

INSTALLATION WELDING OPTIONS

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

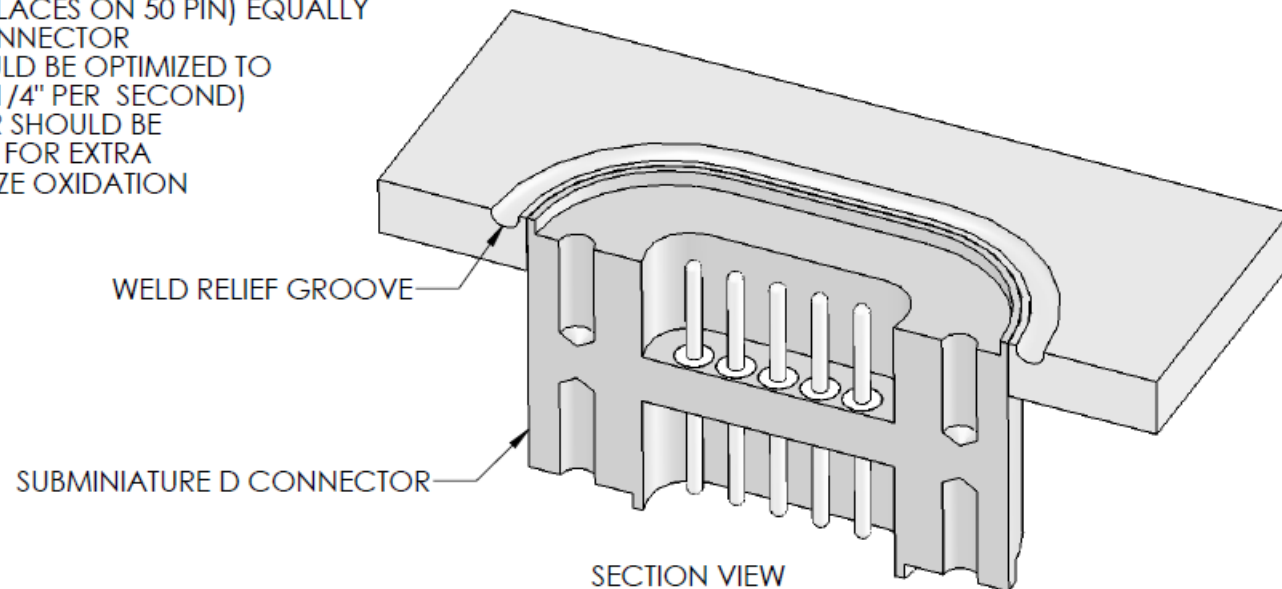
MATING HARDWARE DIMENSIONS/ CONFIGURATION

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

PULSED TIG WELD PROCEDURE

- 1- TYPICAL WELDER SETTINGS
BACKGROUND CURRENT: FIXED AT 1/5 OF PEAK CURRENT
(eg. 5amps @ 25amps)
CURRENT SETTING: 25 TO 30 AMPS
PULSE FREQUENCY: 400Hz
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. 1/4" PER SECOND)
- 4- OPPOSITE SIDE OF HEADER SHOULD BE FLOODED WITH INERT GAS FOR EXTRA COOLING AND TO MINIMIZE OXIDATION

SUB-D CONNECTORS WELDING INSTRUCTIONS



vaqtec
vacuum technology & components

MIL-C-24308 D-type welding instruction

Not scale drawing

Sheet 1 of 2

Date: 10/02/2011

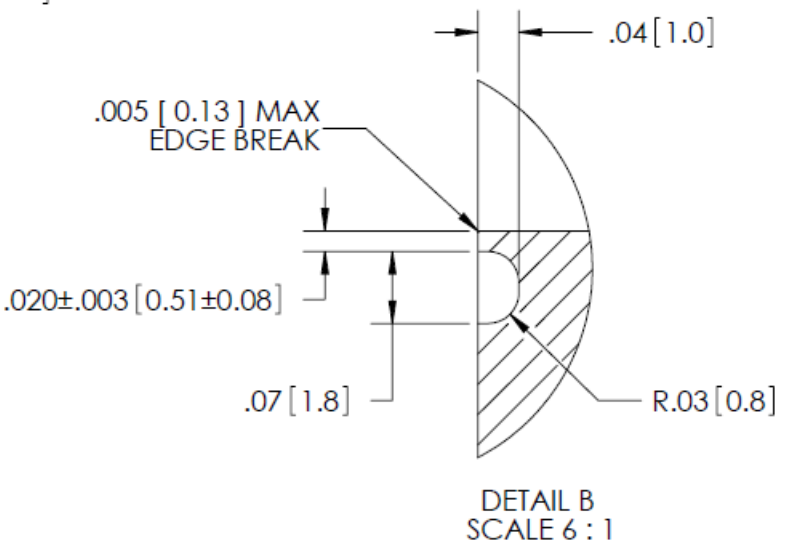
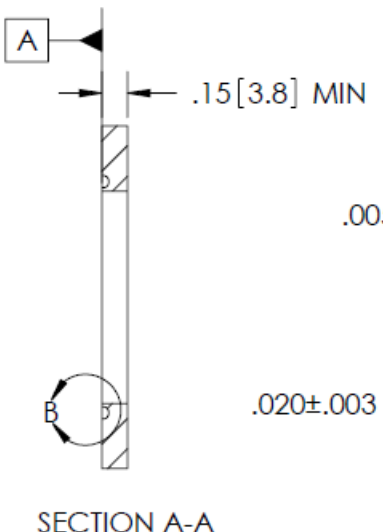
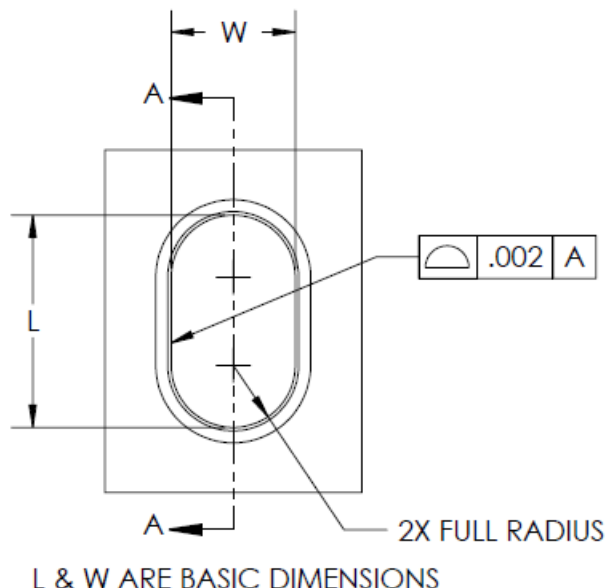
Revision: 0.0

Dimensions: IN (mm)

Number:

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CONNECTOR PART NO.	CONNECTOR # OF PINS	L	W
1-MP-5000	9	1.239 [31.47]	0.725 [18.42]
1-MP-5001	15	1.567 [39.80]	0.725 [18.42]
1-MP-5002	25	2.107 [53.52]	0.725 [18.42]
1-MP-5005	50	2.743 [69.67]	0.837 [21.26]
1-MP-5010	62	2.743 [69.67]	0.725 [18.42]

**SUB-D CONNECTORS
RECOMMENDED
HOLE & WELD PREP
DIMENSIONS**



MIL-C-24308 D-type welding instruction

Not scale drawing

Sheet 2 of 2

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