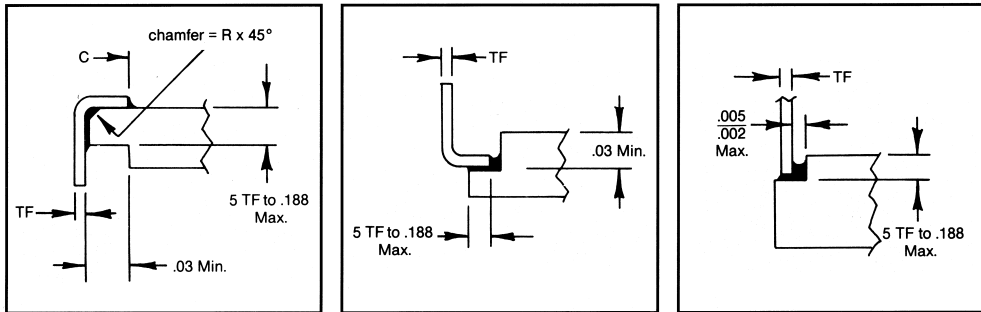
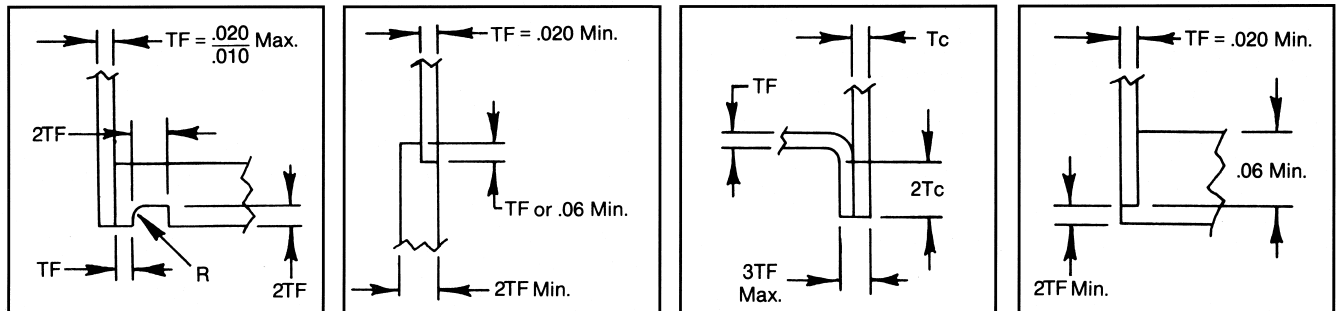


### BRAZE/SOLDER

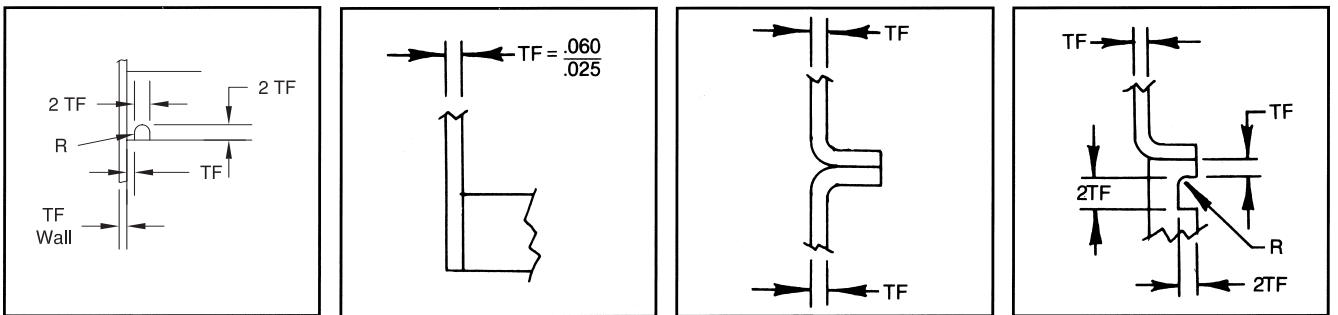


TF = Flange Thickness — Units with copper, copper nickel, nickel iron and Kovar can be soldered.  
 C = Flange-Flat Diameter — Units with nickel, copper-nickel, nickel-iron, Kovar and stainless steel can be brazed.  
 — Fit up to be at solder or braze temperature. Refer to thermal expansion curves on pages L4.

### WELD



TF = Flange Thickness R = TF Tc = Mating Part Thickness



When welding components, the weld should be made on the vacuum side of the system to prevent virtual leaks from small spaces or gaps where the components mate. If both sides of the components need to be welded for strength, the vacuum side should be welded continuously and the welds on the outside of the system should be welded intermittently. All dimensions are in inches.