

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 1/2 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.

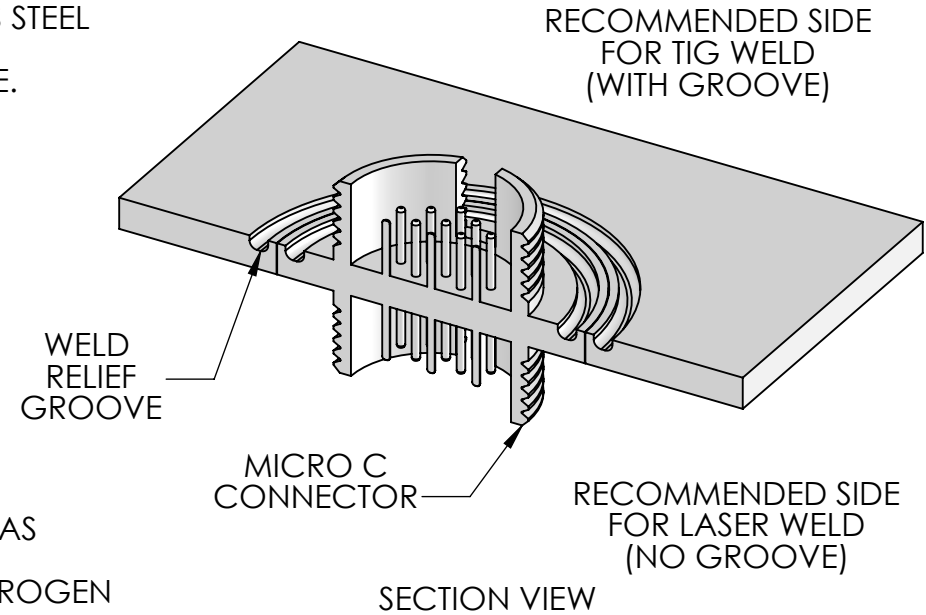
3- TACK WELD IN ACCORDANCE WITH THE TABLE BELOW.

4- TIG WELD BETWEEN THE TACK WELDS AT A SPEED SUFFICIENT TO COMPLETE THE SEGMENT IN A TIME OF 3 TO 4 SECONDS. DO NOT EXCEED 4 SECONDS.

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.

MICRO C CONNECTORS WELDING INSTRUCTIONS



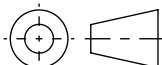
CONNECTOR # OF PINS:	3	7	19	55
DISTANCE BETWEEN TACK WELDS	LASER WELD ONLY	1/2" - 5/8"	1/2" - 5/8"	1/2" - 5/8"
# OF WELDS		4	4	6

- SEE SHEET 2 FOR HOLE DIMENSIONS -

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THIRD ANGLE PROJECTION



TITLE:

INSTRUCTION SHEET
MICRO CIRCULAR WELDING



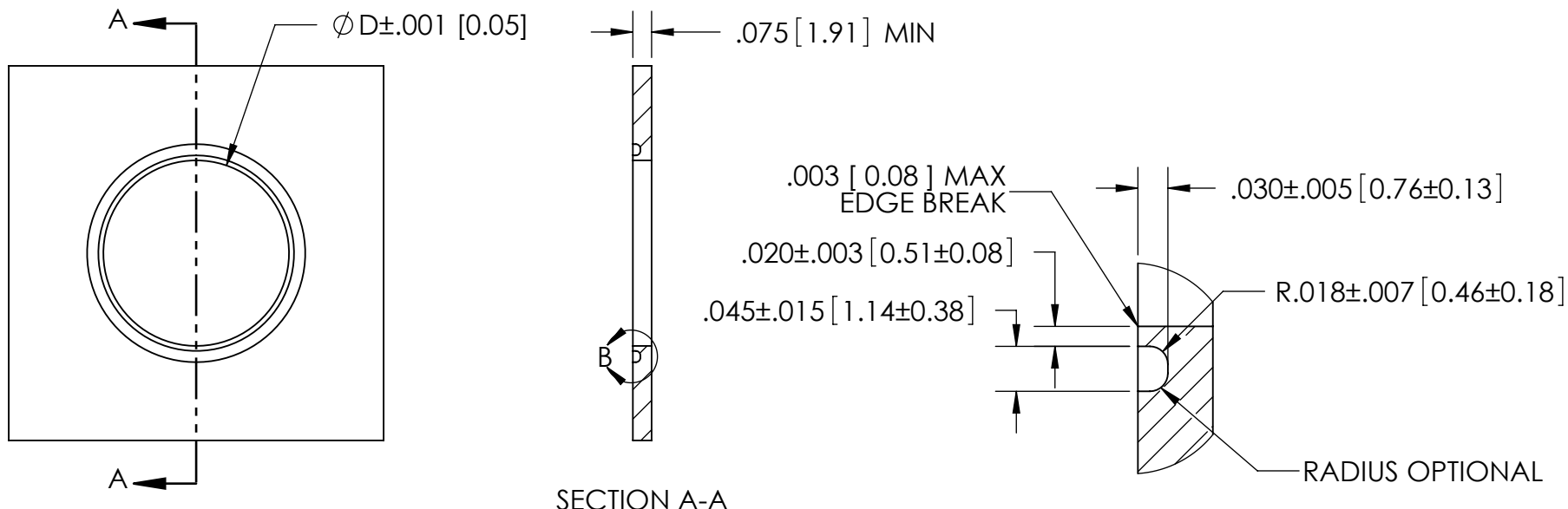
SOLID SEALING
TECHNOLOGY

REV.	APP'D	DATE	SCALE 2.5:1	DIMENSIONS IN INCHES [mm]	DRAWN	CW	7/16/2021	NUMBER:
D	JF	07/05/2024	NSASM003-11		ENG APPR.	JF	7/16/2021	NS41401

REV:

D

SHEET 1 OF 2



DETAIL B
SCALE 6 : 1

CONNECTOR PART NUMBER	CONNECTOR # OF PINS	ϕD
FA42916	3	.340 [8.64]
FA41283	7	.589 [14.96]
FA41401	19	.743 [18.87]
FA42250	55	.982 [24.94]

MICRO-C 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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REV.	APP'D	DATE	SCALE 1.5:1	DIMENSIONS IN INCHES [mm]	DRAWN	CW	7/16/2021	NUMBER:	NS41401	REV:	D	SHEET 2 OF 2
D	JF	07/05/2024	NSPRT002-12		ENG APPR.	JF	7/16/2021					