

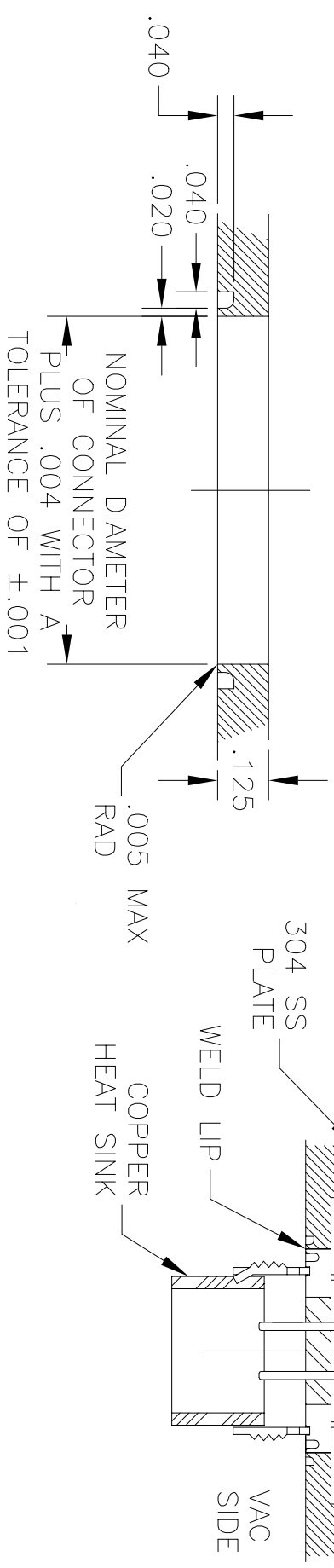
INSTALLATION METHODS IN ORDER OF PREFERENCE:		REV.	DESCRIPTION	APP'D	DATE
1.	E.B. WELDING OR LASER WELDING	2	CONNECTOR WELD PREP REDESIGN	DES	10/19/01
2.	PULSED TIG WELDING				
3.	PLASMA WELDING				
4.	TIG WELDING				

FLANGE CONFIGURATION / DIMENSIONS:

- FLANGE MATERIAL SHOULD BE 304 SS
- BEST ORIENTATION IS WITH WELD LOCATION ON THE VACUUM SIDE

PULSED TIG WELD PROCEDURE:

- TYPICAL WELD SETTINGS:
 - CURRENT SETTING - 20-28 AMPS
 - BACKGROUND CURRENT - FIXED AT 1/5 OF PEAK CURRENT (eg. 5.6A @28A)
 - PULSE FREQUENCY - 350-400 hz.
 - PULSE WIDTH FIXED AT 50%.
 - YIELDED WELD CURRENT SHOULD BE LESS THAN 10 AMPS
- COPPER HEAT SINK SHOULD BE USED TO DRAW EXCESS HEAT AWAY FROM GLASS-CERAMIC SEAL AREAS
- WELD TRAVEL SPEED SHOULD BE MAXIMIZED TO REDUCE HEAT INPUT. (ie. CLOSE INITIAL GAP AND GET MOVING) EACH CONNECTOR SHOULD BE WELDED IN UNDER 10 sec.



TITLE:		DRAWN: MH		SCALE: 1 1/4x		DRAWING No.		REV.	
CERAMASEAL MS CONNECTOR		CHECK: DES		DATE: 05/21/99		INSMSCONN		2	
HEADER INSTALLATION METHOD		REF:						10/19/01	

CERAMASEAL NEW LEBANON CENTER NEW YORK U.S.A. DIVISION Of CeramTec