

INSTALLATION WELDING OPTIONS

1- E.B. OR LASER WELDING

MATING HARDWARE DIMENSIONS/ CONFIGURATION

SEE SHEET 2 OF THIS INSTRUCTION SHEET.

HARDWARE SHOULD BE 304L STAINLESS STEEL.

PREFERRED ORIENTATION IS WITH THE WELD ON THE VACUUM SIDE.

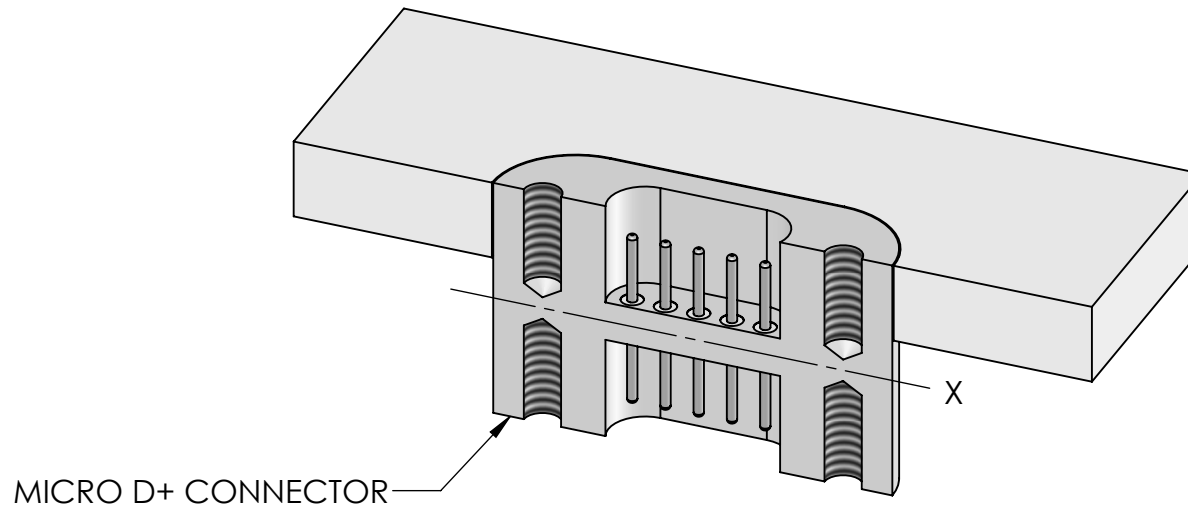
MICRO D+ CONNECTORS WELDING INSTRUCTIONS

LASER WELD PROCEDURE

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

2- STITCH WELD BEGINNING WITH THE END RADII.

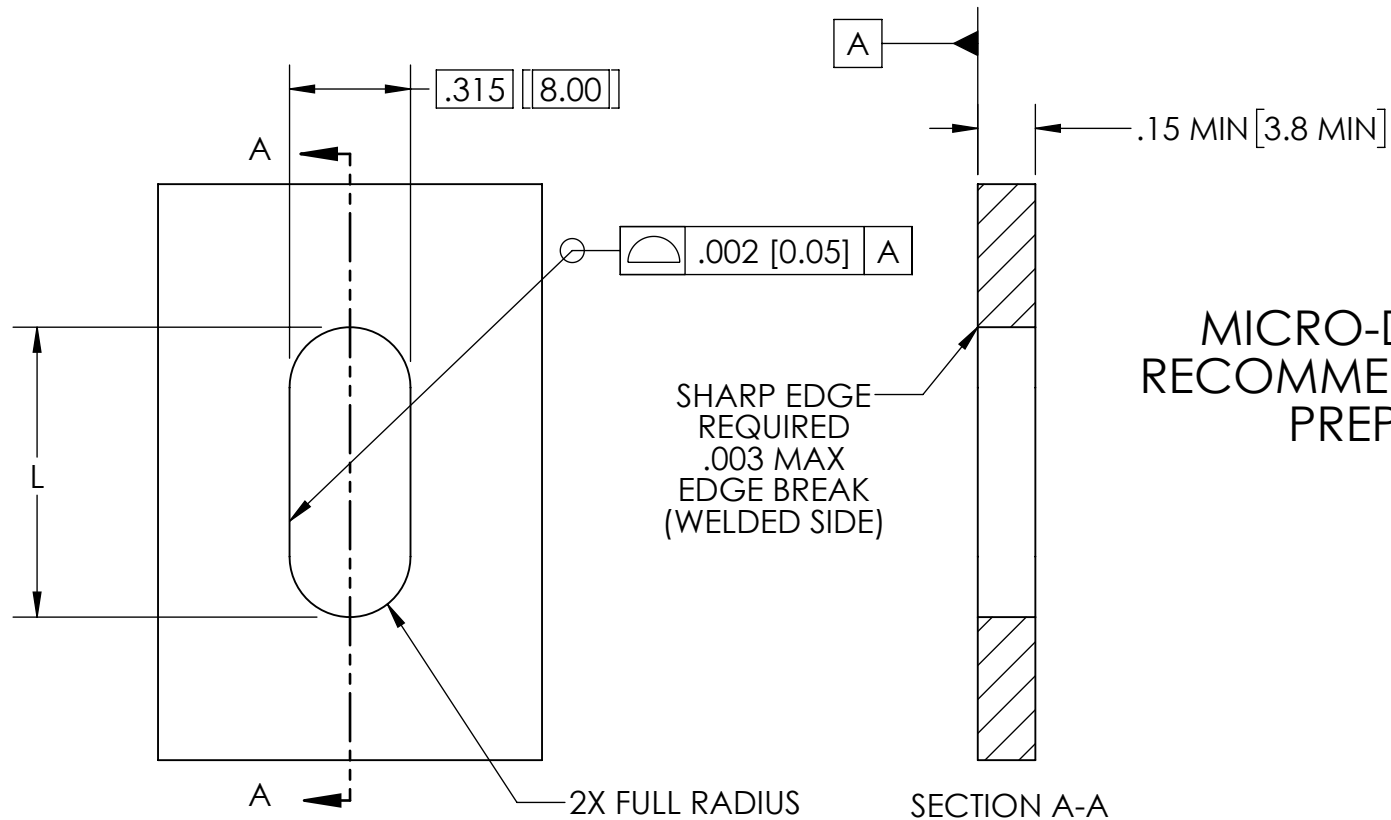
3- HEAT SINKS AND ADDITIONAL COOLING WITH INERT GAS NOT REQUIRED.



NOTE: CONNECTOR IS SYMMETRICAL ALONG THE X-AXIS
AND MAY BE WELDED ON EITHER SIDE.

- SEE SHEET 2 FOR HOLE DIMENSIONS -

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REV.	APP'D	DATE	SCALE 3:1	DIMENSIONS IN INCHES [mm]	DRAWN	CW	7/19/2021	NUMBER:	NS41500
A	JF	07/22/2021	NS41500-11		ENG APPR.	JF	07/22/2021	REV:	
								A	SHEET 1 OF 2



MICRO-D+ CONNECTORS
RECOMMENDED HOLE & WELD
PREP DIMENSIONS

"L" AND .315 ARE BASIC DIMENSIONS

CONNECTOR PART NO.	CONNECTOR # OF PINS	PIN STYLE	L
FA41500	9	STRAIGHT	.755 [19.18]
FA42164	9	SOLDER CUP	.755 [19.18]
FA42273	15	STRAIGHT	.905 [22.99]
FA42467	15	SOLDER CUP	.905 [22.99]

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

- SEE SHEET 1 FOR TIG WELDING INSTRUCTIONS -

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REV.	APP'D	DATE	SCALE 2:1	DIMENSIONS IN INCHES [mm]	DRAWN	CW	7/19/2021	NUMBER:	NS41500
A	JF	07/22/2021	NSPRT005-01		ENG APPR.	JF	07/22/2021	REV:	
								A	SHEET 2 OF 2