

INSTALLATION WELDING OPTIONS

- 1- E.B. OR LASER WELDING
- 2- PULSED TIG WELDING

MATING HARDWARE DIMENSIONS/ CONFIGURATION

SEE SHEET 2 OF THIS INSTRUCTION SHEET.

MATING HARDWARE SHOULD BE 304/304L OR 316/316L STAINLESS STEEL (304/340L ONLY FOR LASER)..

PREFERRED ORIENTATION IS WITH THE WELD ON THE VACUUM SIDE.

MICRO D CONNECTORS WELDING INSTRUCTIONS

PULSED TIG WELD PROCEDURE

1- TYPICAL WELDER SETTINGS:

BACKGROUND CURRENT: FIXED AT 1/2 OF PEAK CURRENT
(eg. 10 AMPS BACKGROUND, 20 AMPS PEAK)

CURRENT SETTING: 20 TO 25 AMPS

PULSE FREQUENCY: 17.5 Hz

PULSE WIDTH FIXED AT 42%

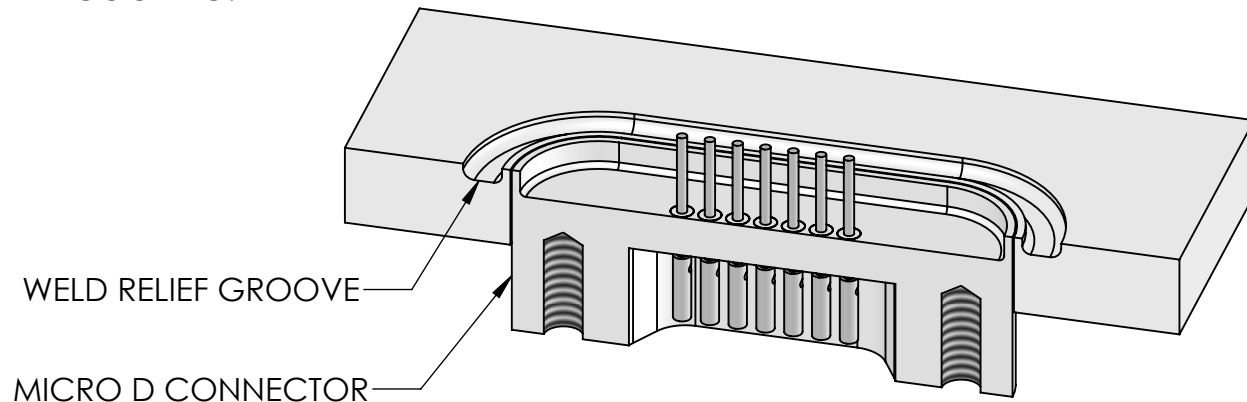
2- USE A HEATSINK ON BOTH SIDES.

3- TACK WELD 4 PLACES EQUALLY SPACED AROUND THE CONNECTOR.

4- WELD TRAVEL SPEED SHOULD BE OPTIMIZED TO REDUCE HEAT INPUT (e.g. 1/8" PER SECOND).

5- OPPOSITE SIDE OF HEADER SHOULD BE FLOODED WITH INERT GAS FOR EXTRA COOLING AND TO MINIMIZE OXIDATION.

6- BETWEEN SEGMENTS, FLOOD THE WELD WITH INERT GAS OR NITROGEN GAS FOR 10 SEC MIN, FOR EXTRA COOLING.



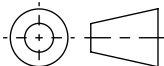
SECTION VIEW

- SEE SHEET 2 FOR HOLE DIMENSIONS -

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THIRD ANGLE
PROJECTION



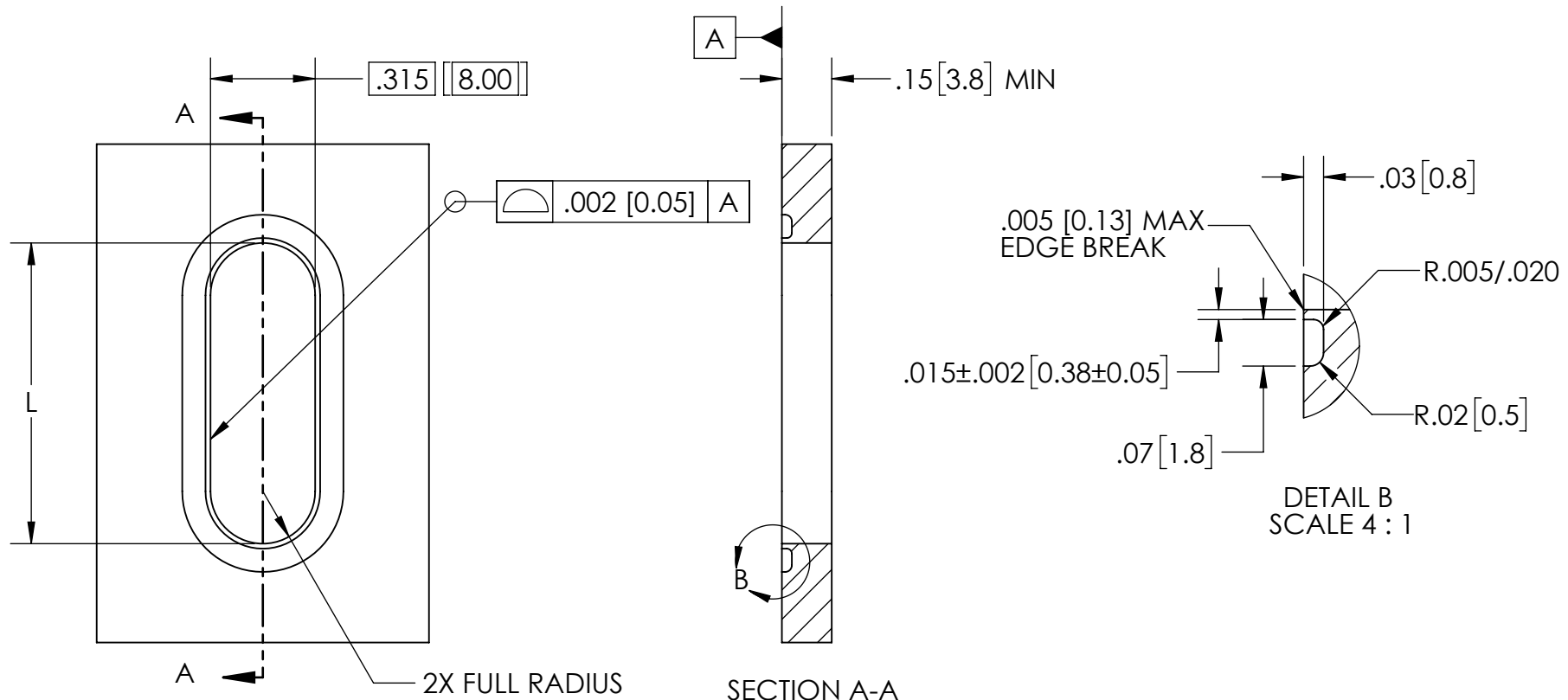
TITLE:

INSTRUCTION SHEET
MICRO D WELDING



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REV.	APP'D	DATE	SCALE 3:1	DIMENSIONS IN INCHES [mm]	DRAWN	JF	08/12/2015	NUMBER:	NS24182	REV:	B	SHEET 1 OF 2
B	CW	7/22/2021	NS24182-11		ENG APPR.	JF	7/19/2021					



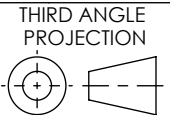
"L" AND .315 ARE BASIC DIMENSIONS

MICRO D CONNECTORS RECOMMENDED HOLE & WELD PREP DIMENSIONS

DIMENSIONS & TOLERANCES REQUIRED MAY DEPEND ON THE PROCESS AND EQUIPMENT USED

- SEE SHEET 1 FOR TIG WELDING INSTRUCTIONS -

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B	CW	7/22/2021	NS24182-12		ENG APPR.	JF	7/19/2021					