

**SPRING ELECTRODE LENGTH**  
( In Inches )

<b>PIPE SIZE</b>	<b>LENGTH</b>	<b>PIPE SIZE</b>	<b>LENGTH</b>
2 .....	6 3/4	20 .....	55 1/2
2 1/2 .....	8	22 .....	57 1/4
3 .....	9 3/4	24 .....	59 1/2
4 .....	11 3/4	26 .....	64 1/4
6 .....	17 1/2	30 .....	67 1/4
8 .....	24 1/2	34 .....	73 1/4
10 .....	29 1/2	36 .....	77 1/4
12 .....	34 1/2	40 .....	87 1/2
14 .....	38 1/2	42 .....	95 1/4
16 .....	43 1/2	48 .....	105 1/4
18 .....	50 1/2	54 .....	116
		60 .....	120

NOTE: Spring stock can best be cut on a grinding wheel, which has a 4 to 6 inch diameter and good sharp corner. Mark the desired spring length with a marks-a-lot pen or crayon. Then with your hands, bend spring stock at the point you wish to grind it; links of the spring should be separated as much as possible. Grind spring link most of the way through and twist up to break the link. The end of the spring should be slightly beveled on the grinder so that the last link fairly well matches the spring end fitting into which it will be screwed. The spring end itself can be clamped in a vice on the shoulder end to hold it firm while screwing on the spring.

Spring electrode chart (sizes in inches)  
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