

Shear Joint Guidelines

Date _____

Customer _____

Sales Engineer _____

Part Name/Description _____

Material(s) _____

Gap → 0.003" to 0.005" per side

Shear Step Height $\frac{w}{2}$ to $2W$

Wall Thickness w

Lead in 0.020" to 0.050" (0.5 mm to 1.3 mm)

Shear Joint Interference Guidelines
Minimum Wall Thickness = 0.075" (1.8mm)

Maximum Part Dimension	Interference per Side (Range)	Part Dimension Tolerance
Less than 0.75" (18 mm)	0.008" to 0.012" (0.2 to 0.3 mm)	± 0.001" (± 0.025 mm)
0.75" to 1.50" (18 to 35 mm)	0.012" to 0.016" (0.3 to 0.4 mm)	± 0.002" (± 0.050 mm)
Greater than 1.50" (35 mm or larger)	0.016" to 0.020" (0.4 to 0.5 mm)	± 0.003" (± 0.075 mm)

a = _____ b = _____ c = _____

Rigid sidewall support is very important with shear joint welding to prevent part deflection during welding.

Fixture

Directs Flash In

Rigid sidewall support is very important with shear joint welding to prevent part deflection during welding.

Fixture

Directs Flash Out

a = _____
b = _____

Single Tongue and Groove

a = _____
b = _____ c = _____

Double Tongue and Groove

**Consult with Dukane before using

a = _____ b = _____

Shear Variation

Proper size and location of shear joint dimensions must be based on individual application requirements, material, part evaluation and testing. Form No. 10872-J-04

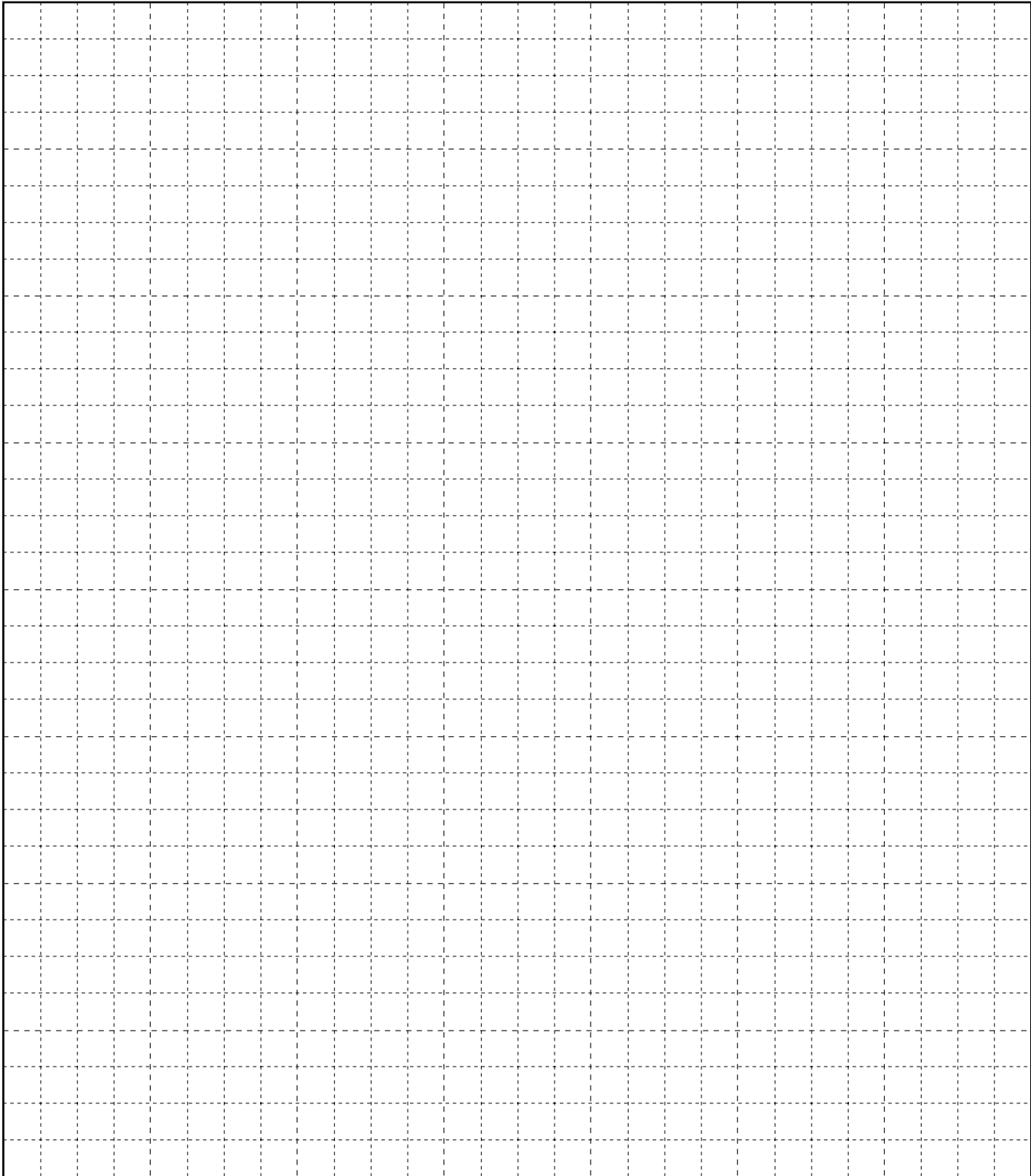
Use grid on back to sketch specific part design showing joint location

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Blank rectangular box for part name/description.

Part Name/Description



Use this grid to sketch the specific part design showing joint dimensions and location

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