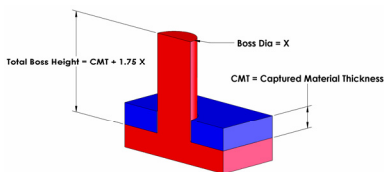


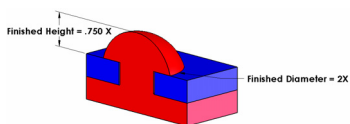
# STANDARD THERMAL STAKING PROFILES

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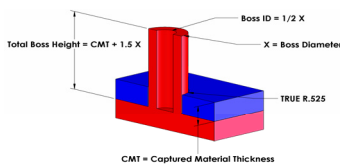


## Dome Stake - High Profile

- To obtain optimal results use with a boss of .250" or less O.D
- Smaller head means faster weld times
- Under normal conditions this method will create a perfectly symmetrical weld
- Recommended for crystalline plastics with highly defined melting points such as 33% G.F.
- Works well with plastic's with abrasive fillers and for materials that easily degrade
- Dome stakes come in two basic silhouettes: High and Low
- Counter bored holes can improve the appearance of these welds
- Stronger weld but slower weld time than a low profile

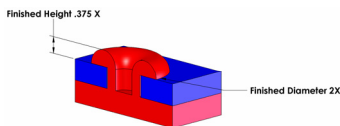


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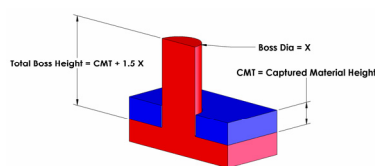


## Hollow Stake

- For best results use bosses with an .150" or larger O.D.
- With out having to melt large amounts of material the hollow stake will produce an extremely strong head
- Use to avoid sink marks on the opposite side of the components
- A hollow stake will enable the parts to be reassembled with a self-tapping screw for repair, or when disassembly is required
- The resemblance to a molded part gives parts a likeness once welded

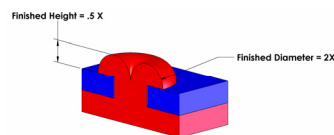


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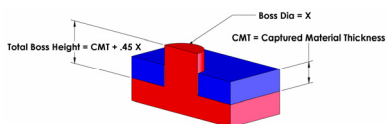


## Rosette Stake - High Profile

- Recommended for bosses with a O.D. of .063" or larger
- Ideally suited for low density non abrasive plastics
- The easiest and quickest way to stake a large amount of material
- Concentration of the material is located over the welding seam
- Accuracy of stake to tip alignment is critical
- X-Y micro adjustment is essential for obtaining the proper welder stake
- Conical Stakes come in two basic silhouettes: High and Low
- The welds resemblance to a rivet provides a clean aesthetic look

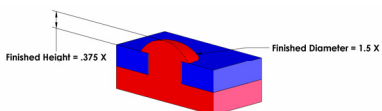


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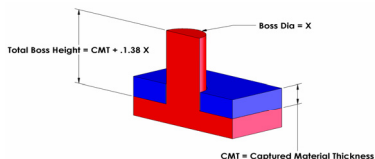


## Dome Stake - Low Profile

- To obtain optimal results use with a boss of .250" or less O.D
- Smaller head means faster weld times
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- Recommended for crystalline plastics with highly defined melting points such as 33% G.F.
- Works well with plastic's with abrasive fillers and for materials that easily degrade
- Dome stakes come in two basic silhouettes: High and Low
- Counter bored holes can improve the appearance of these welds

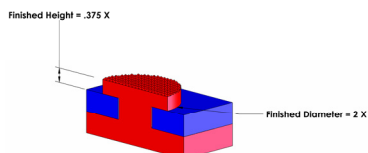


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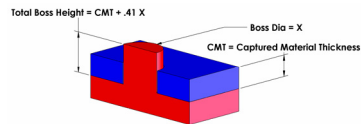


## Knurled Stake

- A key factor in choosing the knurled staking tool is the lack of alignment that is required to produce a quality stake
- Used in applications where appearance and strength are not critical
- The configuration of the stake should be determined by the design needs
- Multiple stakes in a close proximity can be knurled by a single tool
- Normally used in conjunction with a heater platen where thermal expansion is generally a problem
- Ideally suited for production work (capable of achieving short cycle times)

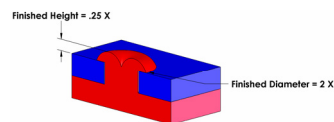


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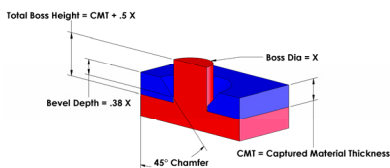


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## Flush Stake

- Typically used for applications requiring a flush mounting surface
- Requires that mating component has sufficient thickness for a countersink, counter bore, or a combination of the two
- The volume of the boss is crucial to ensure the countersink is flush once the weld is complete

