143	0.320	0.77843
3/4	1.050	14	0.07143	0.339	0.98887
1	1.0315	11 1/2	0.08696	0.400	1.23863
1 1/4	1.660	11 1/2	0.08696	0.420	1.58338
1 1/2	1.900	11 1/2	0.08696	0.0420	1.82234
2	2.375	11 1/2	0.08696	0.436	2.29627



Anchor	A	B	Θ
PFCH1	100	25	30
PFCH1½	125	38	30
PFCH2	150	50	45
PFCH2½	175	63	45
PFCH3	175	76	30
PFCH3½	200	88	30

TYPICALLY USED DIAMETERS 5MM, 6MM, 8MM

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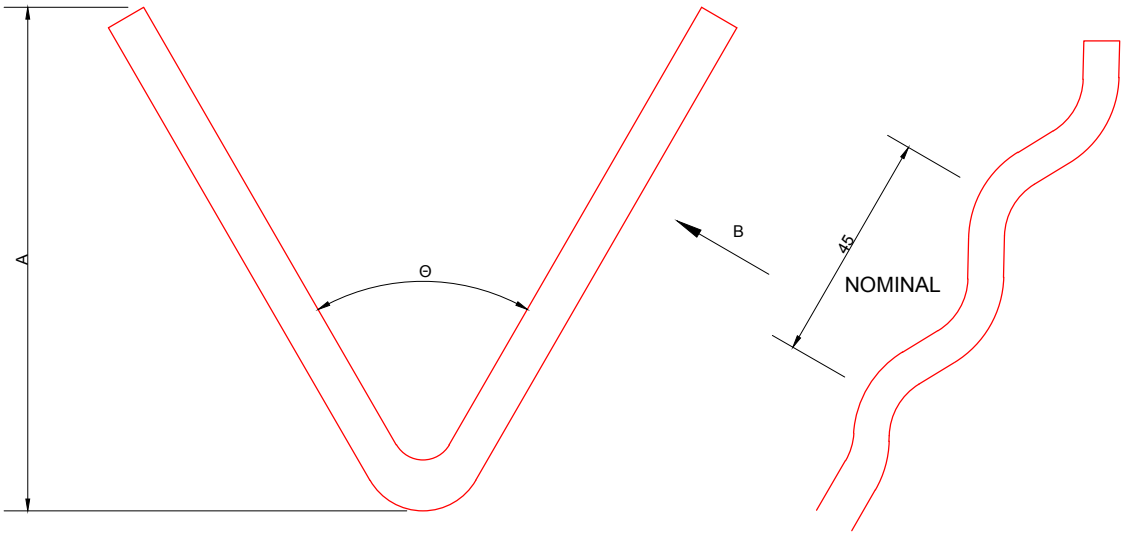
TITLE
PF CH ANCHOR

DATE	REVISION	BY

FILE NAME: PF CH ANCHOR - PF - R001.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S		PF - R001	A4	



ELEVATION
V BASE ANCHOR FOR
MANUAL WELDING

VIEW ON B

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY ANGLE AND CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE

COMMON WIRE SIZES CHOSEN:

A=15-40MM	DIA= 3-5MM
A=25-100MM	DIA= 6MM
A=75-200MM	DIA= 8MM
A=150-300MM	DIA= 10MM

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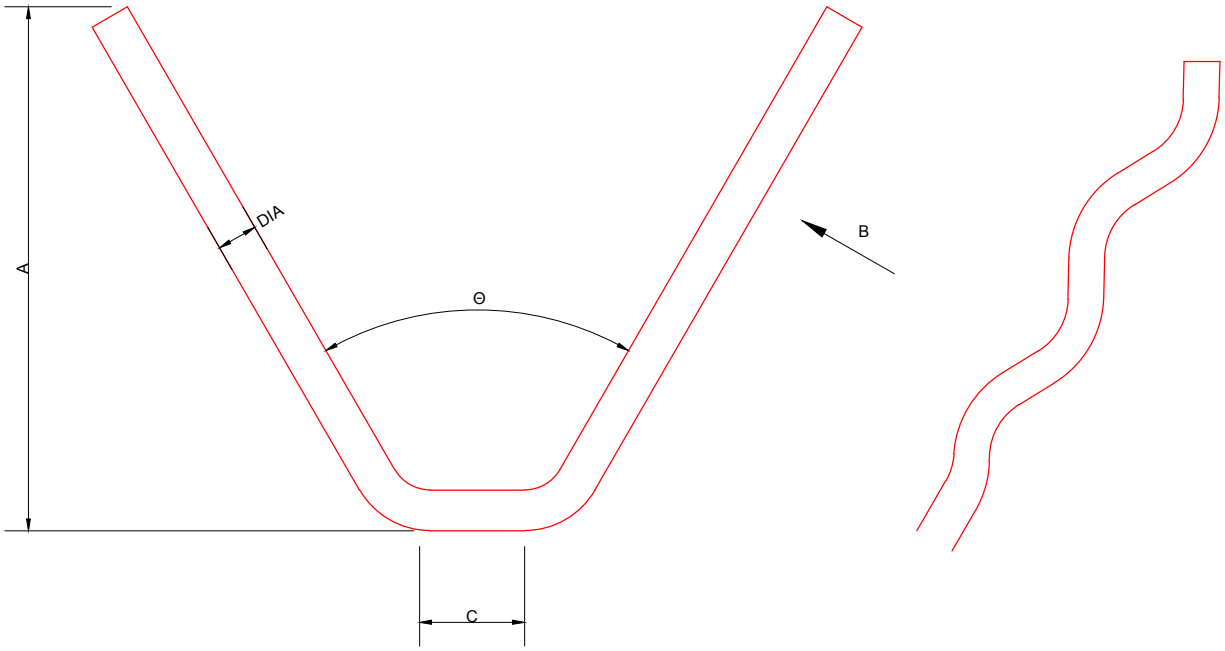
TITLE
PF VW ANCHOR

DATE	REVISION	BY

FILE NAME: PF VW ANCHOR - PF - R002.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S		PF - R002	A4	



ELEVATION
MANUAL WELDING
FLAT BASE ANCHOR

VIEW ON B

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE

COMMON WIRE SIZES CHOSEN:

A=15-40MM	DIA= 3-5MM
A=25-100MM	DIA= 6MM
A=75-200MM	DIA= 8MM
A=150-300MM	DIA=10MM

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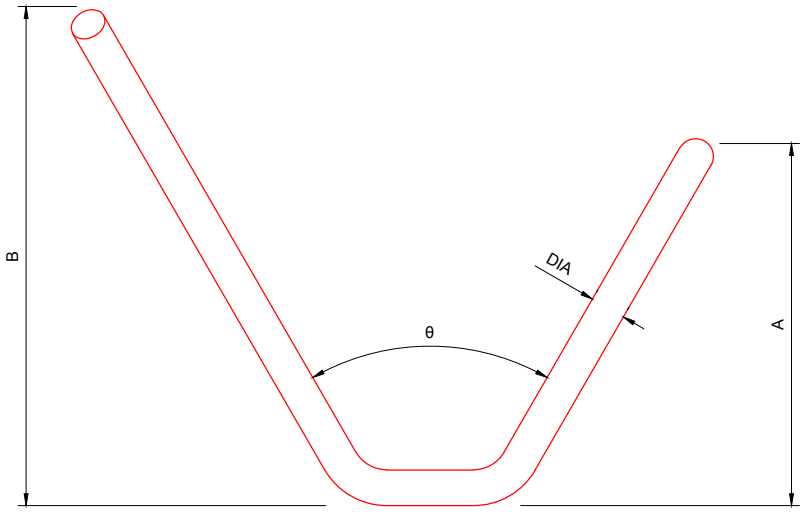
TITLE
PF VWF ANCHOR

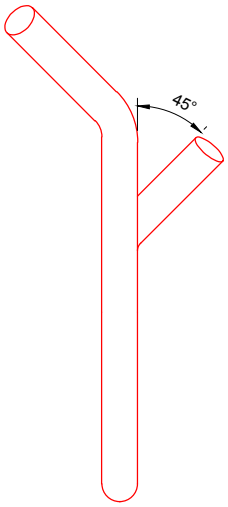
DATE	REVISION	BY

FILE NAME: PF VWF ANCHOR - PF - R003.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

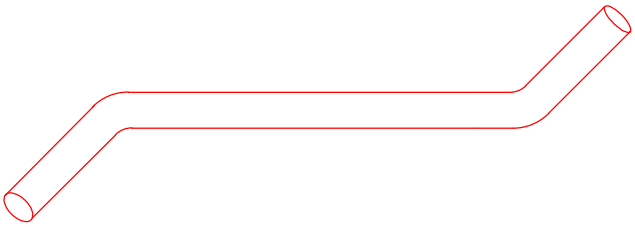
DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S		PF - R003	A4	



ELEVATION



ELEVATION



PLAN

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG NO CORRUGATION

COMMON WIRE SIZES CHOSEN:

A=15-40MM	DIA= 3-5MM
A=15-100MM	DIA= 6MM
A=75-200MM	DIA= 8MM
A=150-300MM	DIA=10MM

ANC No	A	B	C	θ	DIA
PFWO 22	50	50	22	60	6
PFWO 32	75	50	32	60	6
PFWO 43	100	75	43	60	6
PFWO 54	125	100	54	60	6
PFWO 65	150	125	65	60	6
PFWO 76	175	150	76	45	8
PFWO 87	200	175	87	45	8
PFWO 98	230	200	98	45	8
PFWO 109	250	230	109	45	8

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TITLE
PF WOL ANCHOR

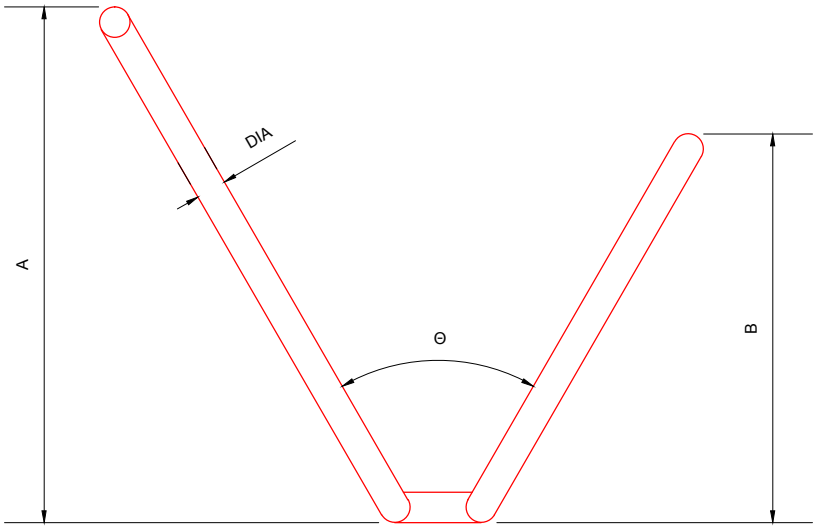
DATE	REVISION	BY

FILE NAME: PF WOL ANCHOR - PF - R004.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

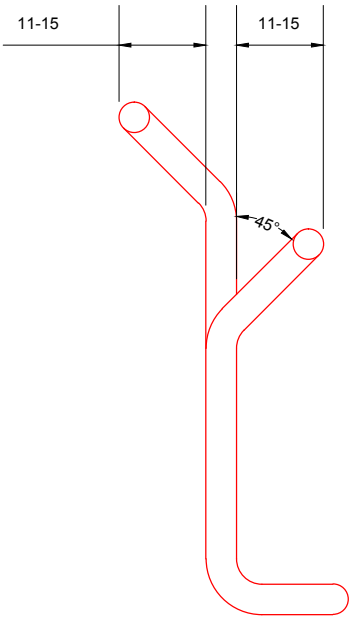
DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

DWG No.
PF - R004

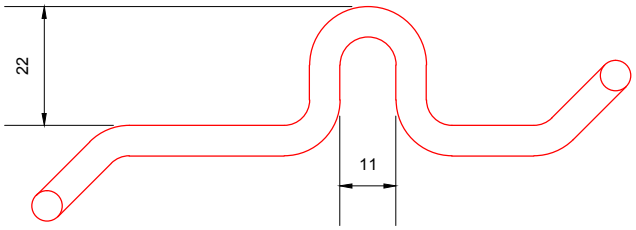
SIZE A4 REV



ELEVATION
LOOP BASE ANCHOR
FOR BOLTING OR WELDING



ELEVATION



PLAN

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG NO CORRUGATION

COMMON WIRE SIZES CHOSEN:

A=15-40MM	DIA= 3-5MM
A=25-100MM	DIA= 6MM
A=75-200MM	DIA= 8MM
A=150-300MM	DIA=10MM

ANC No	A	B	C	θ	DIA
PFWO 22	50	50	22	60	6
PFWO 32	75	50	32	60	6
PFWO 43	100	75	43	60	6
PFWO 54	125	100	54	60	6
PFWO 65	150	125	65	60	6
PFWO 76	175	150	76	45	8
PFWO 87	200	175	87	45	8
PFWO 98	230	200	98	45	8
PFWO 109	250	230	109	45	8

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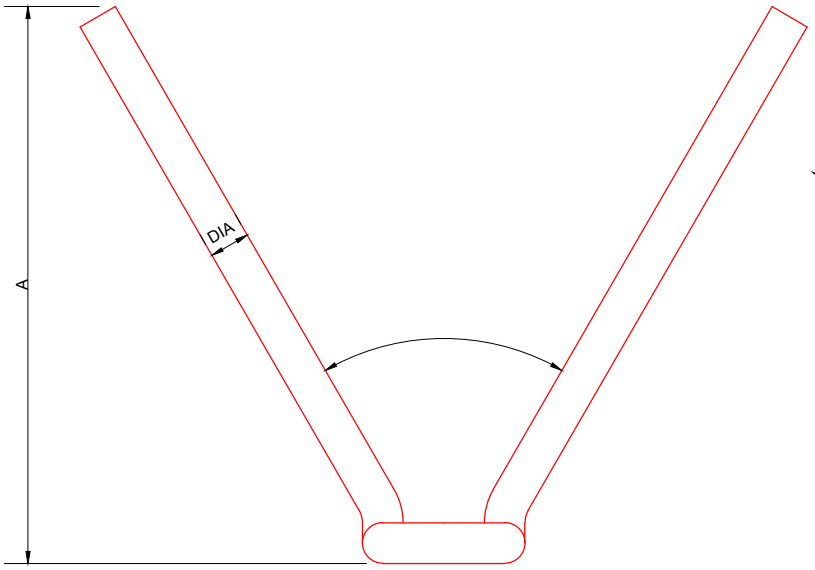
TITLE
PF WBL ANCHOR

DATE	REVISION	BY

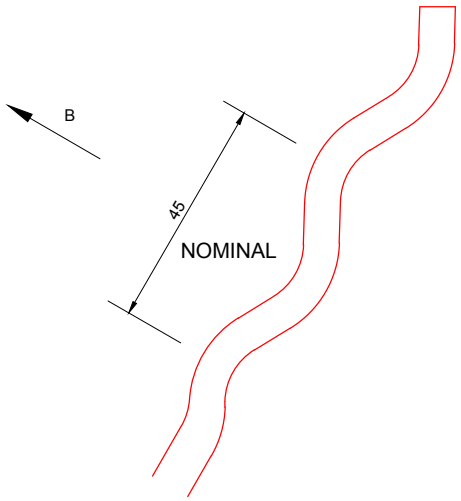
FILE NAME: PF WBL ANCHOR - PF - R005.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

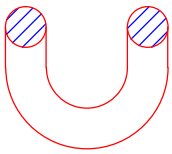
DWG No. PF - R005
SIZE A4
REV



ELEVATION



VIEW ON B



BASE DETAIL
VIEW ON A

LOOP BASE ANCHOR FOR BOLTING
OR MANUAL WELDING

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG NO CORRUGATION

COMMON WIRE SIZES CHOSEN:

A=15-40MM	DIA= 3-5MM
A=25-100MM	DIA= 6MM
A=75-200MM	DIA= 8MM
A=150-300MM	DIA=10MM

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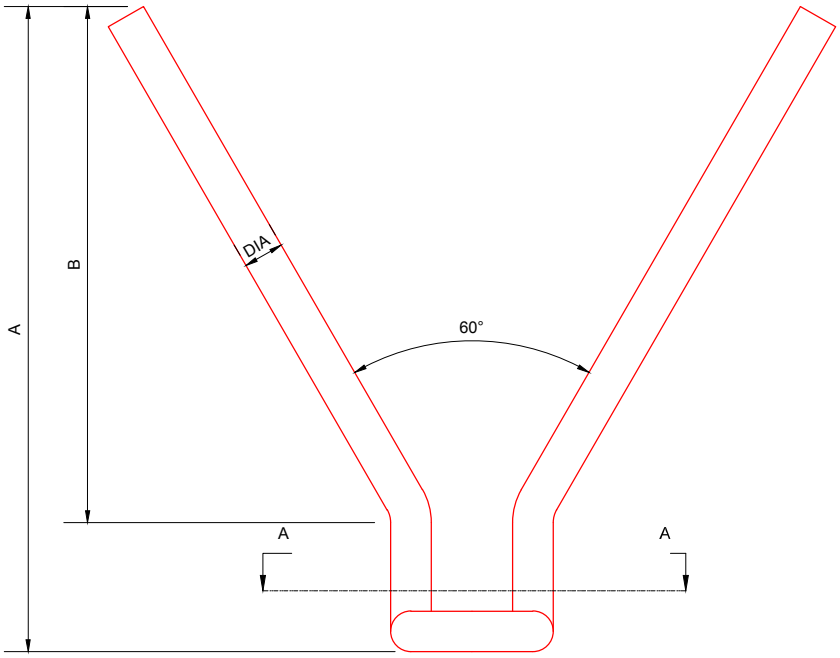
TITLE
PF VWL ANCHOR

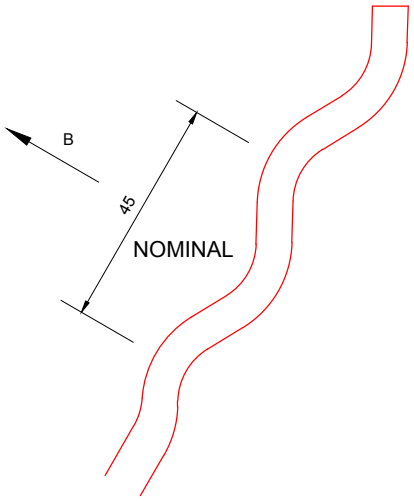
DATE	REVISION	BY

FILE NAME: PF VWL ANCHOR - PF - R006.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

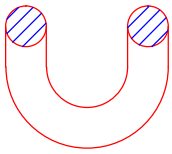
DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S		PF - R006	A4	



ELEVATION



VIEW ON B



BASE DETAIL
VIEW ON A

LOOP BASE ANCHOR FOR BOLTING
OR MANUAL WELDING

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG NO CORRUGATION

TYPICAL WIRE DIAMETERS:

TO PFVS 40	6 OR 8MM
TO PFVS 60	8MM
PFVS 50-80	8 OR 10MM

ANC No	A	B
PFVS-25	70	70
PFVS-35	90	70
PFVS-40	110	90
PFVS-50	130	100
PFVS-60	150	100
PFVS-70	180	100
PFVS-80	200	100

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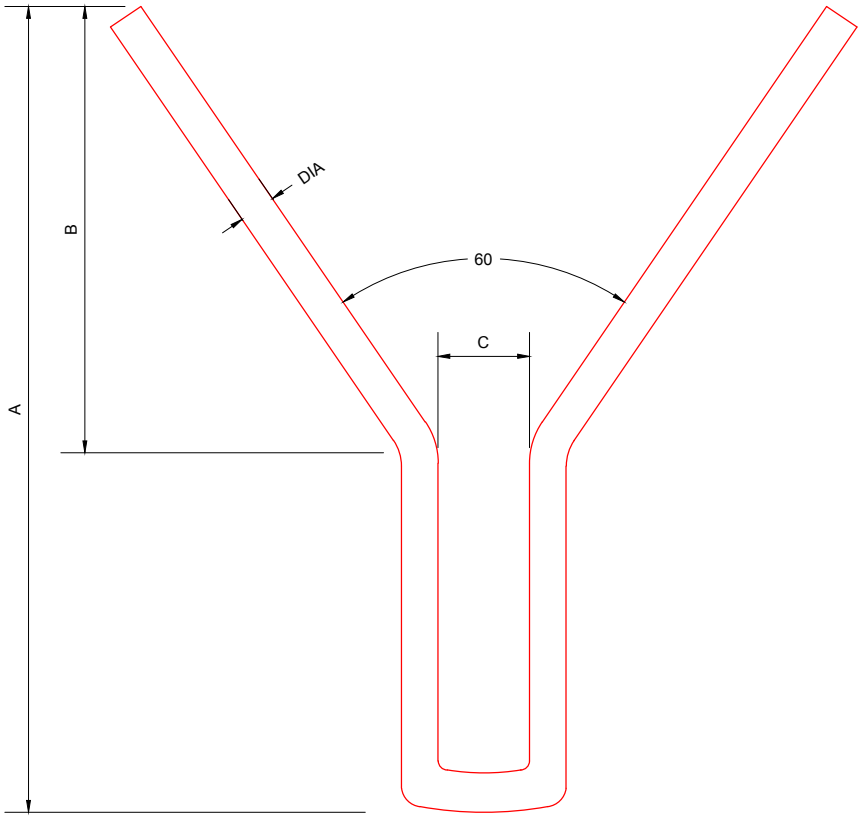
TITLE
PF VSL ANCHOR

DATE	REVISION	BY

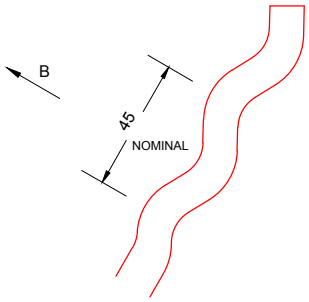
FILE NAME: PF VSL ANCHOR - PF - R007.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

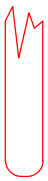
DWG No. PF - R007
SIZE A4
REV



ELEVATION
FLAT BASE MANUAL
WELDING ANCHOR



VIEW ON B



BASE DETAIL

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG NO CORRUGATION

NORMALLY B=100 A=110-300

TYPICAL WIRE SIZES
A=110-175MM 8MM DIA
A=150-300MM 10MM DIA

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TITLE
PF YSWF ANCHOR

DATE	REVISION	BY

FILE NAME: PF YSWF ANCHOR - PF - R008.DWG

MATERIAL: STAINLESS STEEL

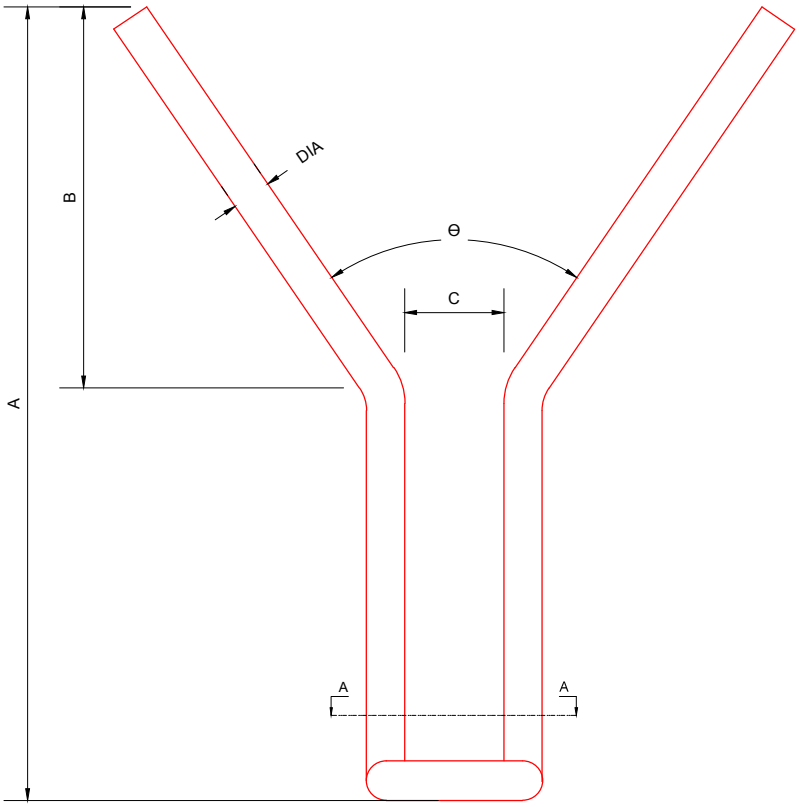
DATE 5.12.11

DRAWN BY	SCALE	PAGE/SHEET
B.MITCHELL	N.T.S	

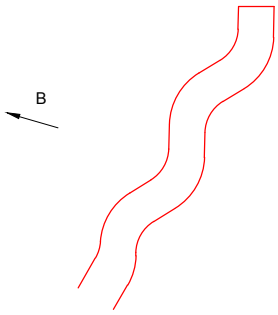
DWG No.
PF - R008

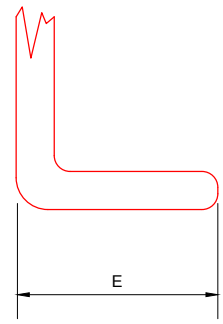
SIZE A4

REV

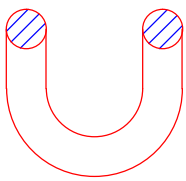


ELEVATION





BASE DETAIL



BASE DETAIL
VIEW ON A

LOOP BASE ANCHOR FOR BOLTING
OR MANUAL WELDING

OPTIONS

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90 DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG, NO CORRUGATION

NORMALLY
A = 110 -300MM
B = 100MM

TYPICAL WIRE SIZES
A = 110MM - 175MM 8MM DIA
A = 150 - 300MM 10MM DIA

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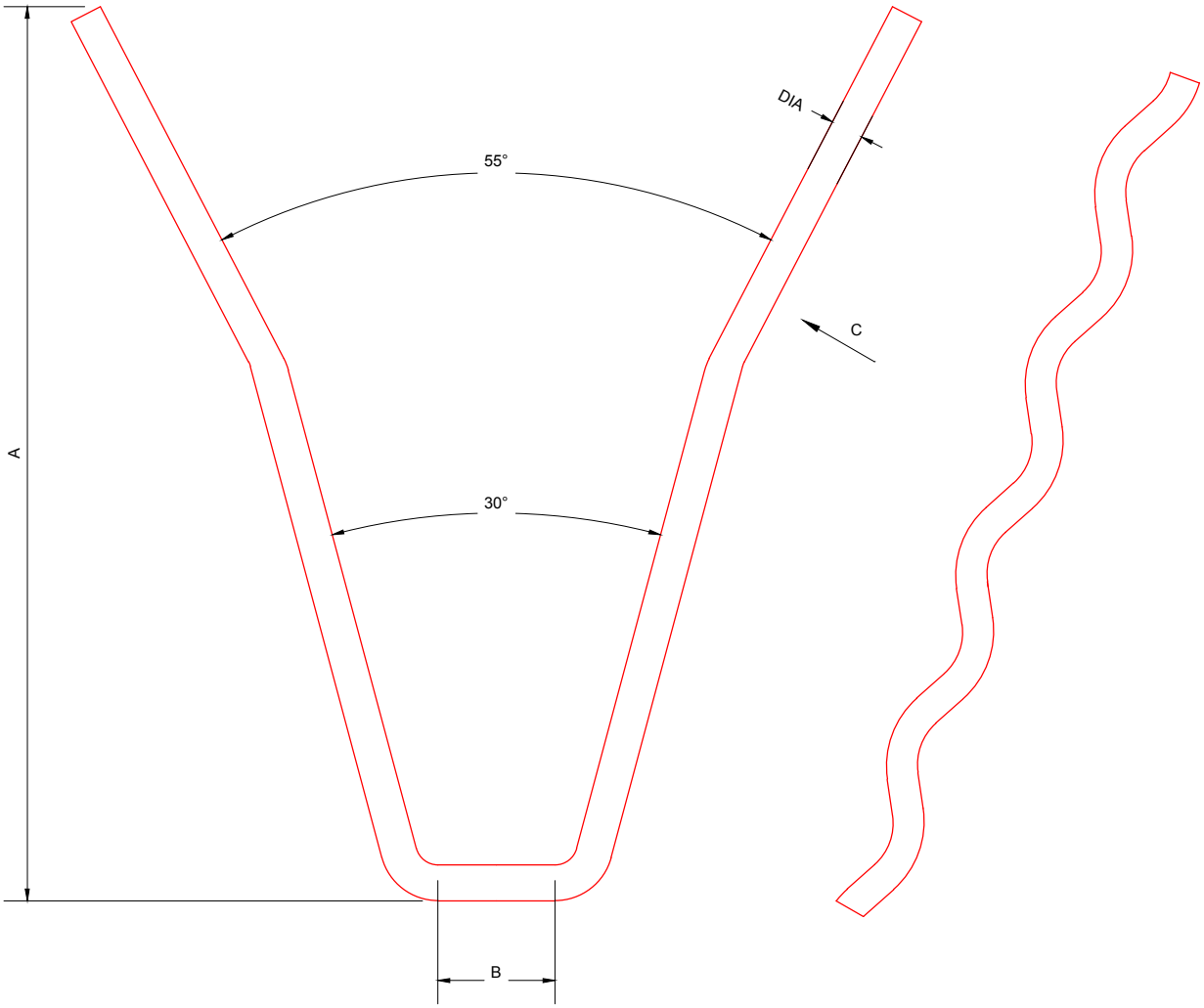
TITLE
PF YSWL ANCHOR

DATE	REVISION	BY

FILE NAME: PF YSWL ANCHOR - PF - R009.DWG
MATERIAL: STAINLESS STEEL
DATE 5.12.11

DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
B.MITCHELL	N.T.S		PF - R009	A4	



ELEVATION VIEW ON C

OPTIONS

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG, NO CORRUGATION

COMMON WIRE SIZES CHOSEN

A=15-40MM	DIA=3-5MM
A=15-100MM	DIA=6MM
A=75-200MM	DIA=8MM
A=150-300MM	DIA=10MM

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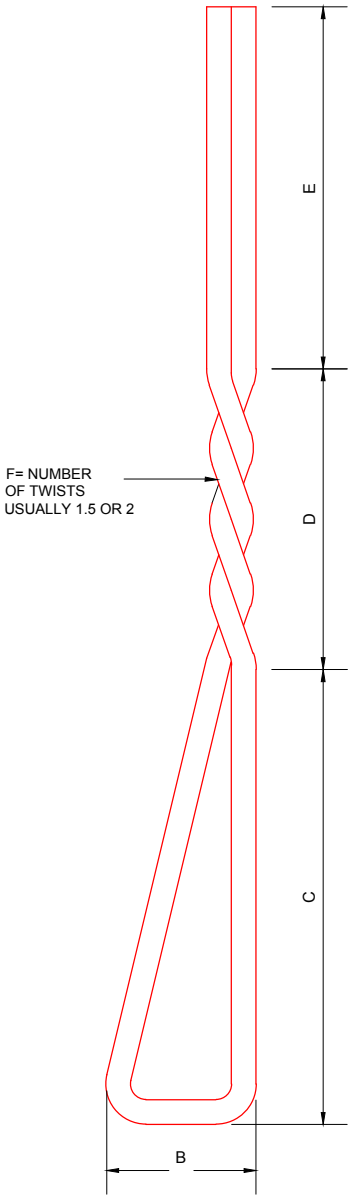
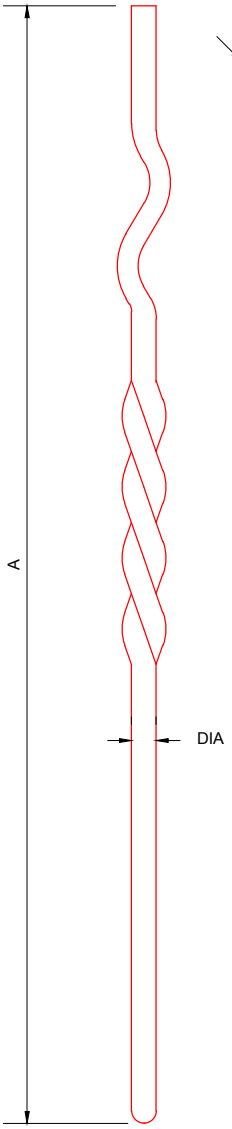
TITLE
PF BULL HORN ANCHOR

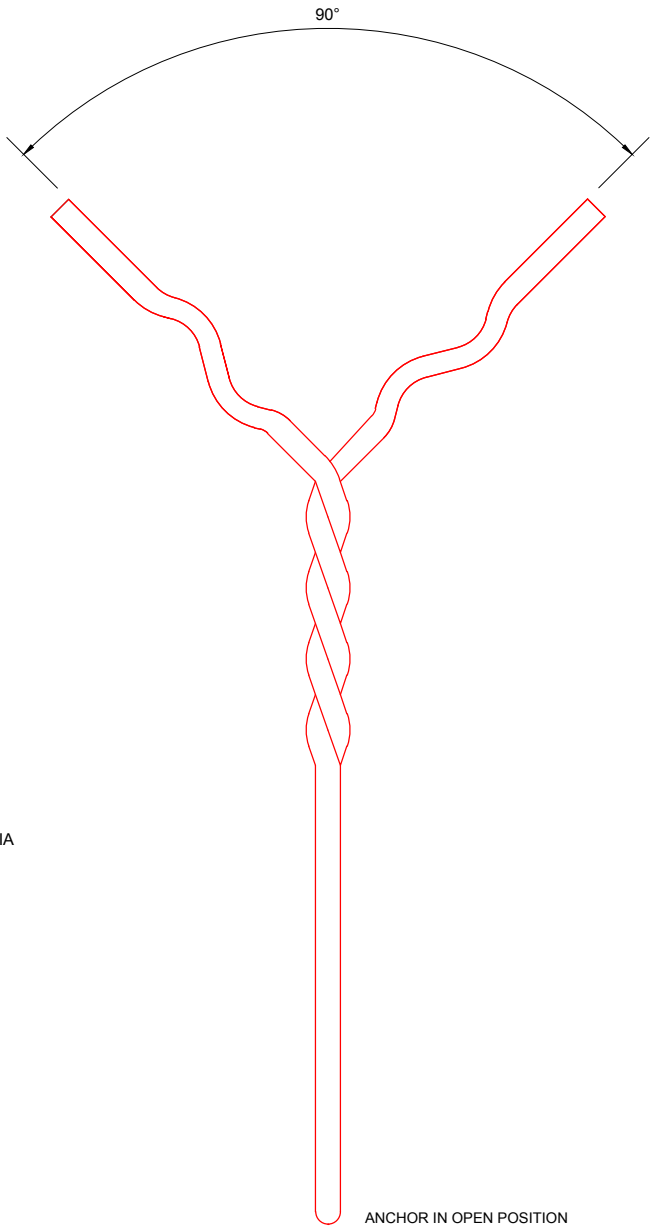
DATE	REVISION	BY

FILE NAME: PF BULL HORN ANCHOR - PF - R010.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S		PF - R010	A4	



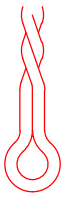




ANCHOR IN OPEN POSITION

IDEAL ANCHOR FOR MULTI-LAYER
CASTABLE AND WHERE WELDING WINGS
OR LEGS ONTO THE STEM IS NOT PREFERRED

CAN BE SUPPLIED CLOSED
COMMON DIAMETER USED IS 7.5 TO 8MM
MINIMUM HEIGHT FOR C=100MM
WITH EXISTING TOOLING



OPTIONS:

LEG HEIGHT CAN BE STAGGERED
NO CORRUGATION IN LEGS
LOOP BASE FOR BOLTING APPLICATIONS

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TITLE
PF TWIST ANCHOR

DATE	REVISION	BY

FILE NAME: PF TWIST ANCHOR - PF - R011.DWG

MATERIAL: STAINLESS STEEL

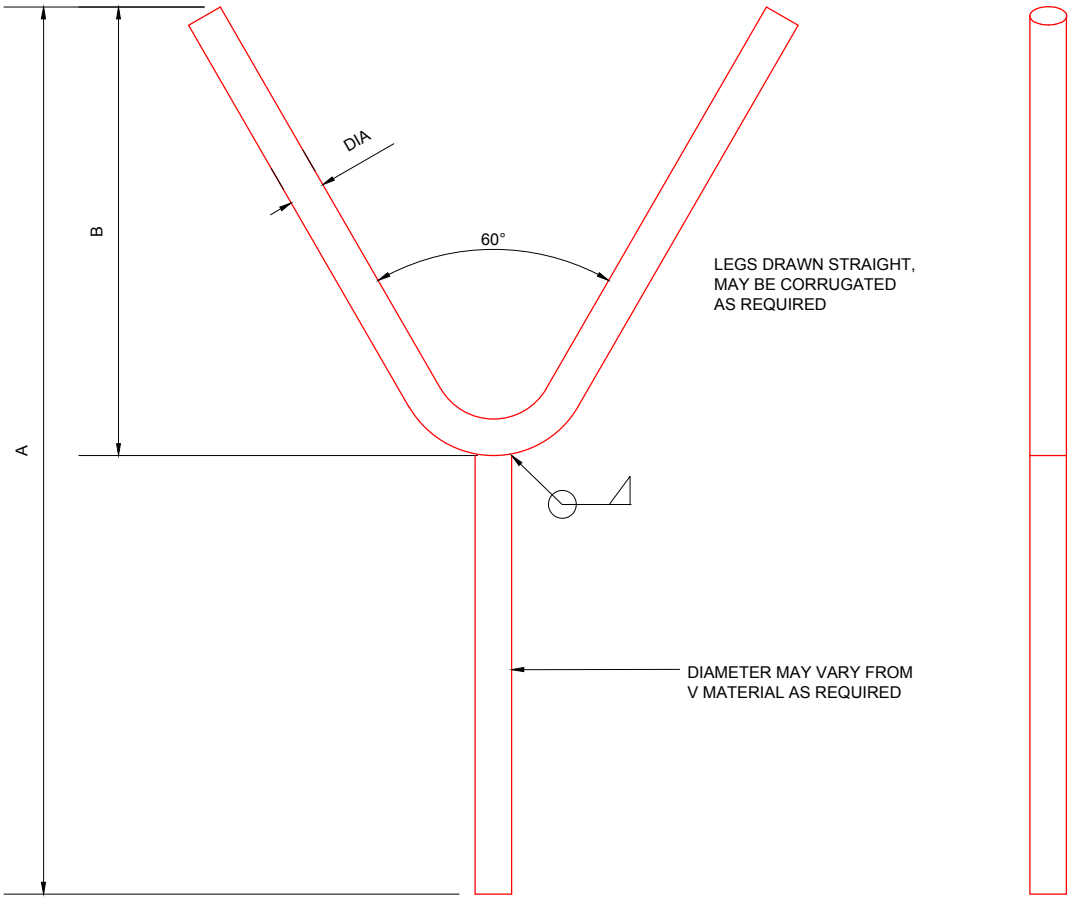
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

DWG No.
PF - R011

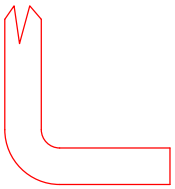
SIZE A4

REV



ELEVATION

ELEVATION



L BASE SOMETIMES PREFERRED
FOR HIGHER STRENGTH WELD
ATTACHMENT

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG NO CORRUGATION

COMMON WIRE SIZES CHOSEN

A=75-200MM	DIA= 8MM
A=150-300MM	DIA= 10MM

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TITLE
PF Y ANCHOR

DATE	REVISION	BY

FILE NAME: PF Y ANCHOR - PF - R012.DWG

MATERIAL: STAINLESS STEEL

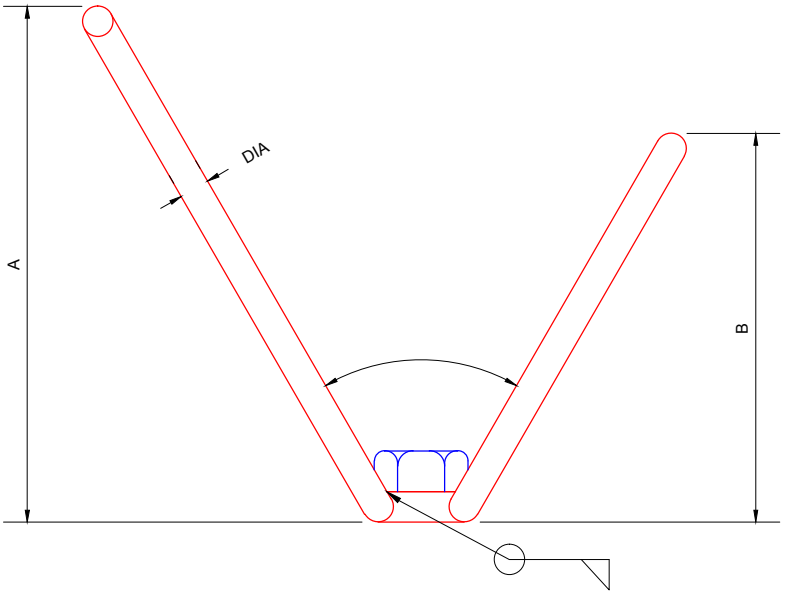
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

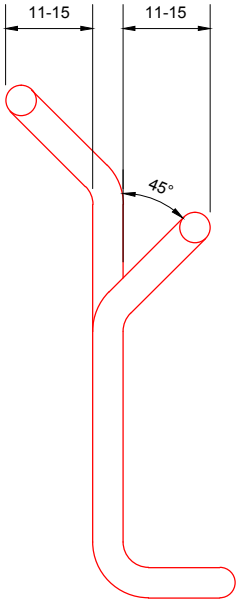
DWG No.
PF - R012

SIZE A4

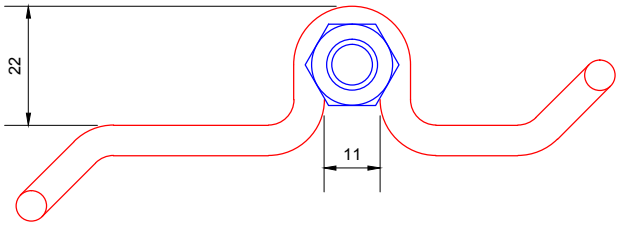
REV



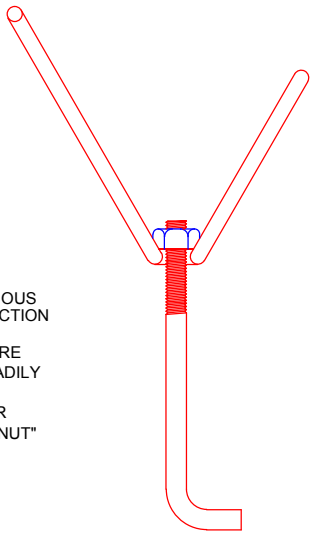
ELEVATION
LOOP BASE ANCHOR
FOR BOLTING OR WELDING



ELEVATION



PLAN



OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG NO CORRUGATION

COMMON WIRE SIZES CHOSEN:

A=15-40MM	DIA= 3-5MM
A=15-100MM	DIA= 6MM
A=75-200MM	DIA= 8MM
A=150-300MM	DIA=10MM

CAN BE COMBINED WITH VARIOUS STUD DESIGNS, SEE STUD SECTION

IN THE CASE OF ALLOYS WHERE HEXAGON NUTS ARE NOT READILY AVAILABLE E.G. 310, 253MA, INCONEL, INCOLOY ROUND OR SQUARE DRILLED & TAPPED "NUT" MAY BE SUBSTITUTED

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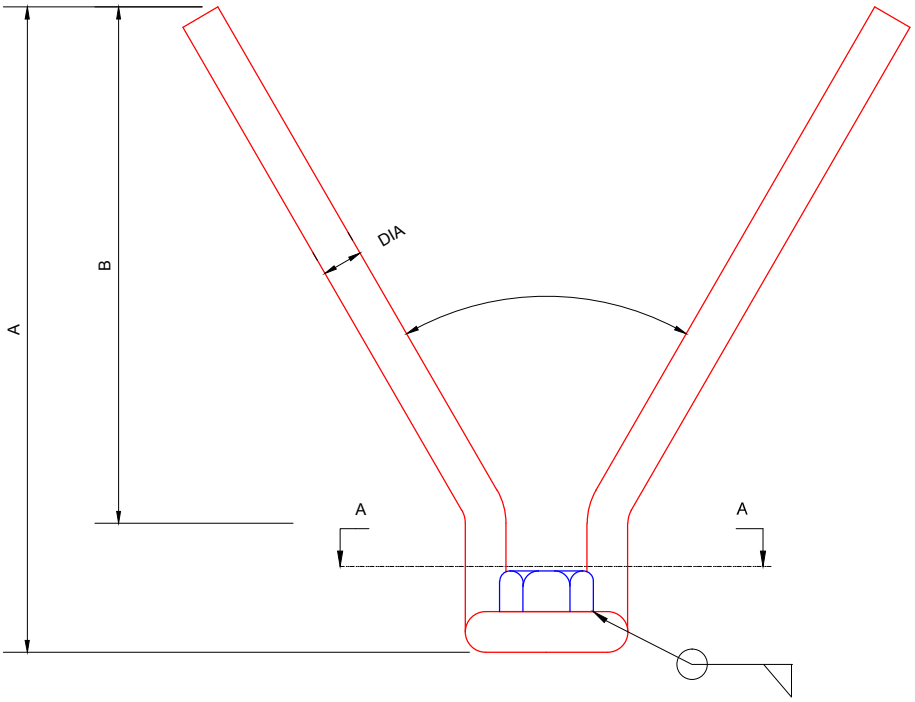
TITLE
PF - WB HEXNUT ANCHOR

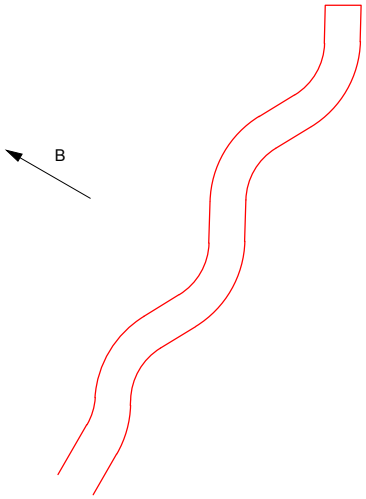
DATE	REVISION	BY

FILE NAME: PF - WB HEXNUT ANCJOR - PF - R013.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

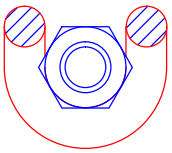
DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S		PF - R013	A4	



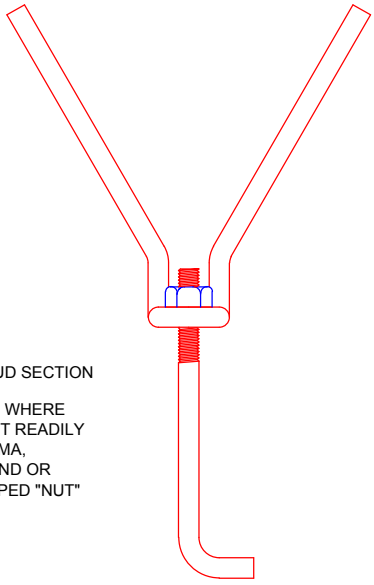
ELEVATION



VIEW ON B



BASE DETAIL
VIEW ON A



OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG NO CORRUGATION

COMMON WIRE SIZES CHOSEN:

A=15-40MM	DIA= 3-5MM
A=25-100MM	DIA= 6MM
A=75-200MM	DIA= 8MM
A=150-300MM	DIA=10MM

STUD DESIGNS, SEE STUD SECTION

IN THE CASE OF ALLOYS WHERE HEXAGON NUTS ARE NOT READILY AVAILABLE E.G. 310, 253MA, INCONEL, INCOLOY ROUND OR SQUARE DRILLED & TAPPED "NUT" MAY BE SUBSTITUTED

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TITLE
PF VS - HEXNUT ANCHOR

DATE	REVISION	BY

FILE NAME: PF VS - HEXNUT ANCHOR - PF - R014.DWG

MATERIAL: STAINLESS STEEL

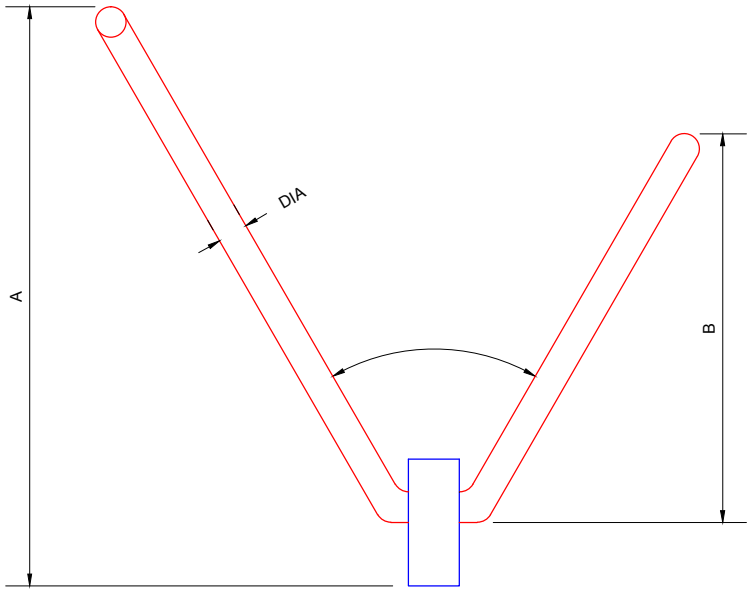
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

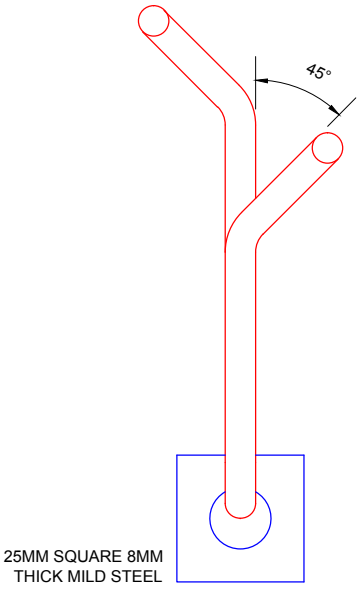
DWG No. PF - R014

SIZE A4

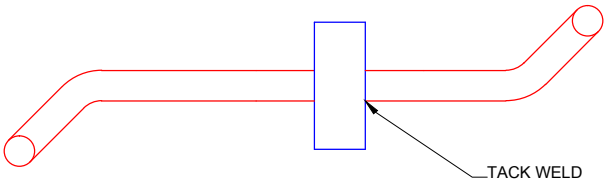
REV



ELEVATION



ELEVATION



PLAN

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG, NO CORRUGATION

COMMON WIRE SIZES CHOSEN

A=15-40MM	DIA=3-5MM
A=15-100MM	DIA=6MM
A=75-200MM	DIA=8MM
A=150-300MM	DIA=10MM

TYPE	ANCHOR	A
PFWN 22	PFWO 22	63
PFWN 32	PFWO 32	88
PFWN 43	PFWO 43	112
PFWN 54	PFWO 54	138
PFWN 65	PFWO 65	162
PFWN 76	PFWO 76	190
PFWN 87	PFWO 87	215
PFWN 98	PFWO 98	242
PFWN 109	PFWN 109	267

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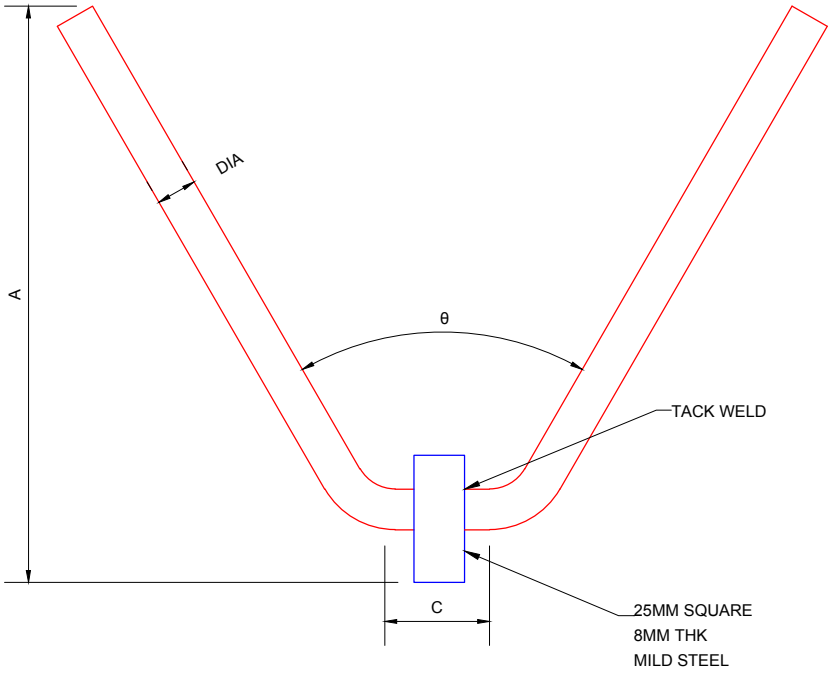
TITLE
PF WN ANCHOR

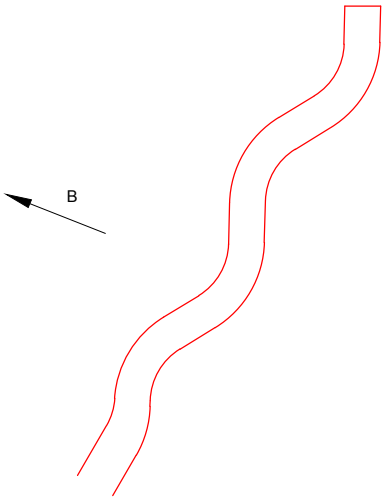
DATE	REVISION	BY

FILE NAME: PF WN ANCHOR - PF - R015.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S		PF - R015	A4	



ELEVATION



VIEW ON B

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG, NO CORRUGATION

COMMON WIRE SIZES CHOSEN

A=15-40MM	DIA=3-5MM
A=15-100MM	DIA=6MM
A=75-200MM	DIA=8MM
A=150-300MM	DIA=10MM

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TITLE
PF VWFN ANCHOR

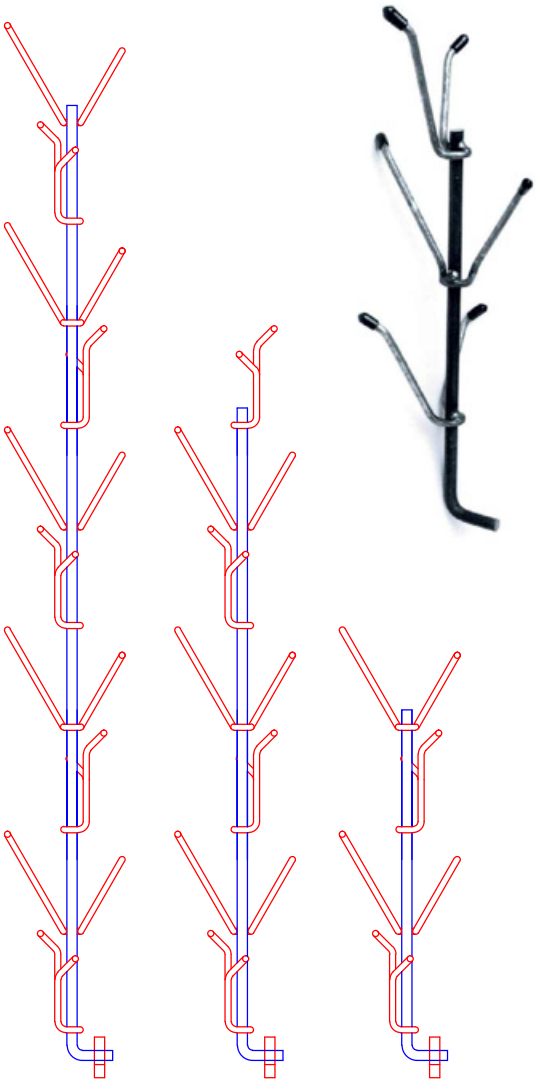
DATE	REVISION	BY

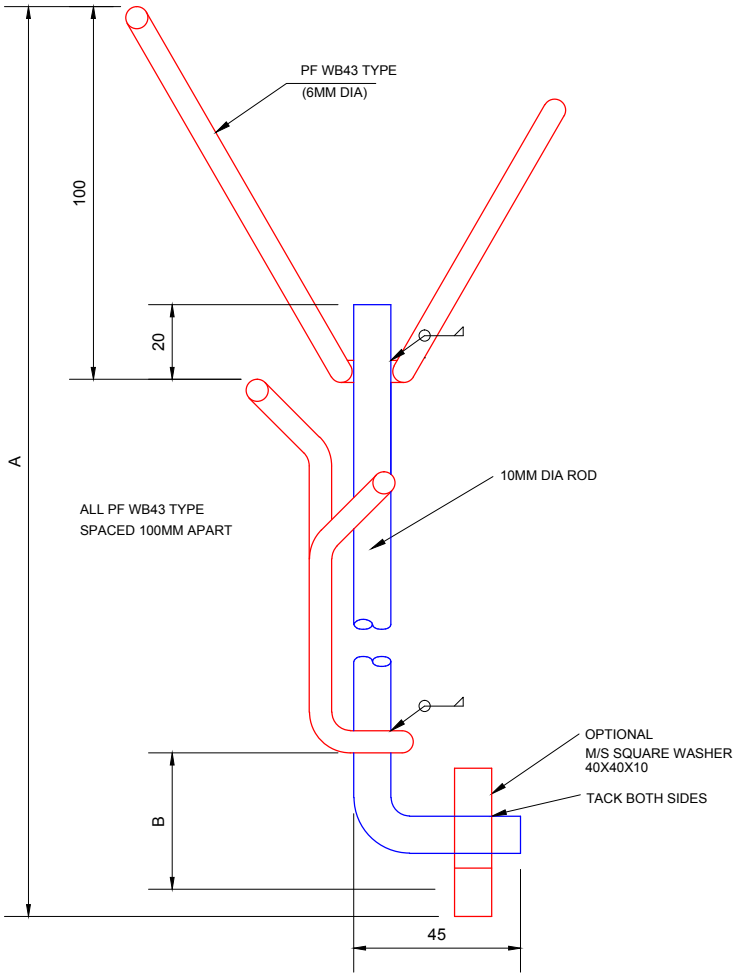
FILE NAME: PF VWFN ANCHOR - PF - R016.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

DWG No.
PF - R016

SIZE N.T.S | REV





NOTE: EACH PF WB43 TYPE ANCHOR
ROTATED 90 DEG ON STEM

COMMONLY KNOWN AS "CHRISTMAS TREE"
ANCHOR FOR DEEP DAMS

ANC No	A	B	WB-43'S
PF-WNL9	230	30	2
PF-WNL10	250	50	2
PF-WNL11	275	75	2
PF-WNL12	300	100	2
PF-WNL13	330	30	3
PF-WNL14	355	55	3
PF-WNL15	380	80	3
PF-WNL16	400	100	3
PF-WNL17	430	30	4
PF-WNL18	455	55	4
PF-WNL19	480	80	4
PF-WNL20	510	110	4
PF-WNL21	530	130	4

ANC No	A	B	WB43'S
PF-WNL22	560	60	5
PF-WNL23	585	85	5
PF-WNL24	610	110	5
PF-WNL25	635	135	5
PF-WNL26	660	60	6
PF-WNL27	685	85	6
PF-WNL28	710	110	6
PF-WNL29	735	135	6
PF-WNL30	760	60	7
PF-WNL31	785	85	7
PF-WNL32	810	110	7
PF-WNL33	835	135	7

ANC No	A	B	WB43'S
PF-WNL34	860	60	8
PF-WNL35	885	85	8
PF-WNL36	915	115	8
PF-WNL37	940	140	8
PF-WNL38	965	65	9
PF-WNL39	990	90	9
PF-WNL40	1015	115	9
PF-WNL41	1040	140	9
PF-WNL42	1065	65	10
PF-WNL43	1090	90	10
PF-WNL44	1115	115	10
PF-WNL45	1140	140	10

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TITLE
PF WNL ANCHOR

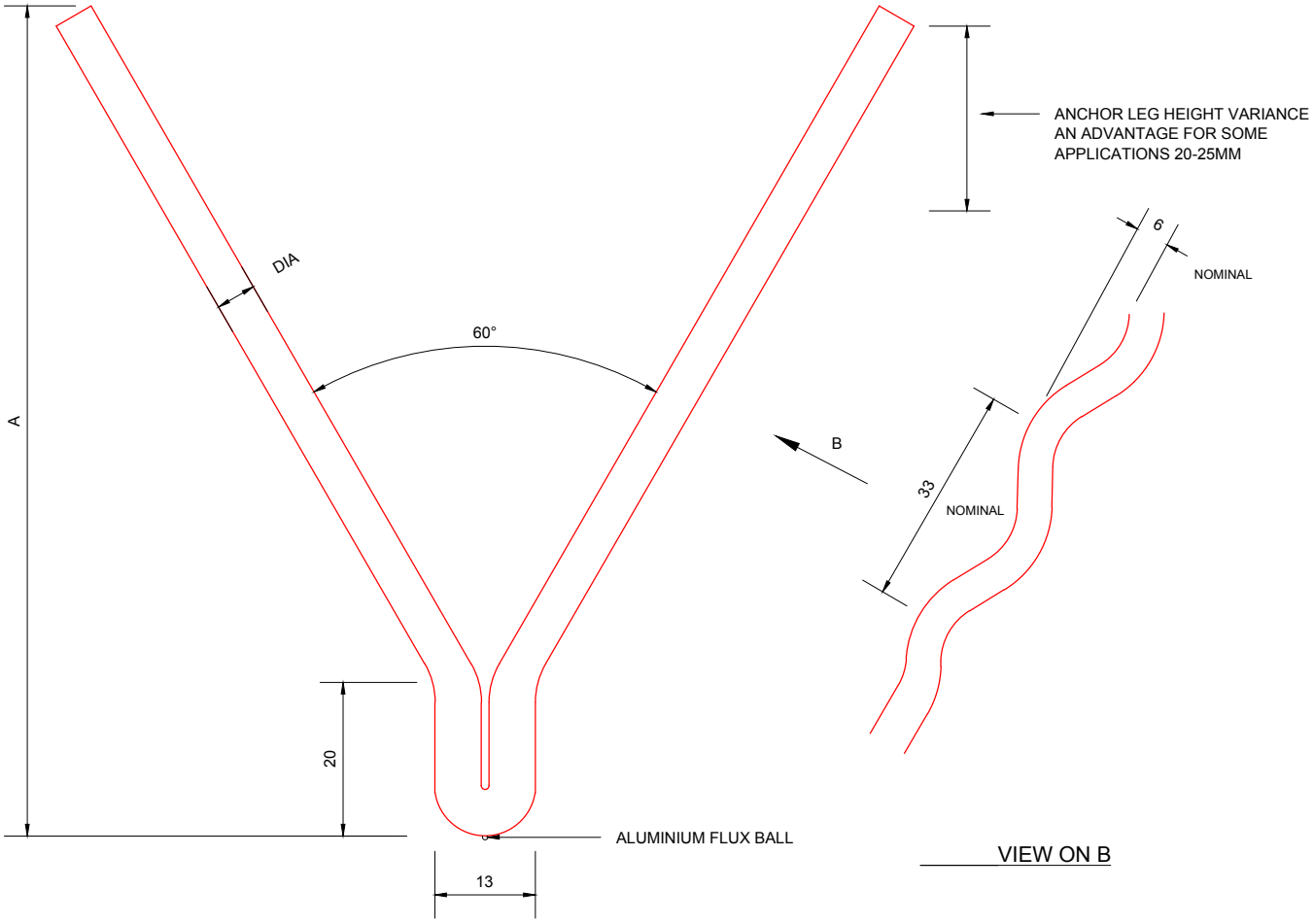
DATE	REVISION	BY

FILE NAME: PF WNL ANCHOR - PF - R017.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

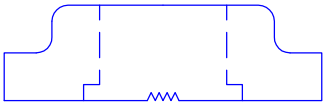
DWG No. PF - R017
SIZE A4
REV

VERSION NO. 05.2024



ELEVATION

N.B: REF FLUX BALL
SOME ADVISERS INDICATE
ONLY NECESSARY FOR WIRE
DIAMETER GREATER THAN 8MM



CERAMIC STUD WELDING FERRULE

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG, NO CORRUGATION

COMMON WIRE SIZES CHOSEN

A=15-40MM	DIA=3-5MM
A=15-100MM	DIA=6MM
A=75-200MM	DIA=8MM
A=150-300MM	DIA=10MM

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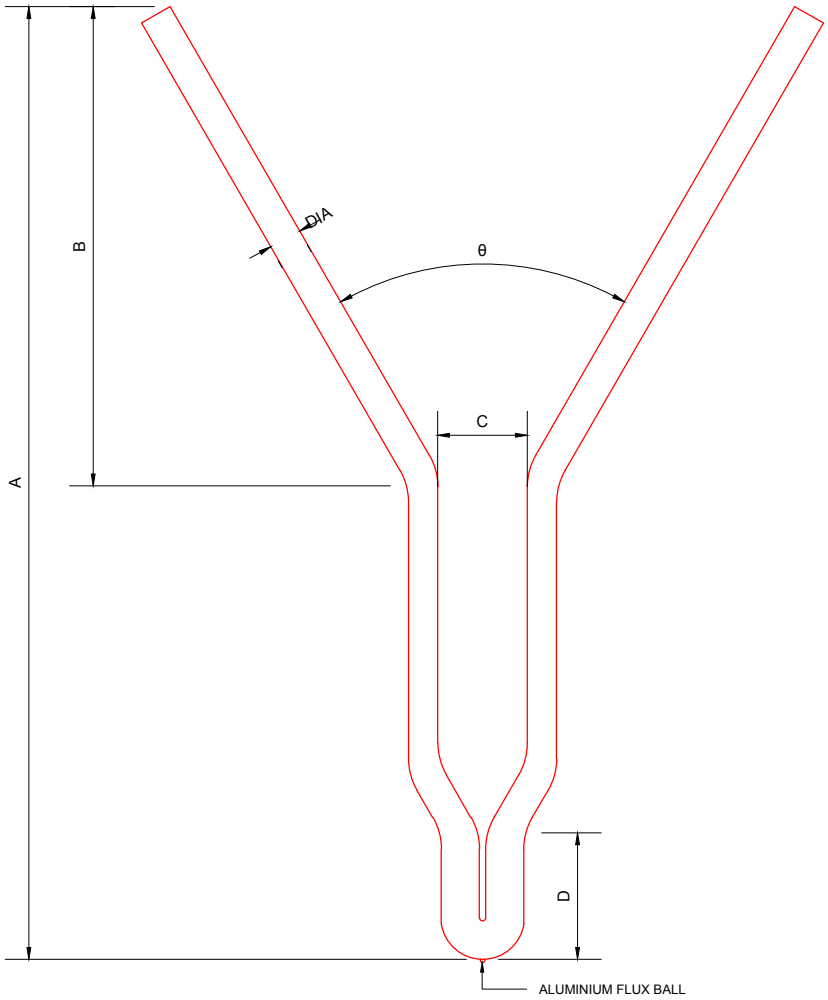
TITLE
PF HRC STUD WELD ANCHOR

DATE	REVISION	BY

FILE NAME: PF HRC STUD WELD ANCHOR - PF - R018.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

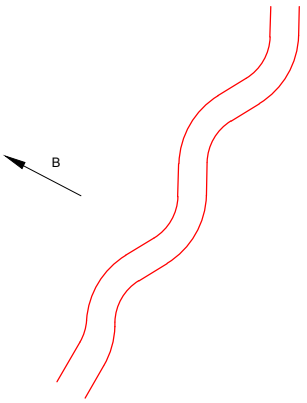
DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

DWG No. PF - R018
SIZE A4
REV

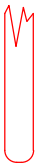


ELEVATION

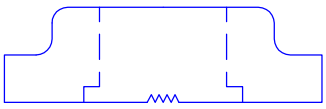
N.B: REF FLUX BALL
SOME ADVISERS INDICATE
ONLY NECESSARY FOR WIRE
DIAMETER GREATER THAN 8MM



VIEW ON B



BASE DETAIL



CERAMIC STUD WELDING FERRULE

OPTIONS:

STAGGER LEG HEIGHT
VARY ANGLE USUALLY 60DEG SOMETIMES 90DEG
VARY CORRUGATION DEPTH/PITCH
EXTEND OR CONTRACT BASE
STRAIGHT LEG, NO CORRUGATION

COMMON WIRE SIZES CHOSEN

A=15-40MM	DIA=3-5MM
A=15-100MM	DIA=6MM
A=75-200MM	DIA=8MM
A=150-300MM	DIA=10MM

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TITLE
PF YWS STUD WELD ANCHOR

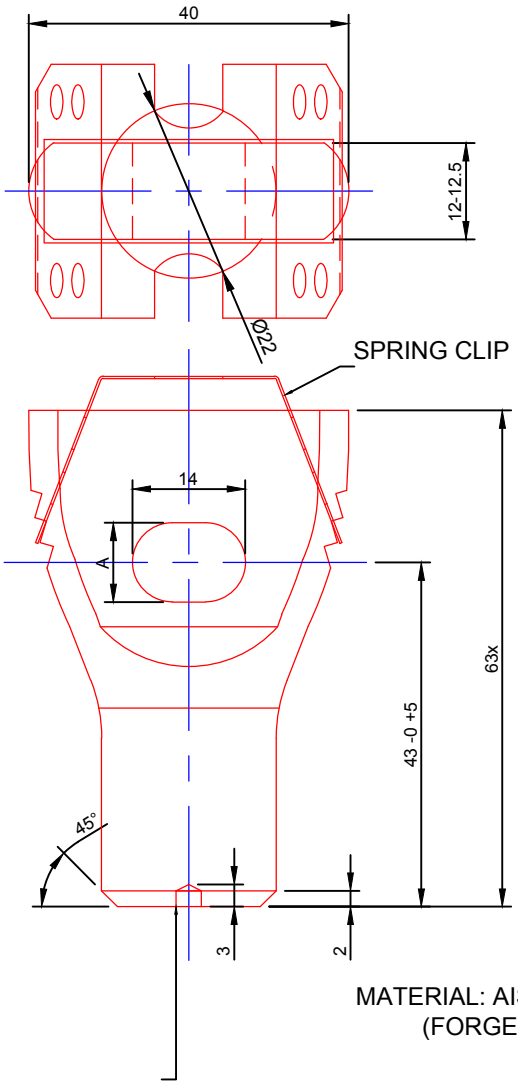
DATE	REVISION	BY

FILE NAME: PF YWS STUD WELD ANCHOR - PF - R019.DWG

MATERIAL: STAINLESS STEEL

DATE 30.1.12

DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
B.MITCHELL	N.T.S		PF - R019	A4	



x **OVERALL LENGTH OF MACHINED BLANK = 125mm**

A=8.1 TO SUIT 8MM WIRE
(PF-SWRLB-43-8)

A=10.1 TO SUIT 10MM WIRE
(PF-SWRLB-43-10)

STUD MANUFACTURE AND INSTALLATION TO CONFORM TO AS/NZ 1554.2:2003

AUSTRALIAN STANDARD
PATENT NO. 2006225331

MATERIAL: AISI C1020
(FORGED HEAD)

INSERT ALUMINIUM
FLUX BALL GRADE 1100 4.75DIA

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TITLE
PF STUD WELDABLE LUG

DATE	REVISION	BY
17.09.10	DETAILS OF FLUX BALL ADDED & LENGTH ALTERED	DB
21.09.11	LENGTH ALTERED TO 63MM O/A	DB
4.10.11	BLANK LENGTH NOTATION ADDED	DB

FILE NAME: LUG 8.7.2008.DWG
MATERIAL: STEEL
DATE 28.03.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S.	

DWG No.
PF - SWRLB - 43 - 8/10 RODLOK LUG

SIZE A4 REV

PATENTED

SPRING LOCKING CLIP

FOR THE ROD LOK REFRACTORY ANCHOR

Pressform has extensive experience in the design and manufacture of Refractory Hardware and is a leader in the field. We understand that providing anchor stability during the refractory concreting process is paramount to a fast, safe, successful and therefore cost effective refractory installation. Our patented Spring Locking Clip design ensures anchor arms will always be vertical, avoiding weakened refractory cement support and hot spots.

DESIGN FEATURES

Manufactured from thin spring steel, so that when it reaches service temperature the spring temper dissipates and the anchor arms can move with expansion as intended.

- Serrations on the side of lug provide adjustment for the clip
- Length of the lug can be variable allowing use of cross arm inserts
- Note the holes in the clip enable refractory cement ingress
- The round base of stud weldable lug lends itself to manual welding as well as stud welding
- Lugs can be flat if directional strength is not an issue
- Round lugs have the same strength in all directions
- Anchor wires can have a parallel section similar to PFVS anchors for thicker refractory anchoring

COST

The spring steel clip and serration of the lug - $2.00

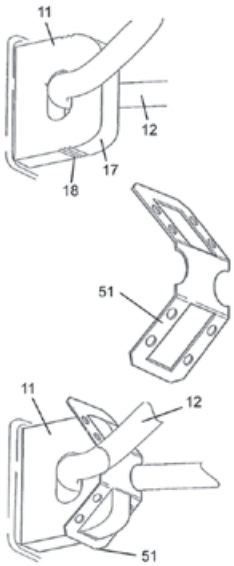
Or receive a reduced price with any order of new anchors and lugs.

Ask us how you can install your anchors safely, securely and 10 times faster with the revolutionary Pressform Stud Welding System.

HOW IT WORKS

These illustrations show how the arms of a Rod Lock Anchor can be locked in the upright position as a fail safe.

11. Steel or stainless steel slotted base
12. 8mm or 10mm diameter wire anchor arm
17. Rounded top edge
18. Clip engaging slots
51. Spring steel locking clip



ALSO AVAILABLE: THE STUD WELDABLE LUG

Carbon Steel
Stainless Steel
Nickel Alloys

ORDER NOW

To order, or to discuss your requirements, contact Pressform Engineering
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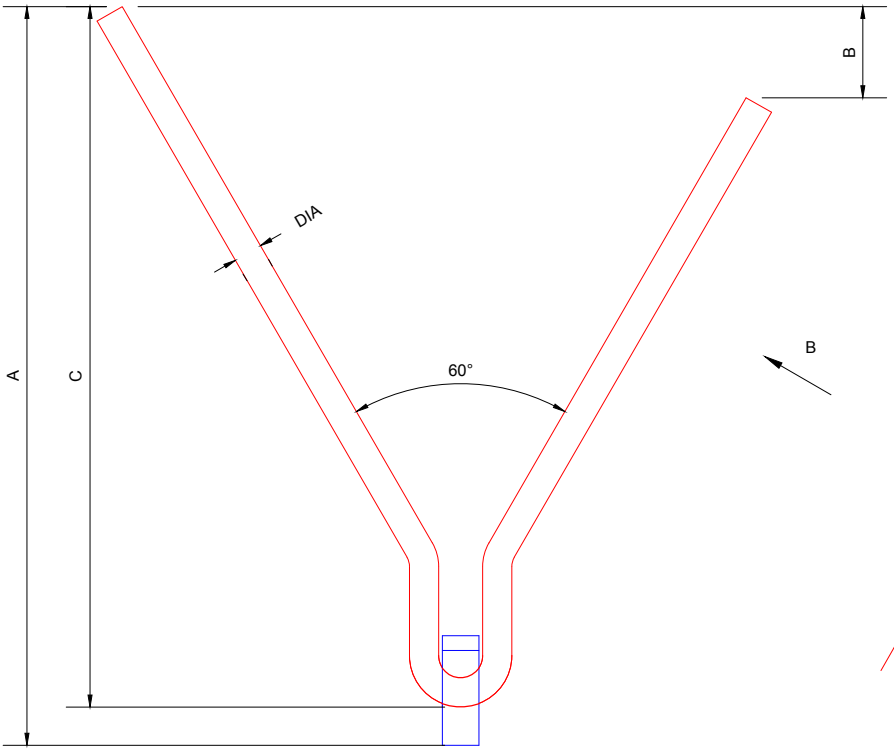
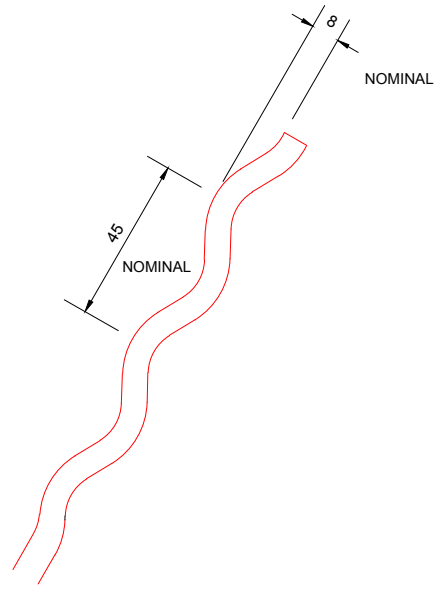
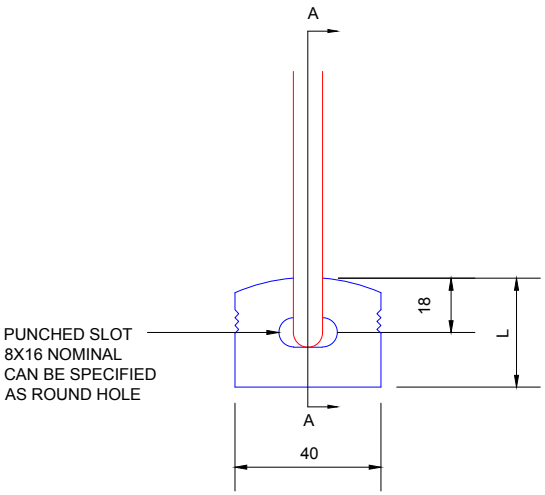
www.pressform.com.au



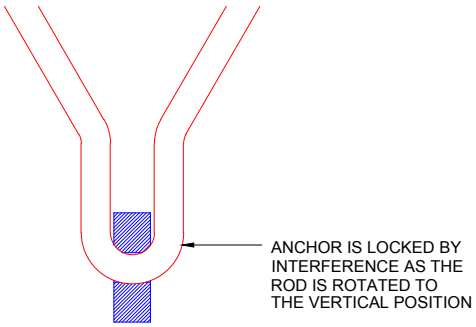
ELEVATION



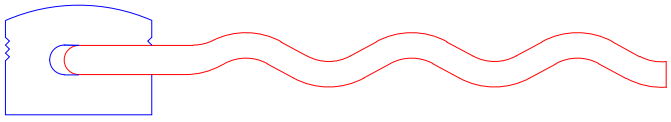
VIEW ON B



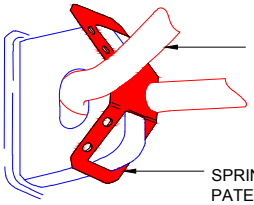
LUG LOCKING DETAIL



SECTION A



CONCEPTUAL VIEW ANCHOR AFTER ASSEMBLY IN HORIZONTAL POSITION
BEFORE LOCKING UPRIGHT FOR CONCRETE POUR



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TITLE
PF ROD LOK ANCHOR

DATE	REVISION	BY

FILE NAME: PF ROD LOK ANCHOR - PF - R020.DWG

MATERIAL: STAINLESS STEEL

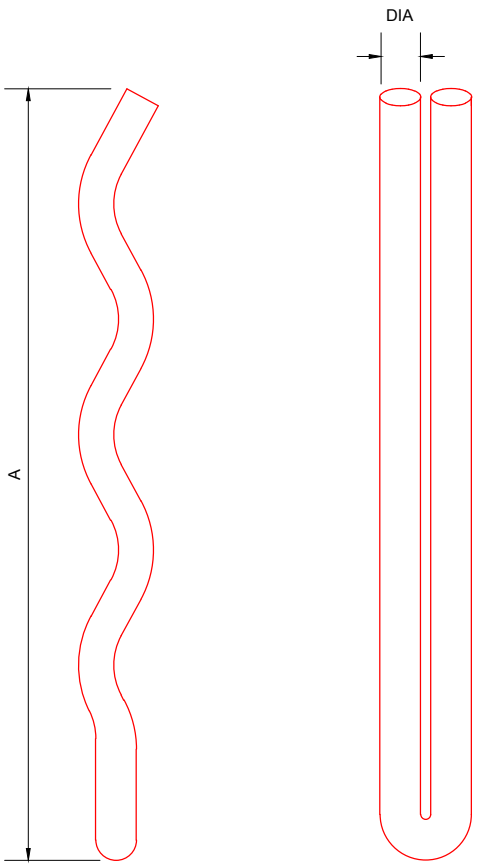
DATE 31.3.11

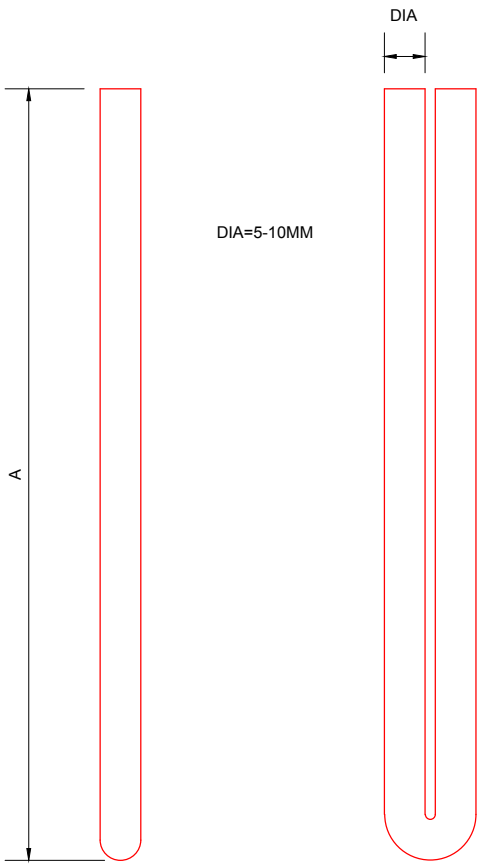
DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

DWG No.
PF - R020

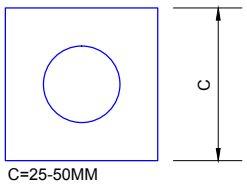
SIZE A4

REV

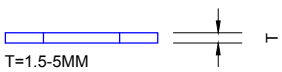




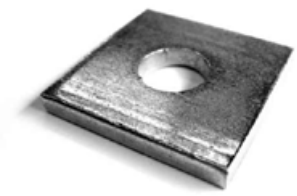
BASE CAN BE STUD WELDED.
IN THE CASE OF WIRE DIAMETERS
ABOVE 6MM A FLUX BALL IS REQUIRED
AN APPROPRIATE WELDING FERRULE
IS REQUIRED IN BOTH CASES

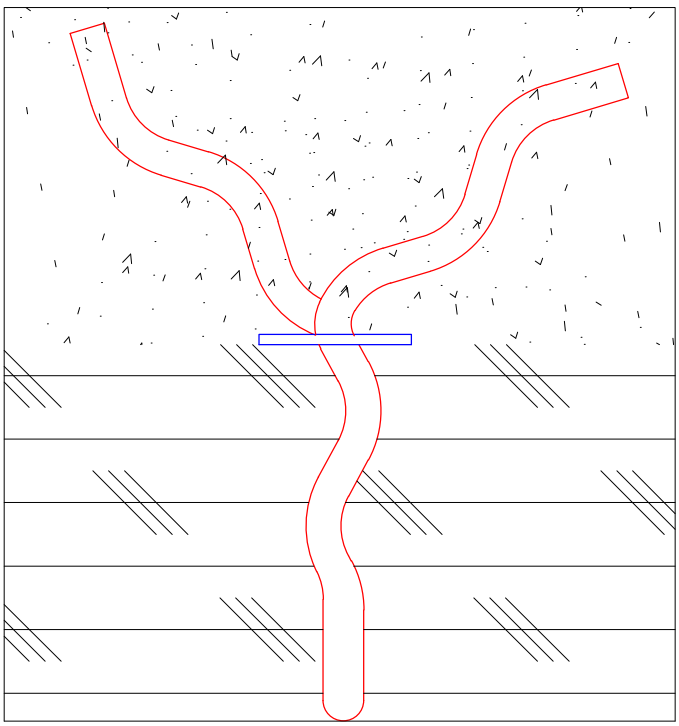


C=25-50MM



T=1.5-5MM





LEGS MAY BE OPENED
OUT AFTER FIRST LAYER

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TITLE
PF CLOSE PARALLEL LEG

DATE	REVISION	BY

FILE NAME: PF CLOSE PARALLEL LEG - PF - R021.DWG

MATERIAL: STAINLESS STEEL

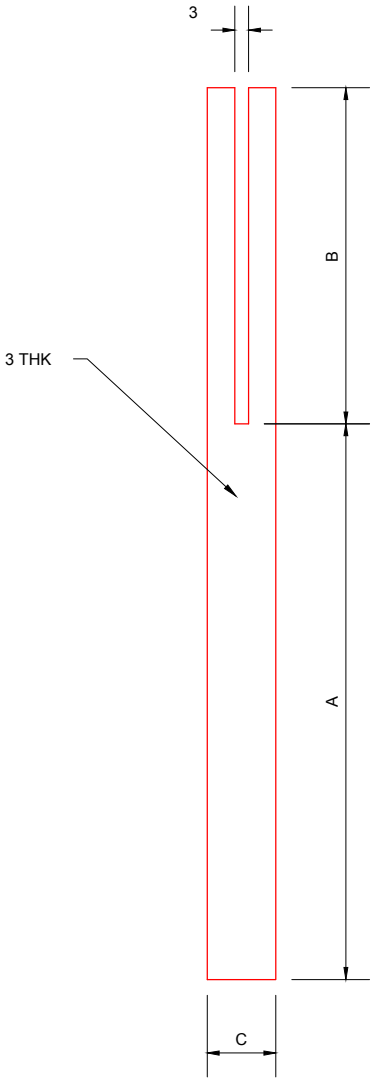
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

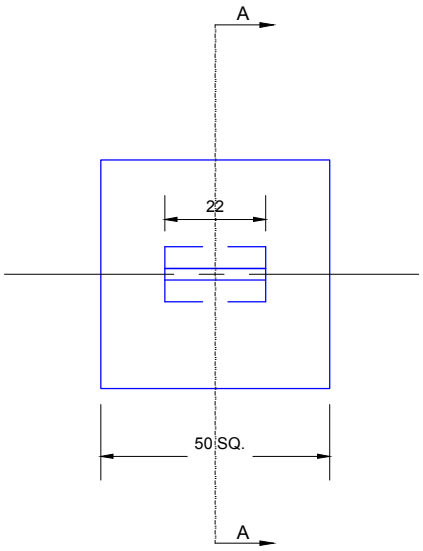
DWG No.
PF - R021

SIZE A4

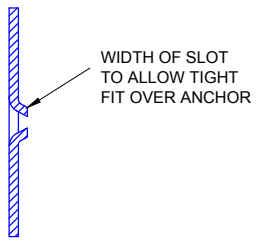
REV



SPLIT FLAT BAR Y-ANCHOR



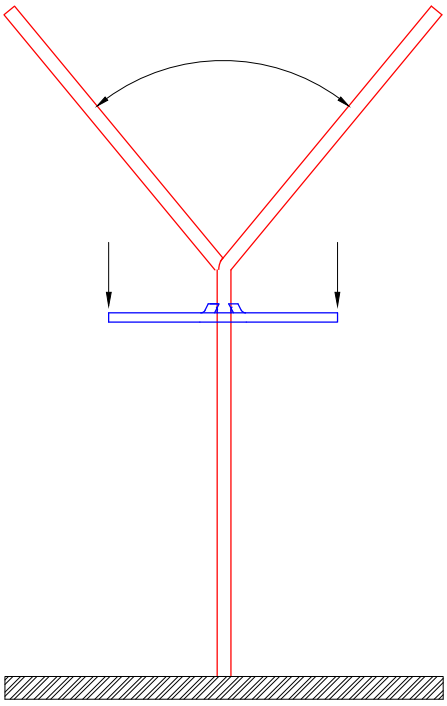
SPEED WASHER



SECTION A

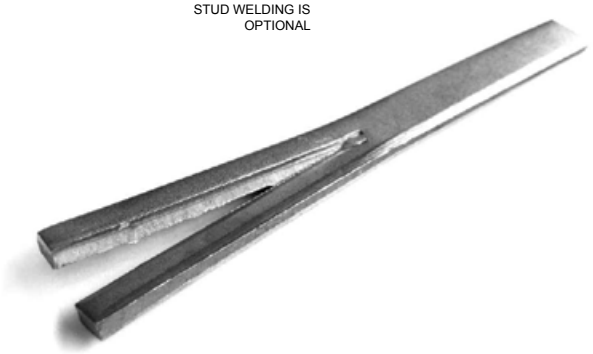
BASE DETAIL

CURVED BASE FOR STUD WELDING IS OPTIONAL



ASSEMBLY DRAWING

SPEED WASHER IS PRESSED OVER THE SPLIT ANCHOR TO HOLD REFRACTORY IN PLACE. HOLD REFRACTORY IN PLACE. UP TO THE DESIRED ANGLE



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TITLE
PF SPLIT FLAT BAR Y-ANCHOR

DATE	REVISION	BY

FILE NAME: PF SPLIT FLATE BAR Y - ANCHOR - PFM- R022.DWG

MATERIAL: STAINLESS STEEL

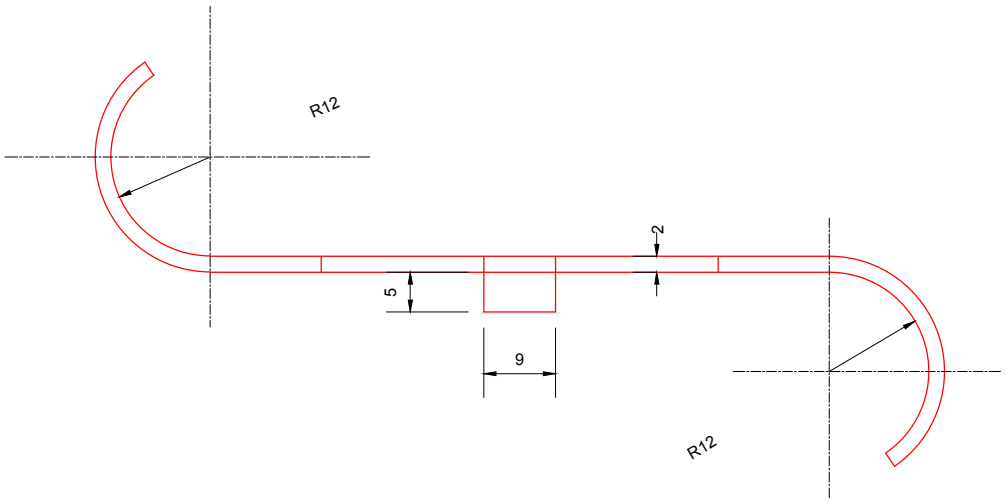
DATE 31.3.11

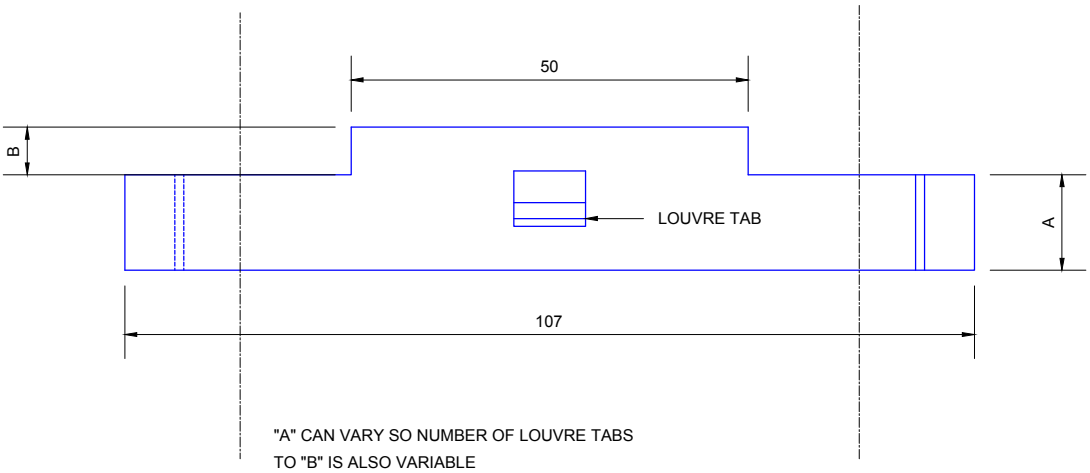
DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S.	

DWG No. PF - R022

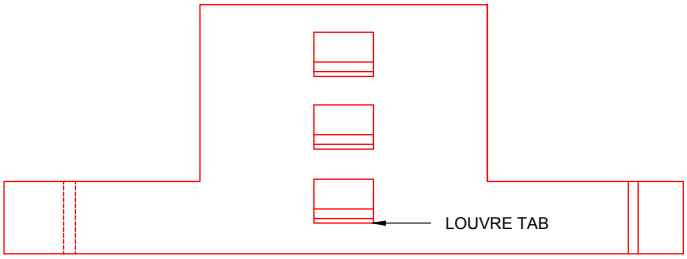
SIZE A4

REV





"A" CAN VARY SO NUMBER OF LOUVRE TABS
TO "B" IS ALSO VARIABLE



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TITLE
PF - S-SHAPE ANCHOR

DATE	REVISION	BY

FILE NAME: PF - S SHAPE ANCHOR - PF - R023.DWG

MATERIAL: STAINLESS STEEL

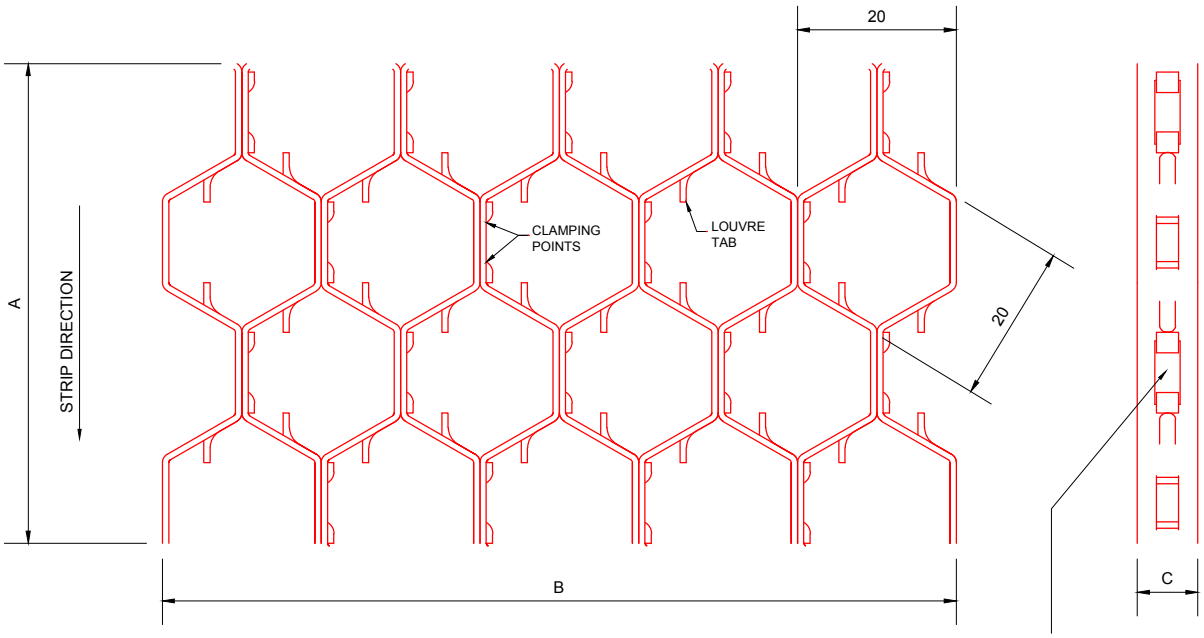
DATE 31.03.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S.	

DWG No.
PF - R023

SIZE A4

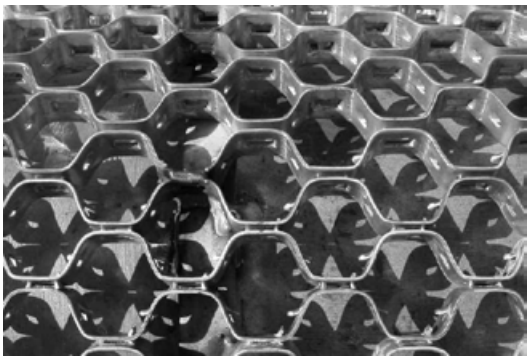
REV



PLEASE NOMINATE DIMENSIONS USING STRIP DIRECTION TO ENSURE APPROPRIATE ORIENTATION TO GAS FLOW ON INSTALLATION

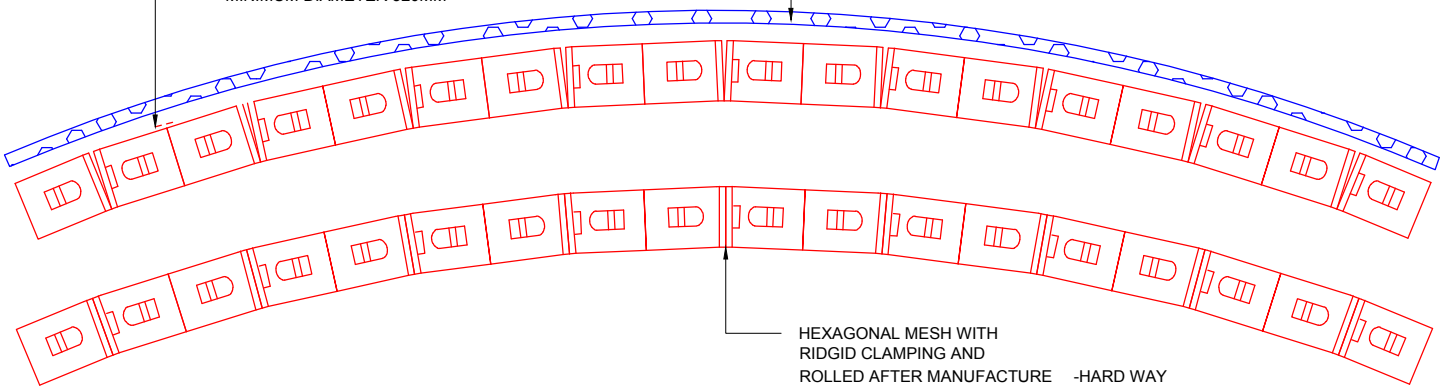
FOR CLAMPING METHOD SEE TECHNICAL NOTES LOUVRE TABS CAN BE LEFT OUT ON REQUEST STRIP THICKNESS 1.5-2.0MM

CLAMPING BACK LEAVES ORIFICE FOR REFRACTORY BONDING BETWEEN HEXAGONAL CELLS



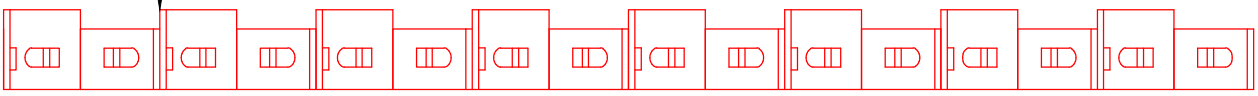
HEXAGONAL MESH GIVEN FLEXABILITY DURING MANUFACTURE WITH AJUSTMENT OF CLAMPING STRENGTH MINIMUM DIAMETER 320MM

WELD TO SHELL, HEXAGONAL MESH HAS A CONVEX SHAPE FOR EASIER INSTALLATION



HEXAGONAL MESH WITH RIDGID CLAMPING AND ROLLED AFTER MANUFACTURE -HARD WAY PRESENT CLOSED EDGES OF MESH STRIPS FOR REFRACTORY INJECTION / TAMPING

OFFSET MESH WIDTH AVAILABLE STANDARD RANGE 19-35MM WIDER CAN BE PROVIDED WITH EXTRA TOOLING COST



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TITLE
PF HEXAGONAL MESH

DATE	REVISION	BY

FILE NAME: PF HEXAGONAL MESH - PF - R024.DWG

MATERIAL: STAINLESS STEEL

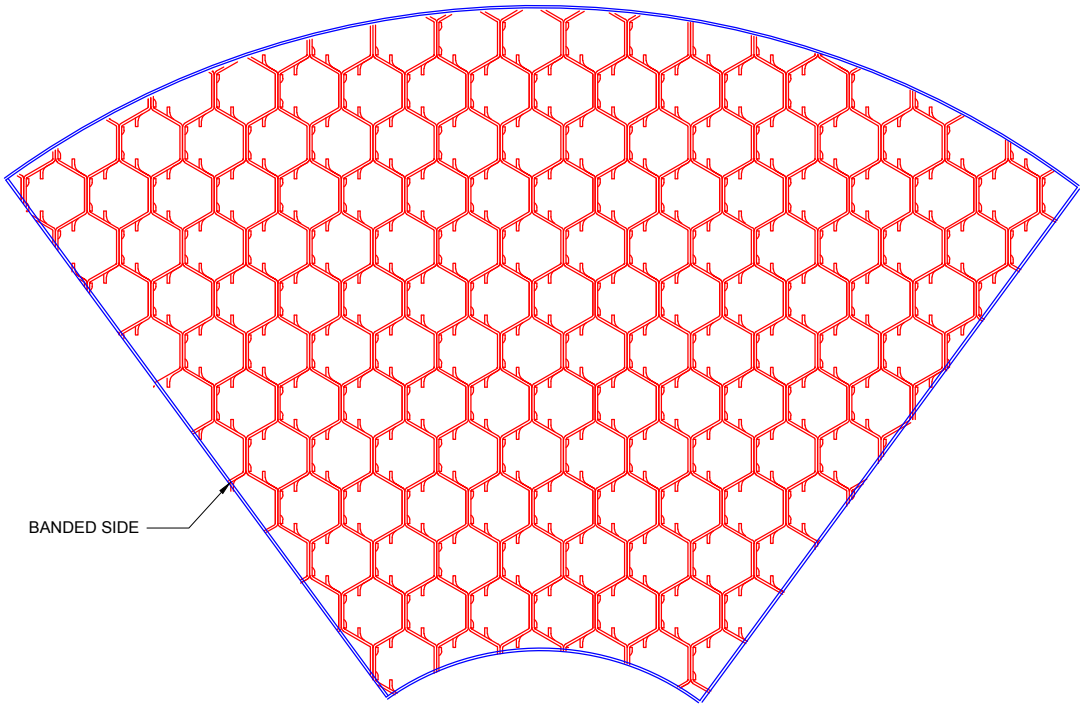
DATE 31.03.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S.	

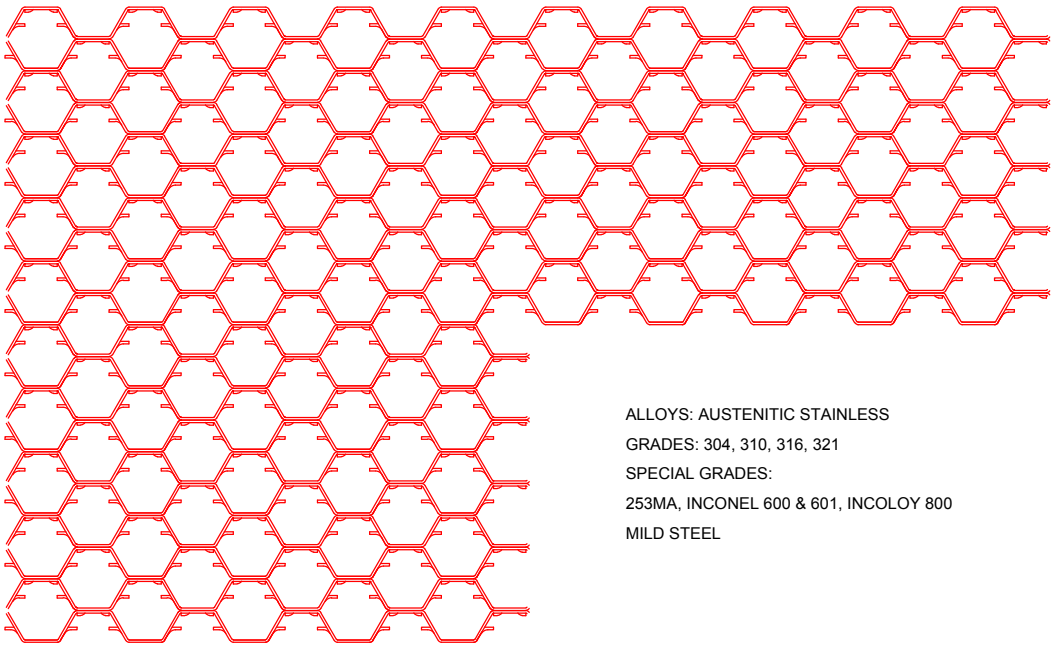
DWG No. PF - R024

SIZE A4

REV



HEXAGONAL MESH CAN BE MANUFACTERED TO CUSTOM SHAPES
AS ABOVE SUITABLE FOR ROLLING INTO CONES ETC.
BANDED SIDES CAN ALSO BE SPECIFIED.



ALLOYS: AUSTENITIC STAINLESS
GRADES: 304, 310, 316, 321
SPECIAL GRADES:
253MA, INCONEL 600 & 601, INCOLOY 800
MILD STEEL

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TITLE
PF HEXAGONAL MESH

DATE	REVISION	BY

FILE NAME: PF HEXAGONAL MESH - PF - R024.DWG

MATERIAL: STAINLESS STEEL

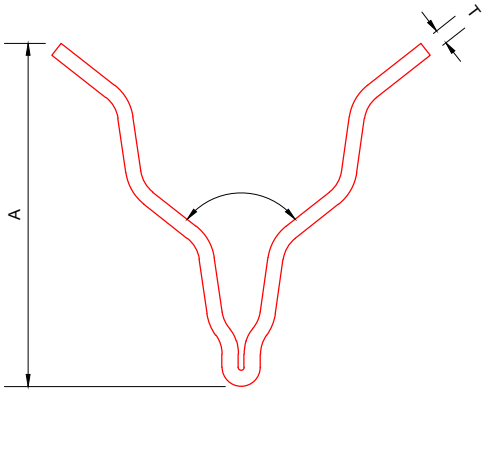
DATE 31.3.11

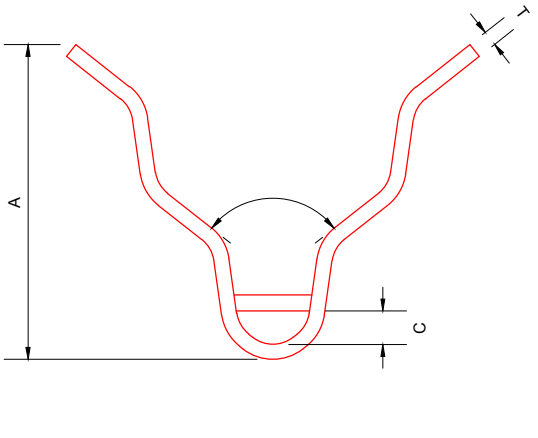
DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S.	

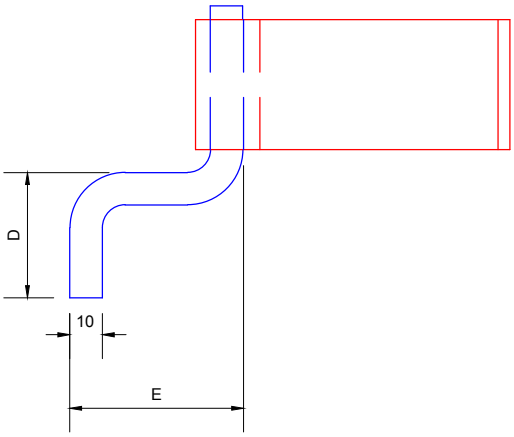
DWG No.
PF - R025

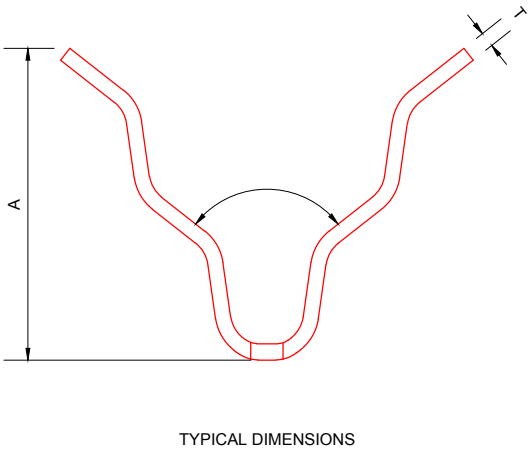
SIZE A4

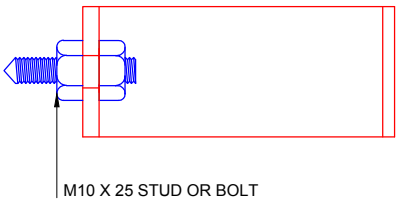
REV











TYPICAL DIMENSIONS
B=15-50MM T=4.5-8MM

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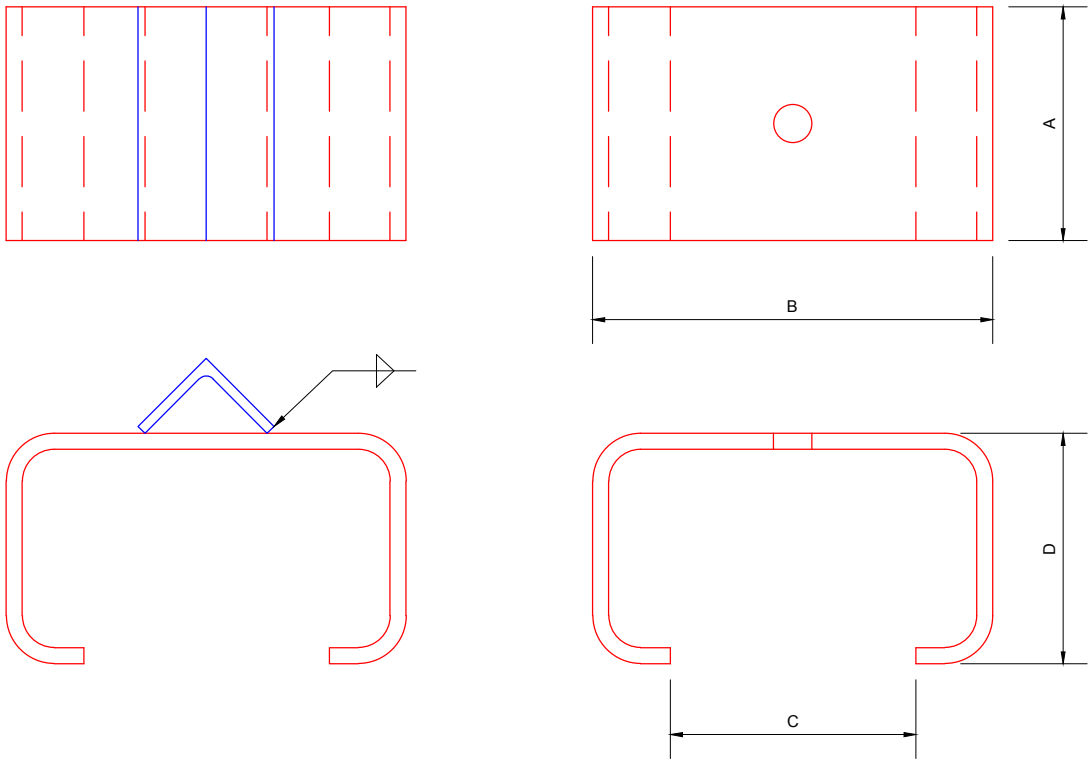
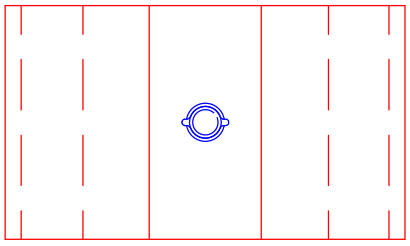
TITLE
PF WALL ANCHOR

DATE	REVISION	BY

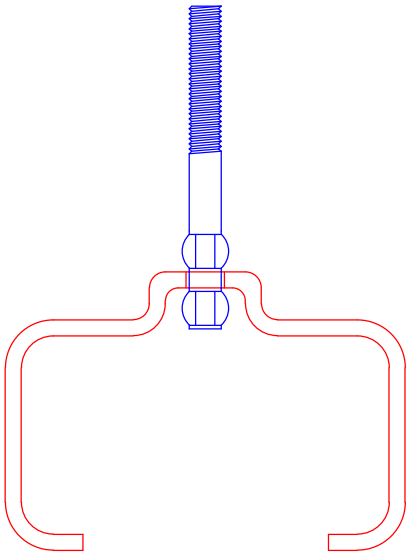
FILE NAME: PF WALL ANCHOR - PF - R026.DWG
MATERIAL: STAINLESS STEEL
DATE 31.3.11

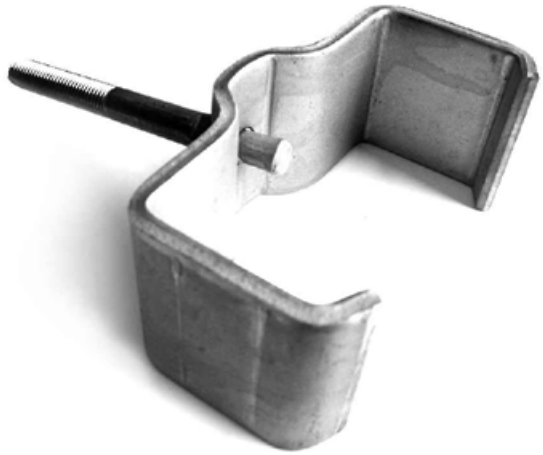
DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S.		PF - R026	A4	





VARIOUS C-CLIP CONFIGURATIONS





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TITLE
PF C CLIPS

DATE	REVISION	BY

FILE NAME: PF C CLIPS - PF - R027.DWG

MATERIAL: STAINLESS STEEL

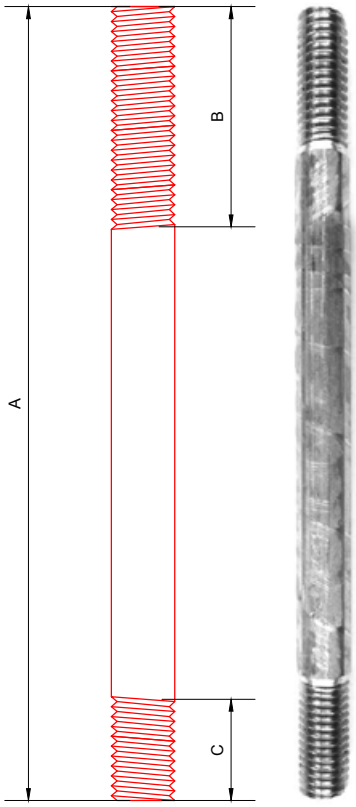
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S.	

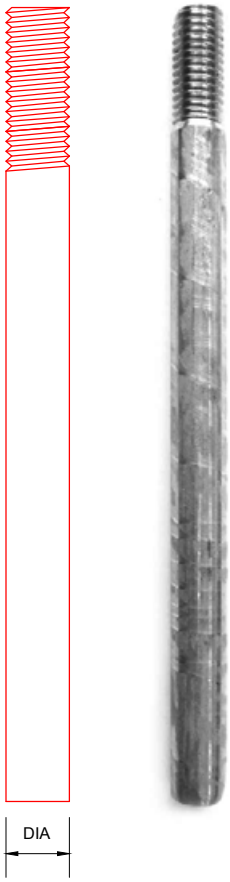
DWG No.
PF - R027

SIZE A4

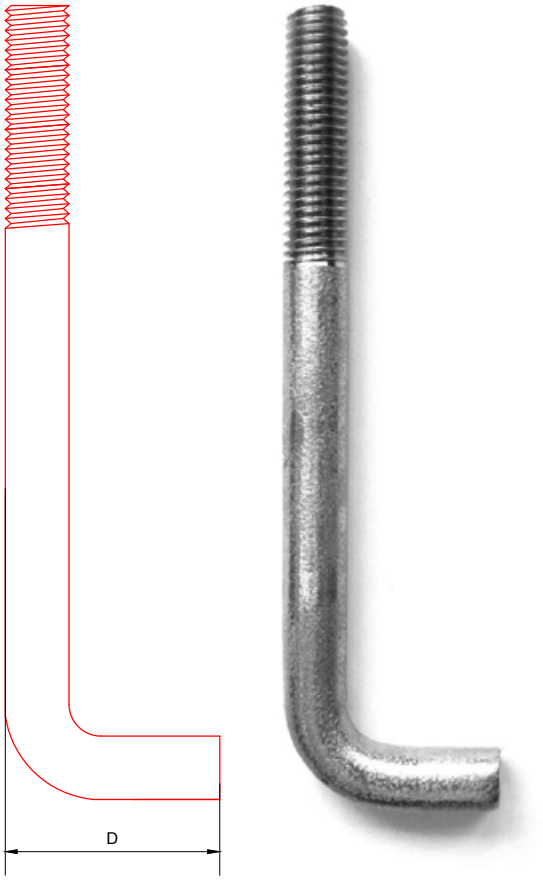
REV



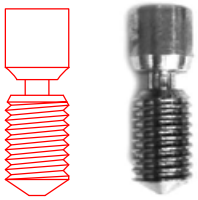
THREADED BOTH ENDS



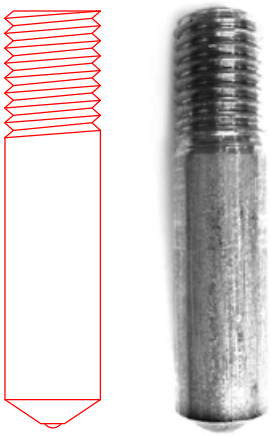
THREADED ONE END



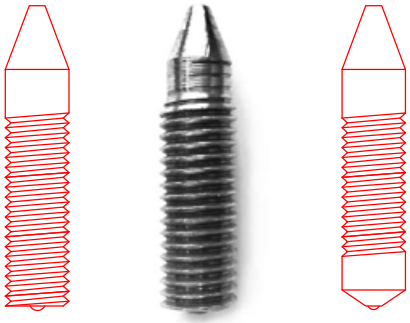
THREADED ONE END WITH L BASE



KNOCK OFF STUD USED IN APPLICATIONS WHERE STUD LENGTH IS BELOW THE MINIMUM LENGTH FOR STUD WELDING IE LESS THAN 25MM



THREADED ONE END WITH STUD WELDING BASE AND ALUMINIUM FLUX BALL



THREADED ONE END WITH STUD WELDING BASE POINTED END AND ALUMINIUM FLUX BALL

N.B REF FLUX BALL
SOME ADVISORS INDICATE ONLY NECESSARY FOR WIRE DIAMETER GREATER THAN 8MM

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TITLE
PF STUDS

DATE	REVISION	BY

FILE NAME: PF STUDS - PF - R028.DWG

MATERIAL: STAINLESS STEEL

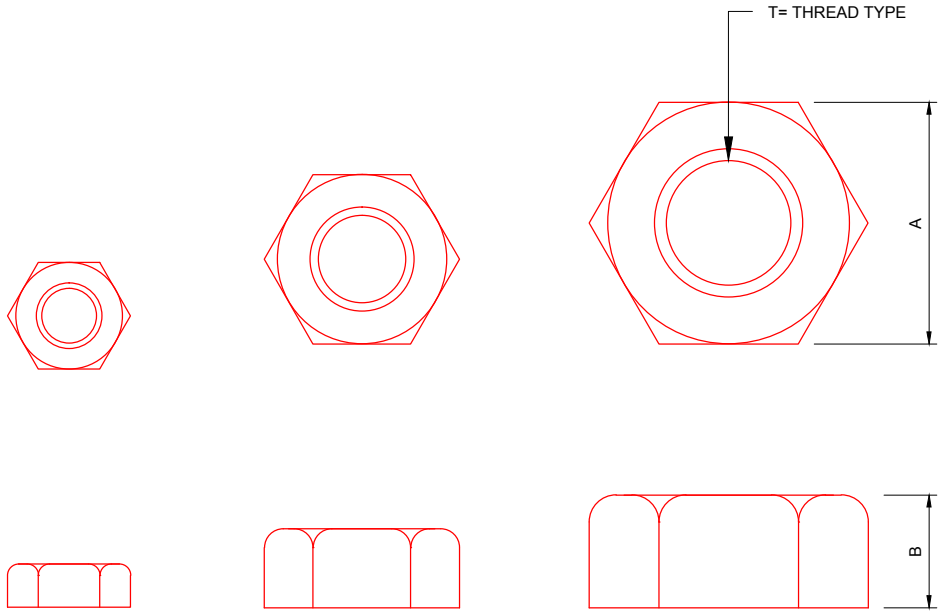
DATE 21.12.11

DRAWN BY	SCALE	PAGE/SHEET
B.MITCHELL	N.T.S.	

DWG No. PF - R028

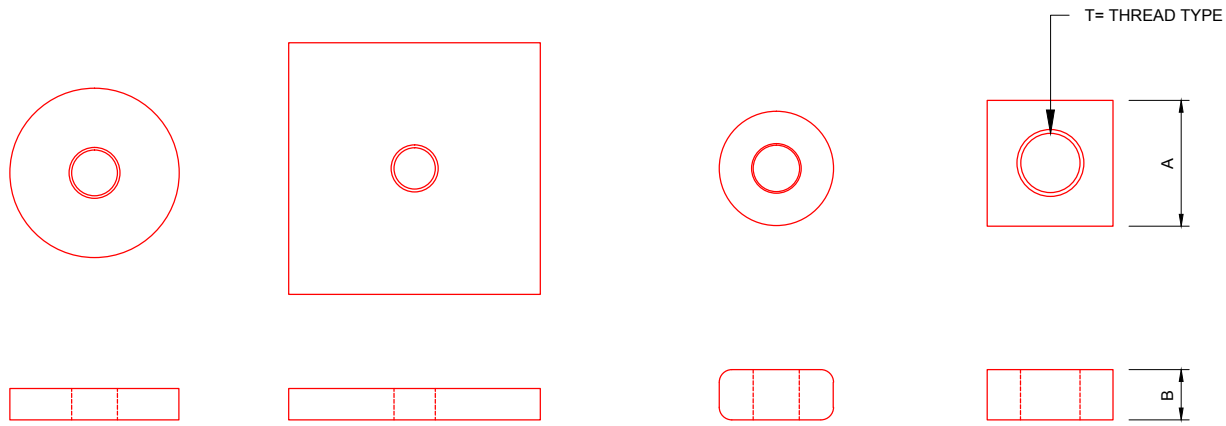
SIZE A4

REV

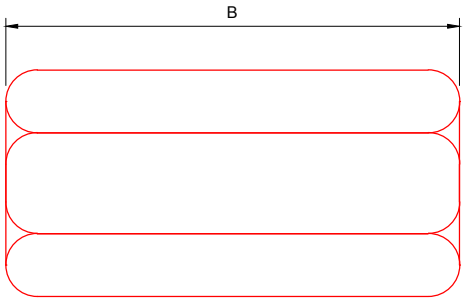


HEXAGON NUTS

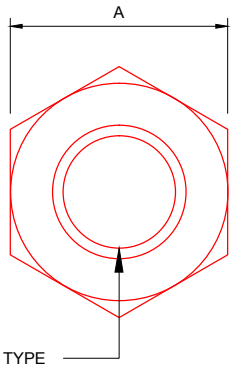
METRIC DIN STANDARD SIZES FOR HEX NUTS		
	A	**B**
M5	8	4
M6	10	5
M8	13	6.5
M10	17	8
M12	19	10
M14	22	11
M16	24	13



ROUND WASHER NUT | SQUARE WASHER NUT | ROUND NUT | SQUARE NUT



LONG SERIES HEXNUT/FERRULE
CAN ALSO BE MANUFACTURED AS ROUND OR SQUARE



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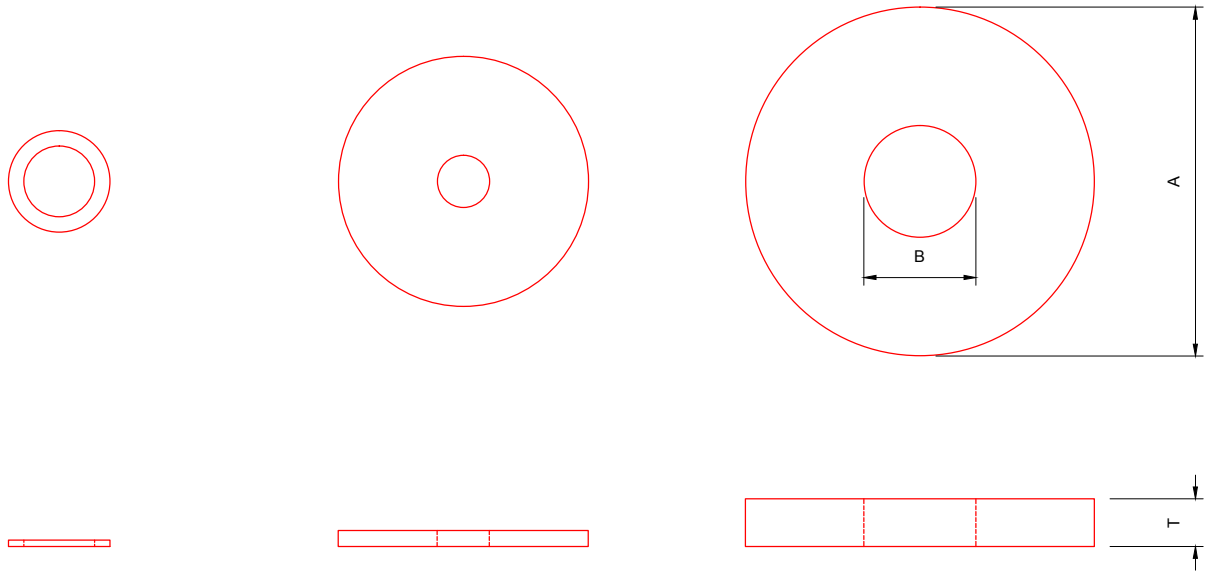
TITLE
PF NUTS

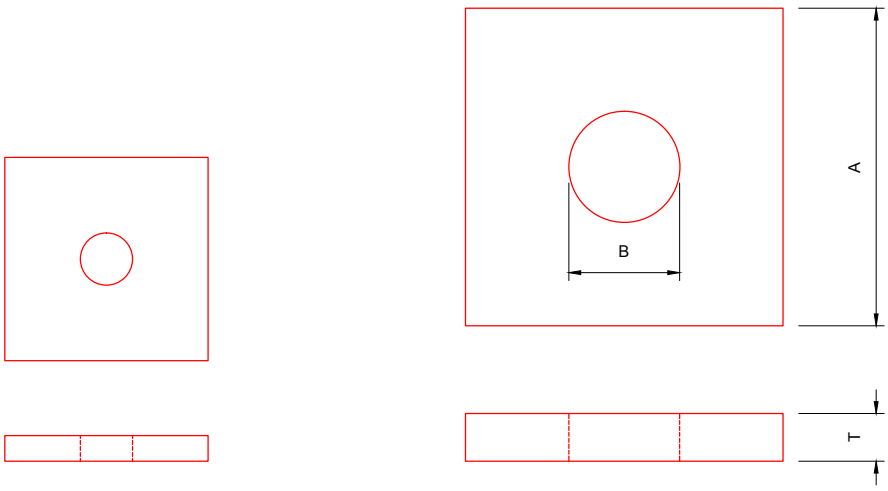
DATE	REVISION	BY

FILE NAME: PF NUTS - PF - R029.DWG
MATERIAL: STAINLESS STEEL
DATE 22.2.12

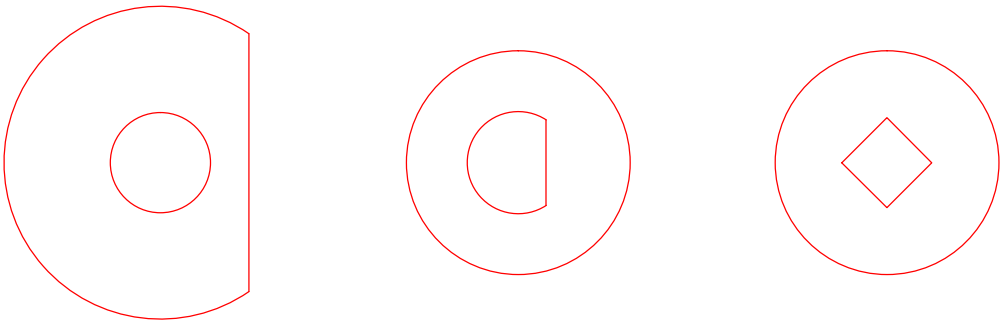
DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
B.MITCHELL	N.T.S.		PF - R029	A4	



ROUND WASHERS



SQUARE WASHERS



NON STANDARD WASHERS

COMMON MATERIALS:
CARBON STEEL
QUENCHED AND TEMPERED
GALVABOND
ZINC PLATED
GALVANISED
STAINLESS
COPPER
ALUMINIUM
BRASS

OPTIONAL RUMBLING

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TITLE
PF WASHERS

DATE	REVISION	BY

FILE NAME: PF WASHERS - PF - R030.DWG

MATERIAL: STAINLESS STEEL

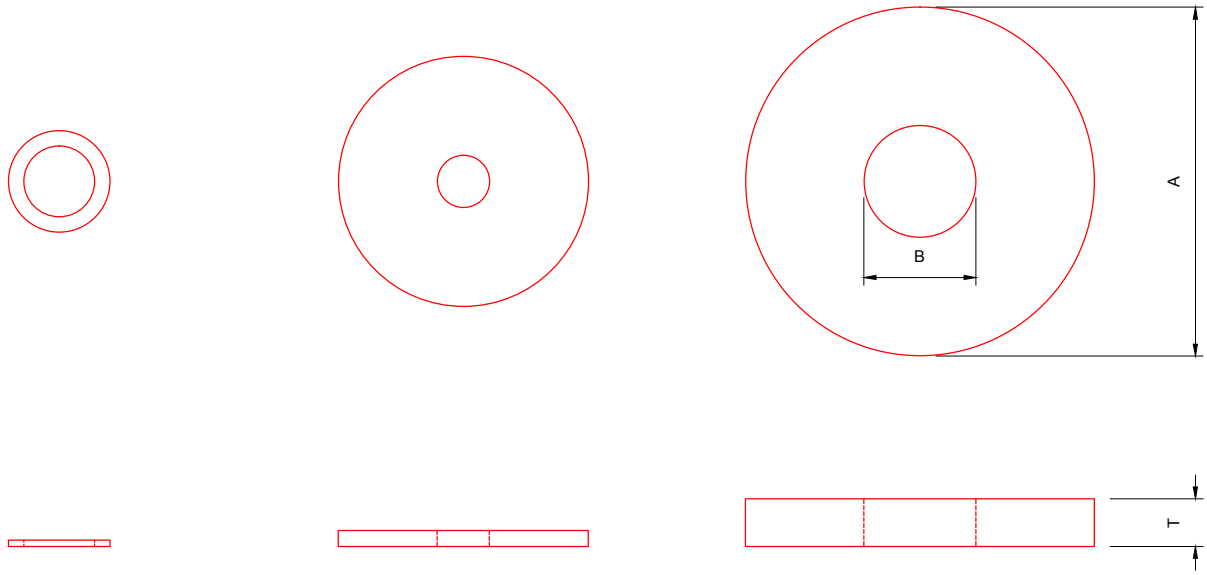
DATE 22.2.12

DRAWN BY	SCALE	PAGE/SHEET
B.MITCHELL	N.T.S.	

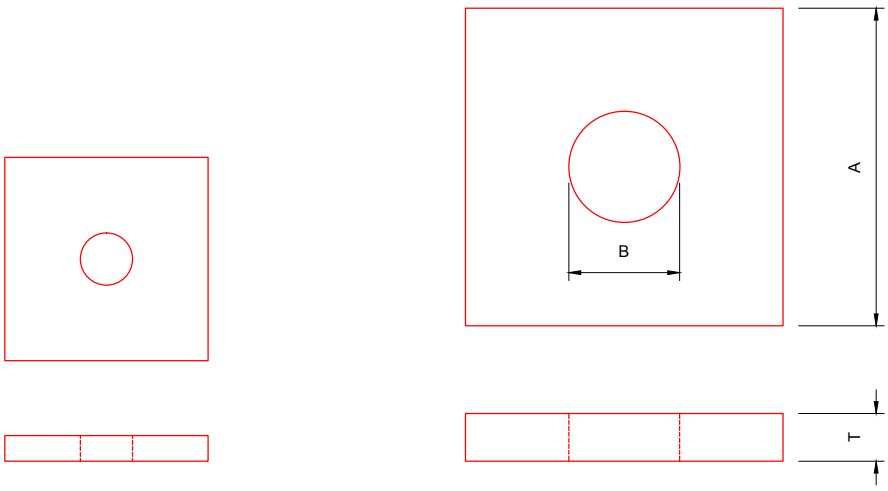
DWG No.
PF - R030

SIZE A4

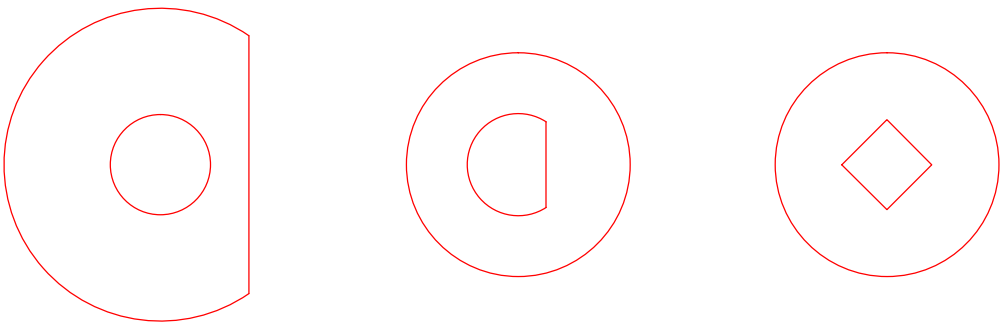
REV



ROUND WASHERS



SQUARE WASHERS



NON STANDARD WASHERS

COMMON MATERIALS:
CARBON STEEL
QUENCHED AND TEMPERED
GALVABOND
ZINC PLATED
GALVANISED
STAINLESS
COPPER
ALUMINIUM
BRASS

OPTIONAL RUMBLING

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TITLE
PF WASHERS

DATE	REVISION	BY

FILE NAME: PF WASHERS - PF - R030.DWG

MATERIAL: STAINLESS STEEL

DATE 22.2.12

DRAWN BY	SCALE	PAGE/SHEET
B.MITCHELL	N.T.S.	

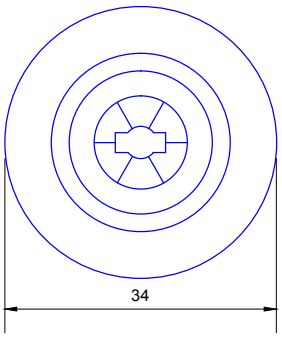
DWG No.
PF - R030

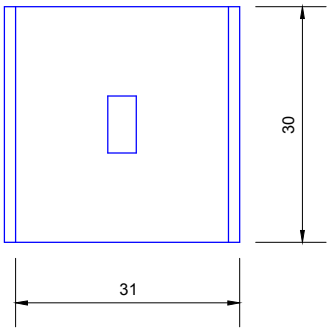
SIZE A4

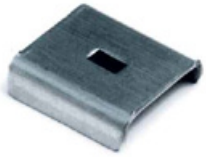
REV

PRESSED LOCK WASHER

TYPICAL SPEED CLIP
CAN BE USED ON
SERRATED SECTION
OR ROUND ROD.



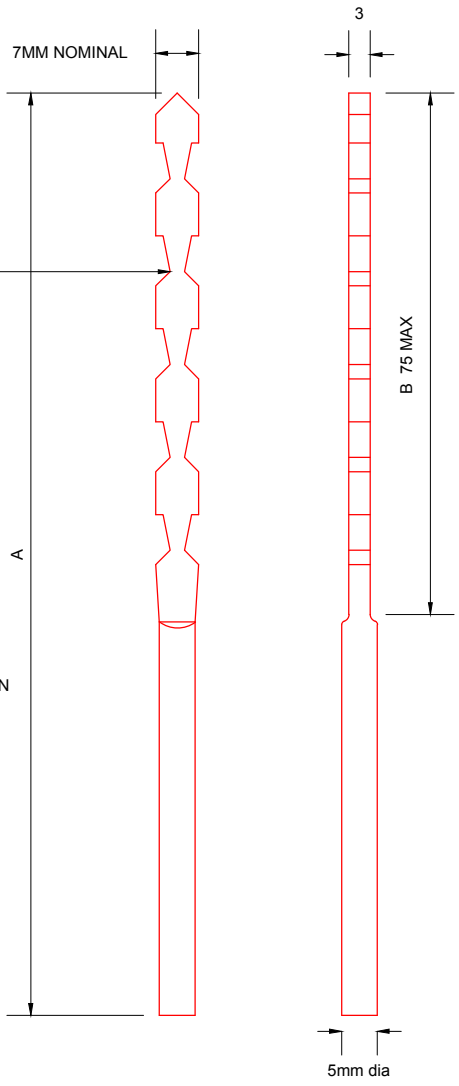




CROSS SECTIONAL
AREA CALCULATED TO
EQUAL OR EXCEED
MINIMUM INDUSTRY
STANDARD

CAREFULLY CENTRALISED
SERRATIONS.
MAXIMUM 75MM

FOR STUD WELDING
SEE INFORMATION SECTION



WIRE 5MM DIA.

MANUFACTURE

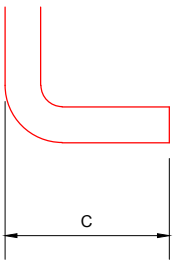
CERAMIC FIBRE BLANKET PIN
PRESSED FROM FULLY ANNEALED

SOME NICKEL ALLOYS HAVE AN
"INTERSTAGE ANNEAL" DURING

NOTE: IN COMPARISON TO PINS
PRESSED FROM 6MMX3MM FLAT
STRIP, PRESS FORM'S FIBRE LOK
PIN PRESSED FROM 5MM DIAMETER
WIRE HAS A GREATER CROSS
SECTIONAL AREA AT THE BASE
THUS A GREATER RESISTANCE
TO BENDING

COMMON ALLOYS:
STAINLESS ALLOYS: 304, 321, 310, 253MA
NICKEL ALLOYS: INCONEL 601, INCOLOY 800

CERAMIC WELDING FERRULE



L-BASE SOMETIMES PREFERRED
FOR HIGHER STRENGTH WELD
ATTACHMENT

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TITLE
PF FIBRE LOK ANCHOR

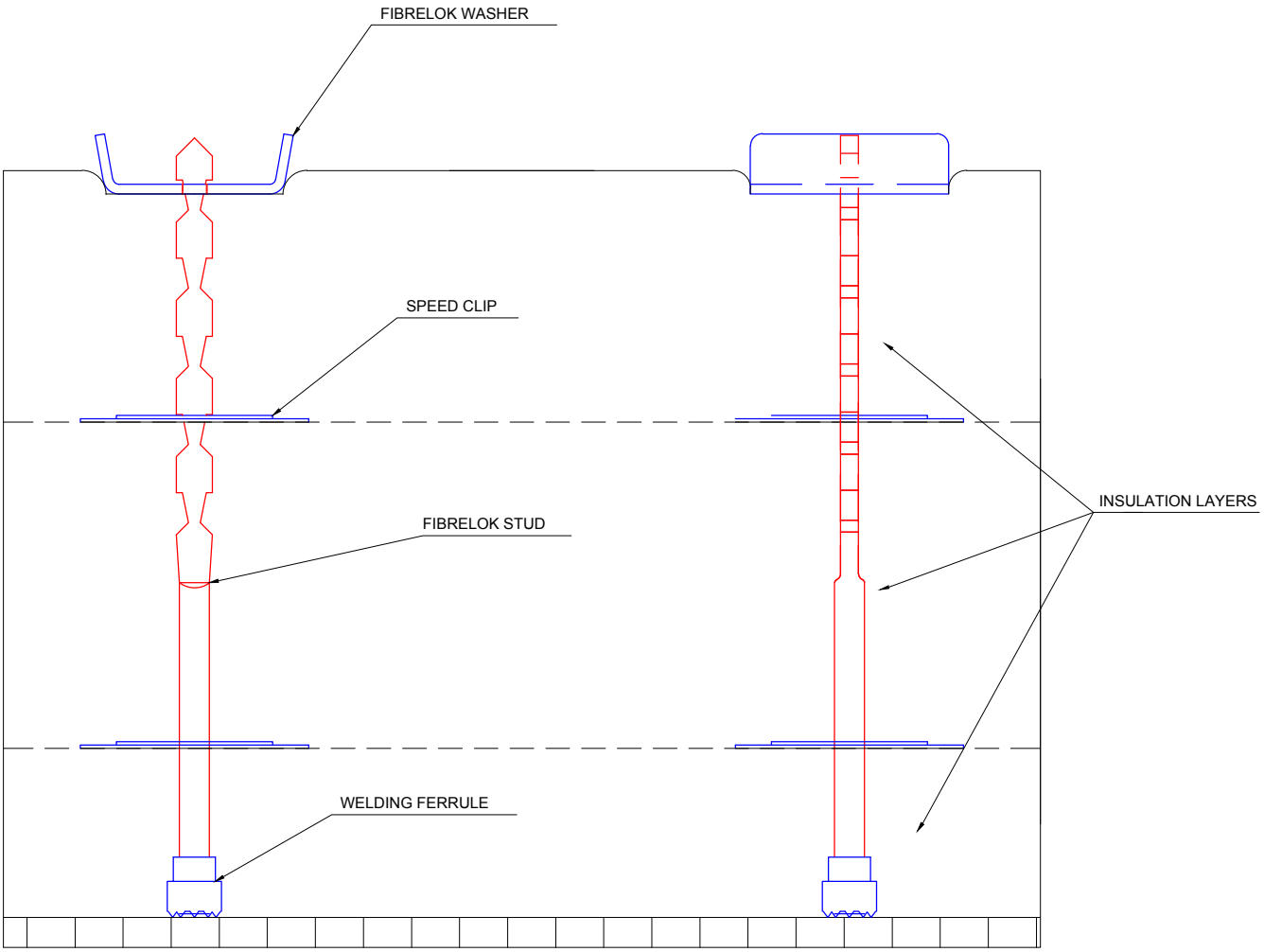
DATE	REVISION	BY

FILE NAME: PF FIBRE LOK ANCHOR - PF - R031.DWG

MATERIAL: STAINLESS STEEL

DATE 31.03.11

DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S		PF - R031	A4	



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TITLE
PF FIBRE LOK ASSEMBLY

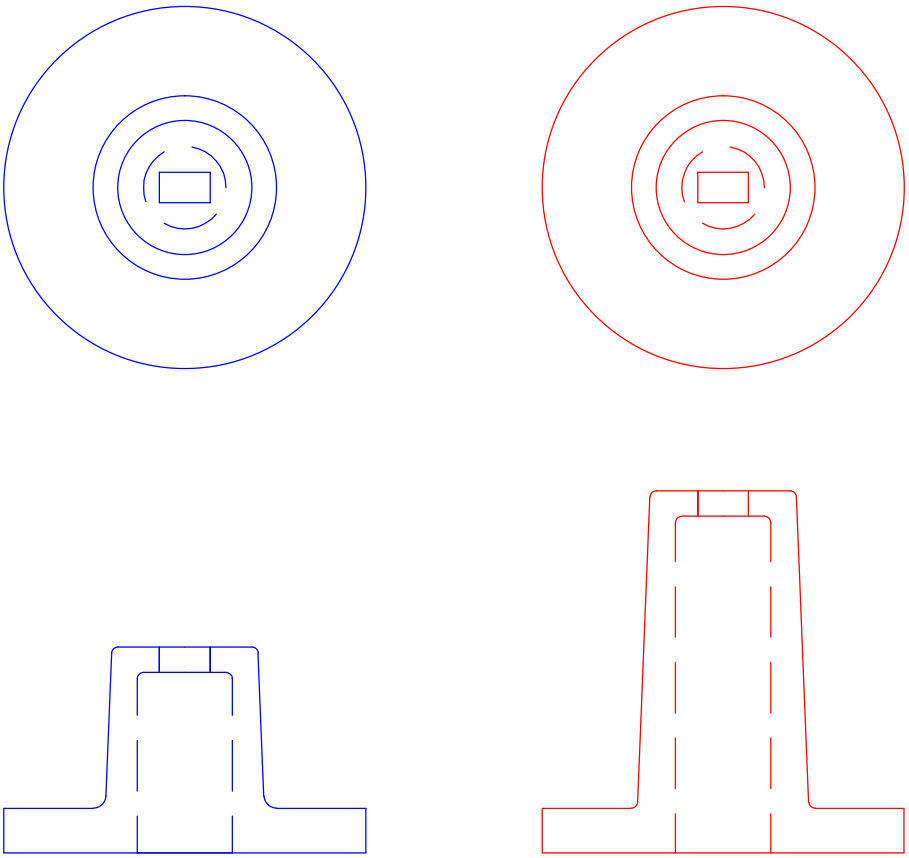
DATE	REVISION	BY

FILE NAME: PF FIBRE LOK ASSEMBLY - PF - R032.DWG

MATERIAL: STAINLESS STEEL

DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET	DWG No.	SIZE	REV
D.BRAMLEY	N.T.S.		PF - R032	A4	



CERAMIC CUP LOKS SUITABLE FOR USE WITH
FIBRELOK ANCHORS
VARIOUS LENGTHS AVAILABLE

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TITLE
PF CERAMIC CUP LOKS

DATE	REVISION	BY

FILE NAME: PF CERAMIC CUP LOKS - PF - R033.DWG

MATERIAL:

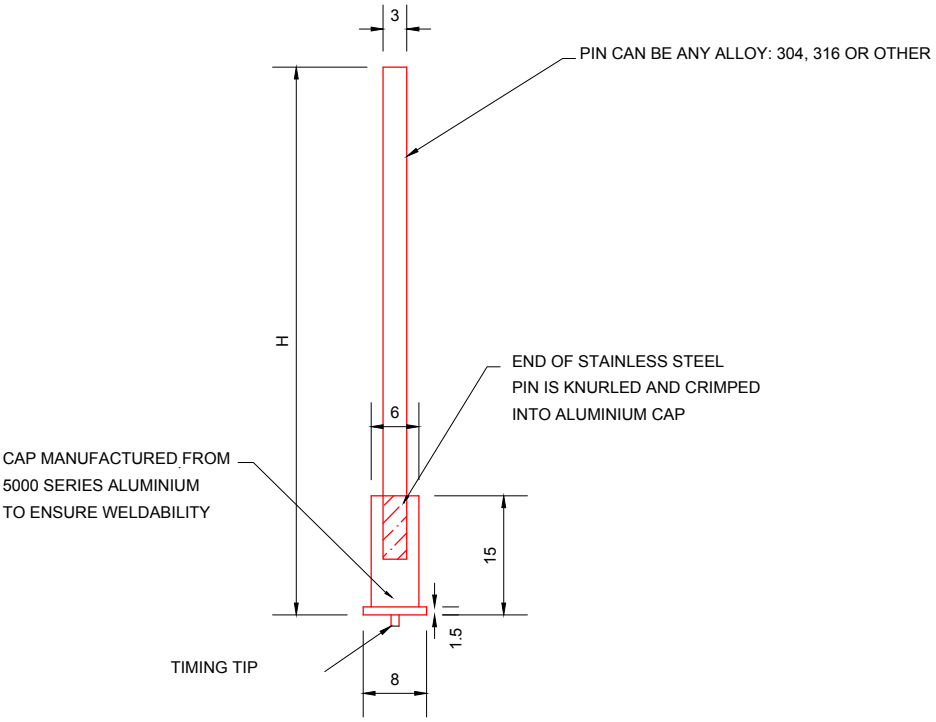
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S.	

DWG No.
PF - R033

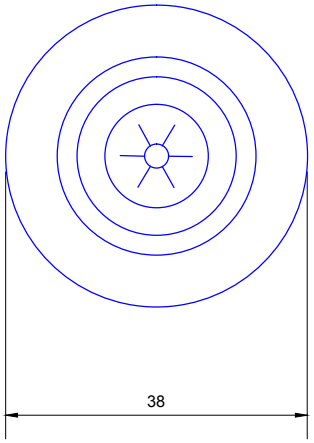
SIZE A4

REV



BI METALIC ANCHOR

SUITABLE FOR CAPACITOR DISCHARGE WELDING



SPEED CLIP

SPRING TEMPER STAINLESS

304 OR 316

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TITLE
PF BI-METALLIC PIN

DATE	REVISION	BY

FILE NAME: PF - BI-METALLIC PIN - PF - R034.DWG

MATERIAL: STAINLESS STEEL

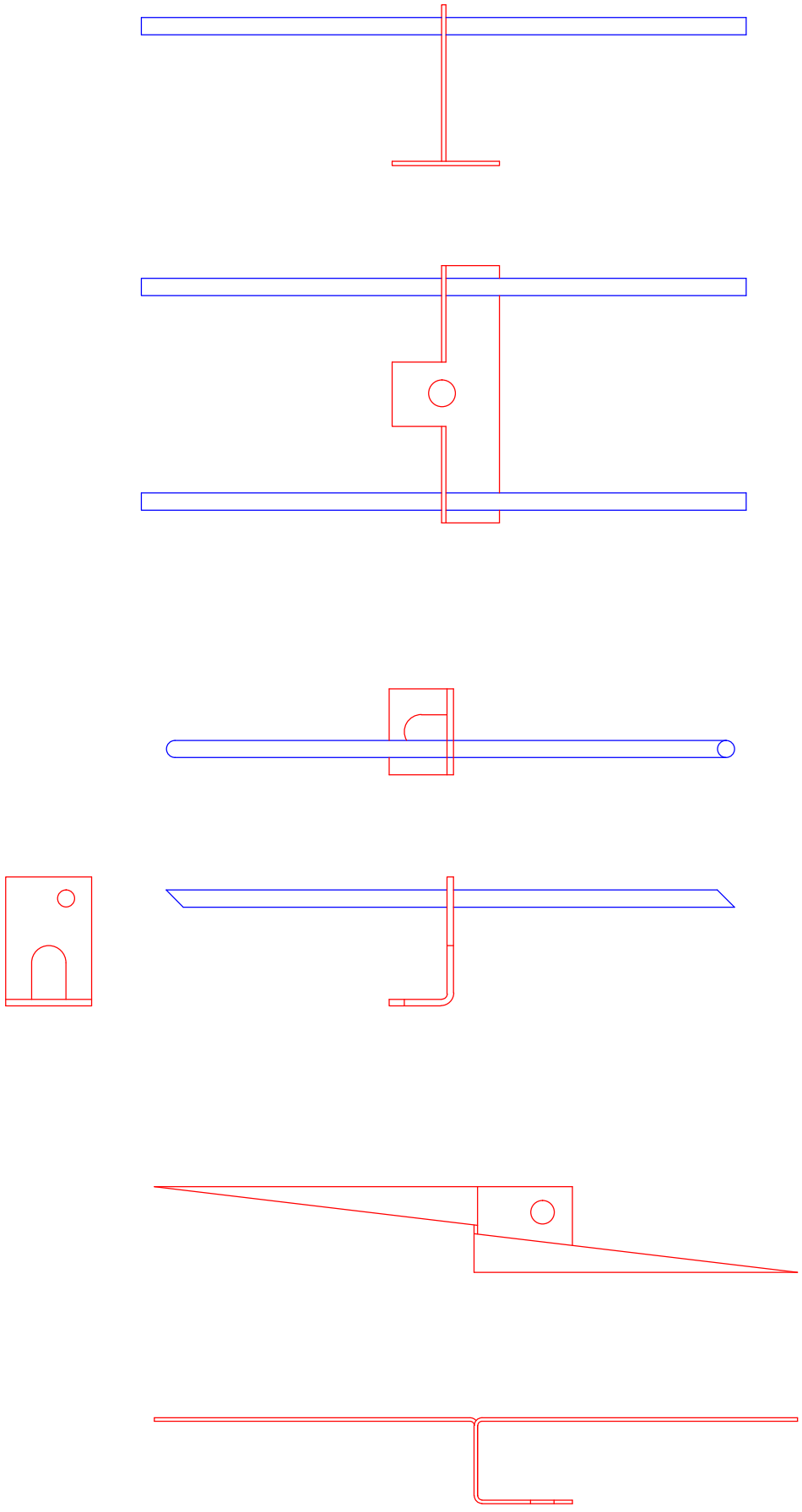
DATE 31.3.11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S.	

DWG No.
PF - R034

SIZE A4

REV



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TITLE
PF BLOCK ANCHORS

DATE	REVISION	BY

FILE NAME: PF BLOCK ANCHORS - PF - R035.DWG

MATERIAL: STAINLESS STEEL

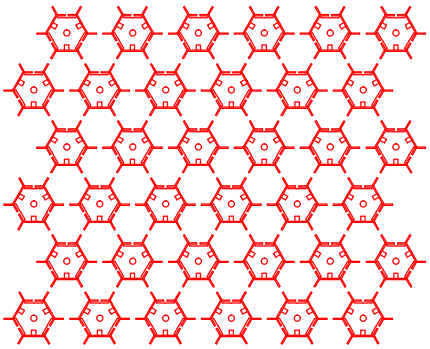
DATE 31.3.11

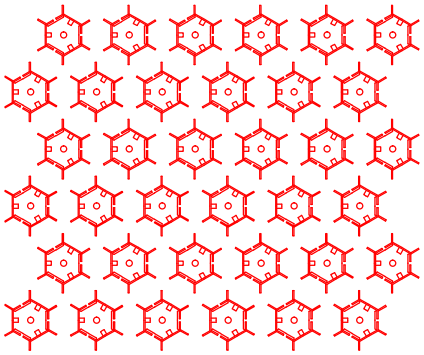
DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S.	

DWG No.
PF - R035

SIZE A4

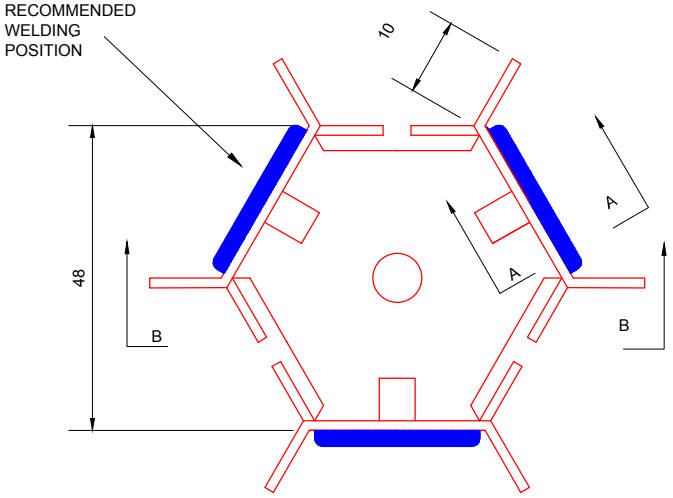
REV

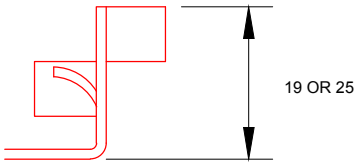




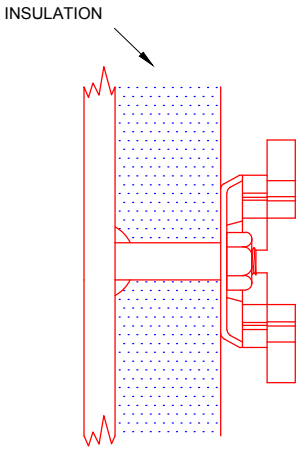
LAYOUT PATTERNS

(TYPICAL SPACING 90MM CENTRES
APPROXIMATELY 143 PER SQUARE METRE)



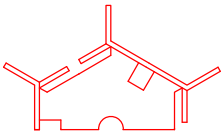


VIEW AA



PRESSFORM HEXAGONAL CELL

MANUFACTURED IN 1.6 OR 2.0 MM
STAINLESS STEEL IN GRADES 304, 310,
INCONEL 601, 253MA OR 3CR12,
CENTER HOLE SIZE CAN BE VARIED
FOR HIGH CARBON BUILD UP AREAS



HALF CELL FOR EDGING

AVAILABLE ON REQUEST

OPTIONAL STUD MOUNTING (CELL VIEWED ON BB)

NUT CAN BE TACK WELDED TO
HEXAGONAL CELL (BOTTOM OR TOP
MOUNTED)

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TITLE
PF HEXAGONAL CELL

DATE	REVISION	BY

FILE NAME: PF HEXAGONAL CELL - PF - R036.DWG

MATERIAL: STAINLESS STEEL

DATE 31/3/11

DRAWN BY	SCALE	PAGE/SHEET
D.BRAMLEY	N.T.S	

DWG No.
PF - R036

SIZE A4

REV