

INSTALLATION WELDING OPTIONS:

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

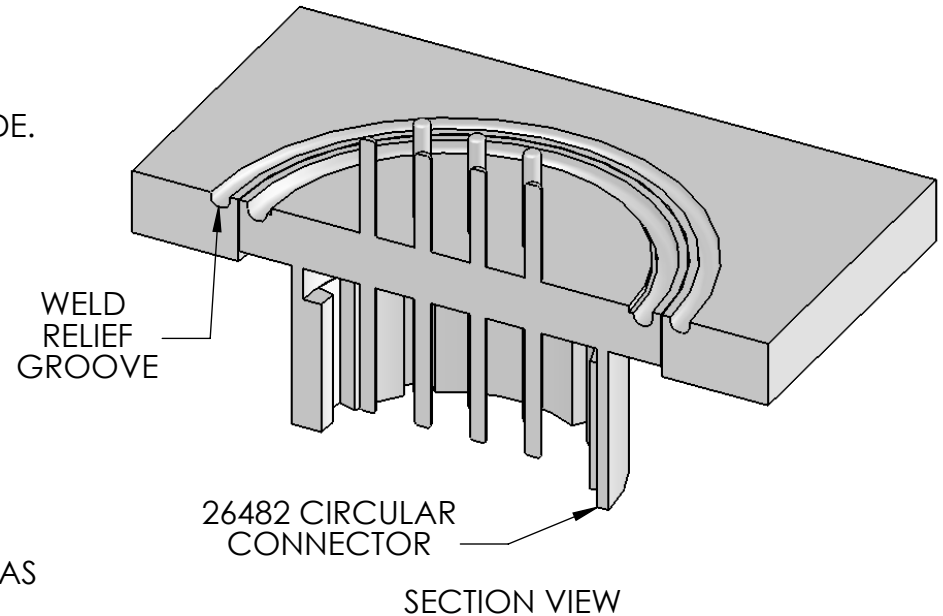
26482 CIRCULAR CONNECTORS WELDING INSTRUCTIONS

MATING HARDWARE DIMENSIONS/ CONFIGURATION:

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

PULSED TIG WELD PROCEDURE:

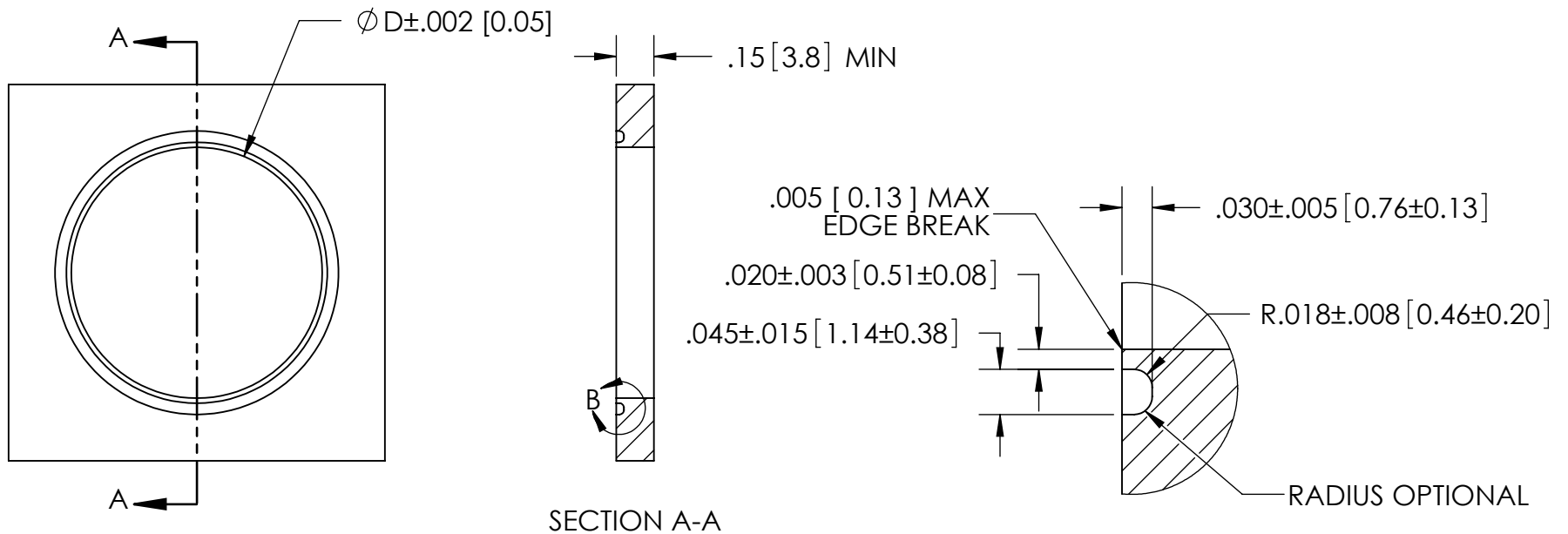
- 1- TYPICAL WELDER SETTINGS:
 - BACKGROUND CURRENT: FIXED AT 1/2 OF PEAK CURRENT
(eg. 10amps BACKGROUND, 20amps PEAK)
 - CURRENT SETTING: 20 TO 25 AMPS
 - PULSE FREQUENCY: 17.5 Hz
 - PULSE WIDTH FIXED AT 42%
- 2- USE A HEATSINK ON BOTH SIDES.
- 3- TACK WELD IN ACCORDANCE WITH THE TABLE BELOW.
- 4- TIG 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.



CONNECTOR # OF PINS:	3	6	10	19	32	41
DISTANCE BETWEEN TACK WELDS	1/2" - 5/8"	1/2" - 5/8"	1/2" - 5/8"	1/2" - 5/8"	1/2" - 5/8"	3/8" - 1/2"
# OF WELDS	4	5	6	6	7, 8	10-12

- SEE SHEET 2 FOR HOLE DIMENSIONS -

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REV.	APP'D	DATE	SCALE 2.5:1	DIMENSIONS IN INCHES [mm]	DRAWN	JS	10/15/2008	NUMBER:	NS13003	REV:	A	SOLID SEALING TECHNOLOGY, INC. SHEET 1 OF 2
A	OG	04/14/2009	NSASM002-11X1		ENG APPR.	OG	04/14/2009					



CONNECTOR # OF PINS	ϕD
3	.750 [19.05]
6	.875 [22.23]
10	1.000 [25.40]
19	1.125 [28.58]
32	1.375 [34.93]
41	1.500 [38.10]

MIL-C-26482 CONNECTORS
RECOMMENDED
HOLE & WELD PREP
DIMENSIONS

- SEE SHEET 1 FOR WELDING INSTRUCTIONS -

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A	OG	04/14/2009	NSPRT002-11		ENG APPR.	OG	04/14/2009						