REV.	DESCRIPTION	APP'D	DATE
A	UPDATED	OG	08/06/03

INSTALLATION METHODS IN ORDER OF PREFERENCE:

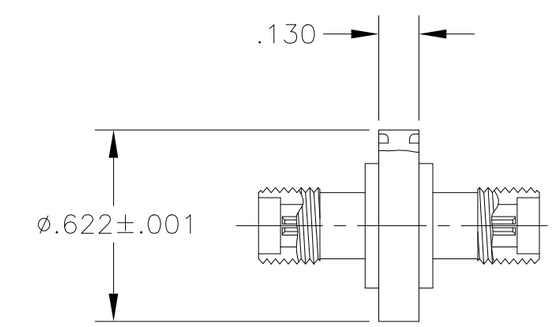
1. E.B. WELDING AND OR LASER WELDING
2. PULSED TIG WELDING
3. PLASMA WELDING
4. STRAIGHT TIG WELDING

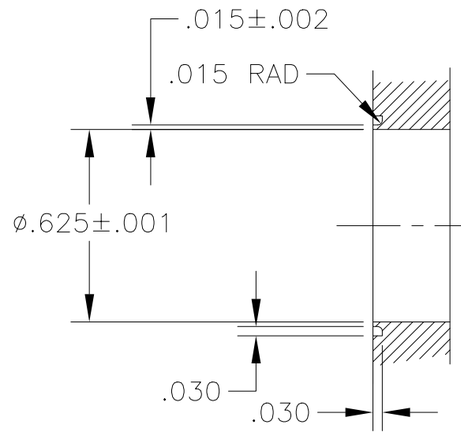
FLANGE CONFIGURATION / DIMENSIONS:

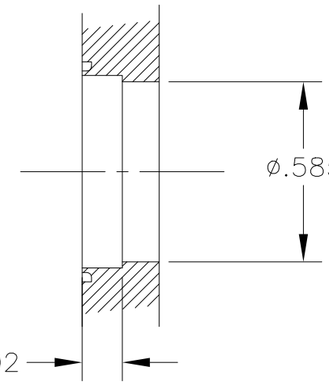
- FLANGE MATERIAL SHOULD BE 304 SS
- BEST ORIENTATION IS WITH WELD LOCATION ON THE VACUUM SIDE

PULSED TIG WELD PROCEDURE:

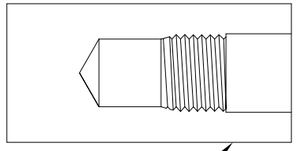
- TYPICAL WELD SETTINGS:
  - CURRENT SETTING – 15–20 AMPS
  - PULSE FREQUENCY – 400 hz.
  - YIELDED WELD CURRENT SHOULD BE LESS THAN 10 AMPS
- COPPER HEAT SINK SHOULD BE USED TO DRAW EXCESS HEAT AWAY FROM GLASS–CERAMIC SEAL AREAS
- WELD TRAVEL SPEED SHOULD BE MAXIMIZED TO REDUCE HEAT INPUT.(ie. CLOSE INITIAL GAP AND GET MOVING)

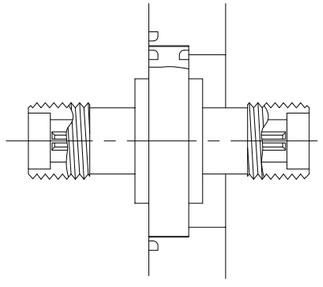






ALTERNATE CONFIGURATION





MATERIAL:		TITLE: CERAMASEAL SMA CONNECTOR INSTALLATION METHOD			**CeramTec** CeramTec North America Corporation Ceramaseal Division		
FINISH:	DO NOT SCALE DRAWING WORK TO DIMENSIONS ALL DIMENSIONS IN INCHES EXCEPT AS NOTED TOLERANCES APPLY UNLESS OTHERWISE SPECIFIED				SUPERSEDES:		SIMILAR TO:
PLATING:					DRAWN: MH	SCALE:	DRAWING No. INSSMA / REV. A
SPECIFICATION:	1 PLACE	2 PLACE	3 PLACE	ANGLES	CHECK: OG	DATE: 01/30/98	
USED ON:			±.005		REF:		08/06/03

INSSMA