

INSTALLATION WELDING OPTIONS

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

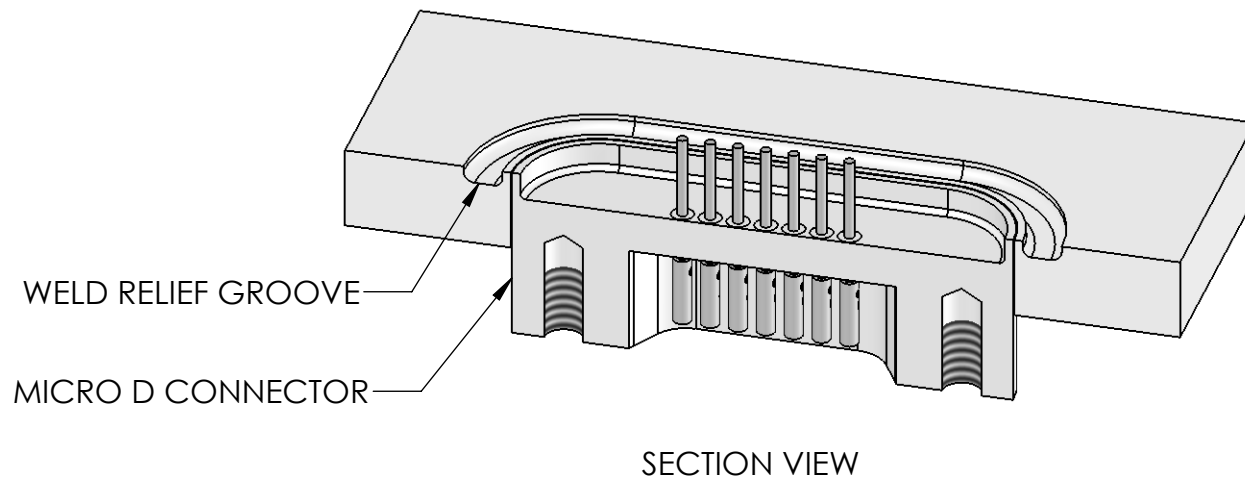
MATING HARDWARE DIMENSIONS/ CONFIGURATION

SEE SHEET 2 OF THIS INSTRUCTION SHEET.
 HARDWARE SHOULD BE 304L OR 316L STAINLESS STEEL.
 PREFERRED ORIENTATION IS WITH THE WELD ON THE VACUUM SIDE.

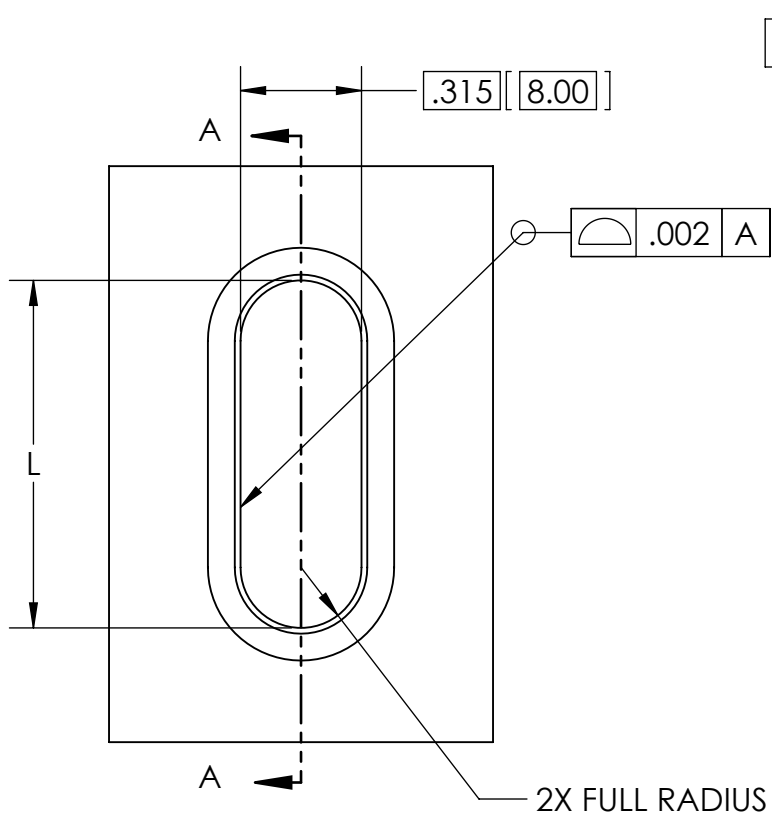
MICRO D CONNECTORS WELDING INSTRUCTIONS

PULSED TIG WELD PROCEDURE

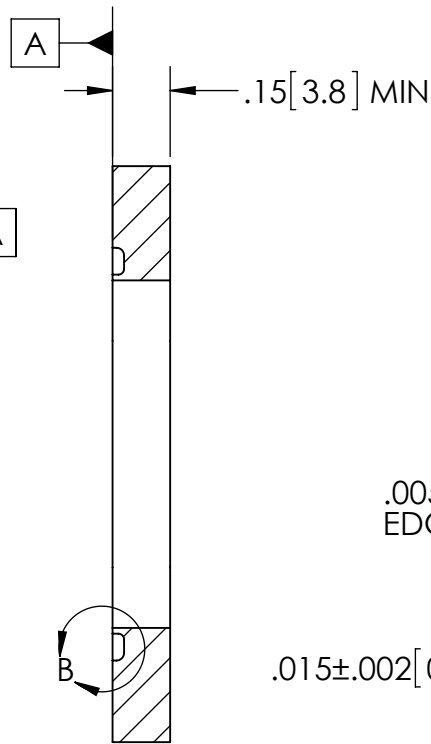
- 1- WELDER SETTINGS WILL VARY DEPENDING ON EQUIPMENT USED
- 2- TACK WELD EQUALLY SPACED AROUND THE CONNECTOR BEFORE WELDING CONTINUOUS
- 3- WELD TRAVEL SPEED SHOULD BE OPTIMIZED TO REDUCE HEAT INPUT
- 4- OPPOSITE SIDE OF HEADER SHOULD BE FLOODED WITH INERT GAS FOR EXTRA COOLING AND TO MINIMIZE OXIDATION



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REV.	APP'D	DATE	SCALE 3:1	DIMENSIONS IN INCHES [mm]	DRAWN	JF	08/12/2015	NUMBER:	NS24182	REV:	A	SOLID SEALING TECHNOLOGY, INC. SHEET 1 OF 2
A	JF	08/12/2015	NS24182-11		ENG APPR.	JF	08/12/2015					

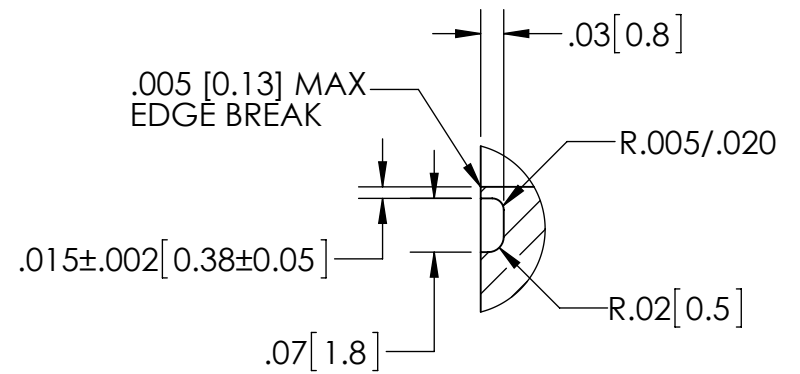


"L" AND .315 ARE BASIC DIMENSIONS



SECTION A-A

MICRO D CONNECTORS
RECOMMENDED
HOLE & WELD PREP
DIMENSIONS



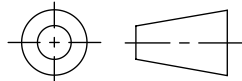
DETAIL B
SCALE 4 : 1

CONNECTOR PART NO.	CONNECTOR # OF PINS	L
FA26701	9	.755 [19.18]
FA24182	15	.905 [22.99]
FA26702	25	1.155 [29.34]
FA26703	37	1.455 [36.96]

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THIRD ANGLE PROJECTION



TITLE: INSTRUCTION SHEET
MICRO D WELDING



REV.	APP'D	DATE	SCALE 2:1	DIMENSIONS IN INCHES [mm]	DRAWN	JF	08/12/2015
A	JF	08/12/2015	NS24182-12		ENG APPR.	JF	08/12/2015

NUMBER: NS24182

REV: A

SOLID SEALING TECHNOLOGY, INC.
SHEET 2 OF 2