

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.

PULSED TIG WELD PROCEDURE

1- TYPICAL WELDER SETTINGS

BACKGROUND CURRENT: FIXED AT 1/3-1/2 OF PEAK CURRENT

(eg. 8.3 -12.5 AMPS @ 25 AMPS)

CURRENT SETTING: 25 TO 30 AMPS

PULSE FREQUENCY: 25-30 Hz

PULSE WIDTH FIXED AT 50%

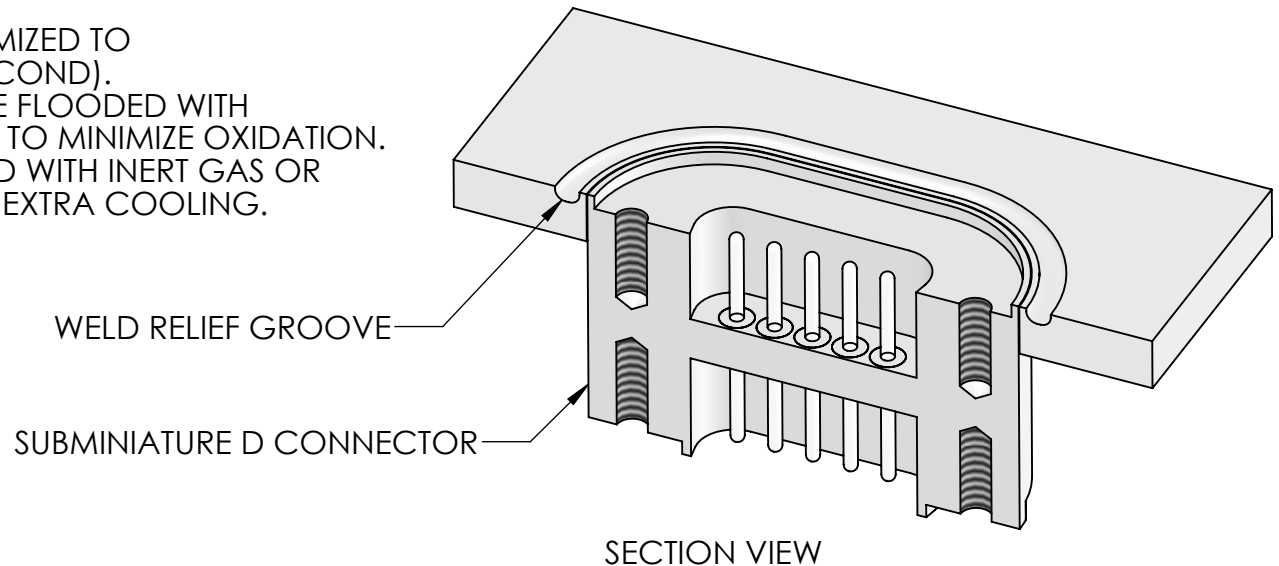
2- TACK WELD 4 PLACES (6 PLACES ON 50 PIN) EQUALLY SPACED AROUND THE CONNECTOR.

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

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

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

SUB-D CONNECTORS WELDING INSTRUCTIONS

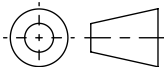


- SEE SHEET 2 FOR HOLE DIMENSIONS -

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THIRD ANGLE
PROJECTION



TITLE:

INSTRUCTION SHEET
MIL-C-24308 WELDING



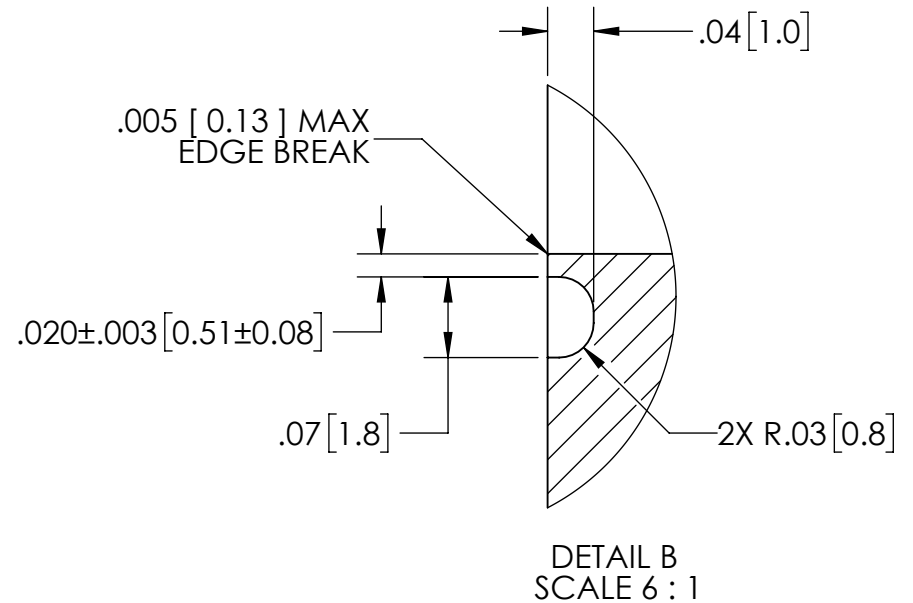
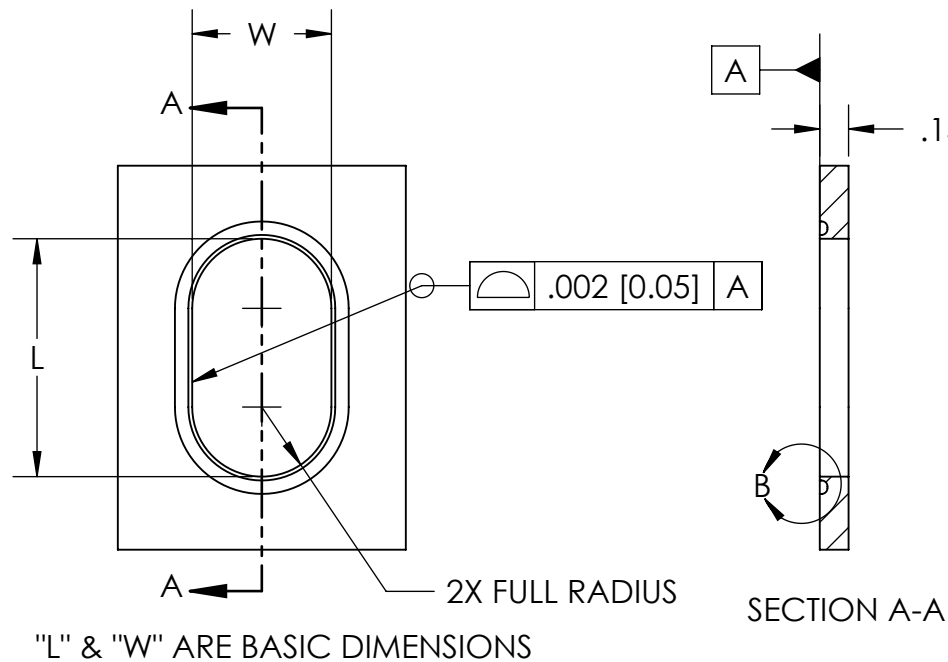
**SOLID SEALING
TECHNOLOGY**

REV.	APP'D	DATE	SCALE 1:0.4	DIMENSIONS IN INCHES [mm]	DRAWN	MH	06/07/2006	NUMBER:
F	CW	7/22/2021	NS13118-01X1		ENG APPR.	OG	06/09/2006	NS13118

REV:

F

SHEET 1 OF 2



SUB-D CONNECTORS RECOMMENDED
HOLE & WELD PREP DIMENSIONS

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

CONNECTOR PART NO.	CONNECTOR # OF PINS	L	W
FA13118	9	1.239 [31.47]	0.725 [18.42]
FA42763	15 HD	1.239 [31.47]	
FA13119	15	1.567 [39.80]	
FA26041	26 HD	1.567 [39.80]	
FA13121	25	2.107 [53.52]	
FA16702	37	2.743 [69.67]	0.837 [21.26]
FA13122	50	2.743 [69.67]	
FA16640	62 HD	2.743 [69.67]	

- SEE SHEET 1 FOR TIG WELDING INSTRUCTIONS -

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REV.	APP'D	DATE	SCALE 1:1	DIMENSIONS IN INCHES [mm]	DRAWN	MH	06/07/2006	NUMBER:	NS13118
F	CW	7/22/2021	NSPRT001-01		ENG APPR.	OG	06/09/2006	REV:	
								SHEET 2 OF 2	