

# SUB-D FEEDTHROUGH WELDING INSTRUCTIONS

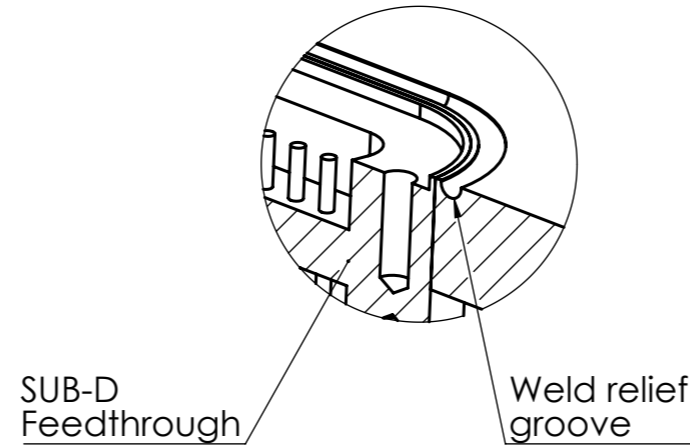
## MATING HARDWARE DIMENSIONS / CONFIGURATION

Hardware should be from AISI 304 or AISI 316 Stainless steel  
 Preferred orientation is with the weld on the Vacuum side

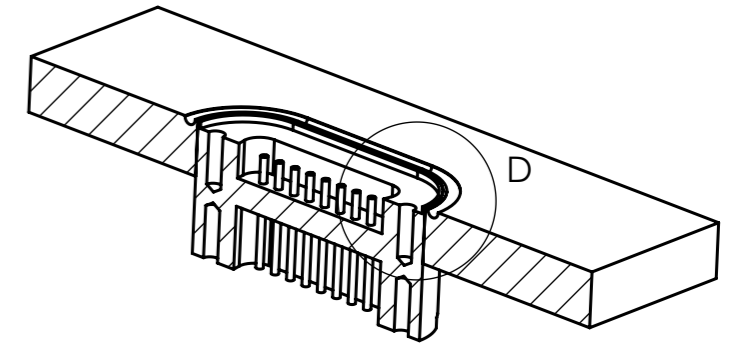
## TIG WELD PROCEDURE

- 1) Insert the feedthrough with some friction into the slot
- 2) Once in place, tack weld 4 places equally spaced around the feedthrough
- 3) TIG weld the complete feedthrough (in sections of 2 cm each section) at 25/30 A
- 4) Flood with inert gas to avoid thermal stress

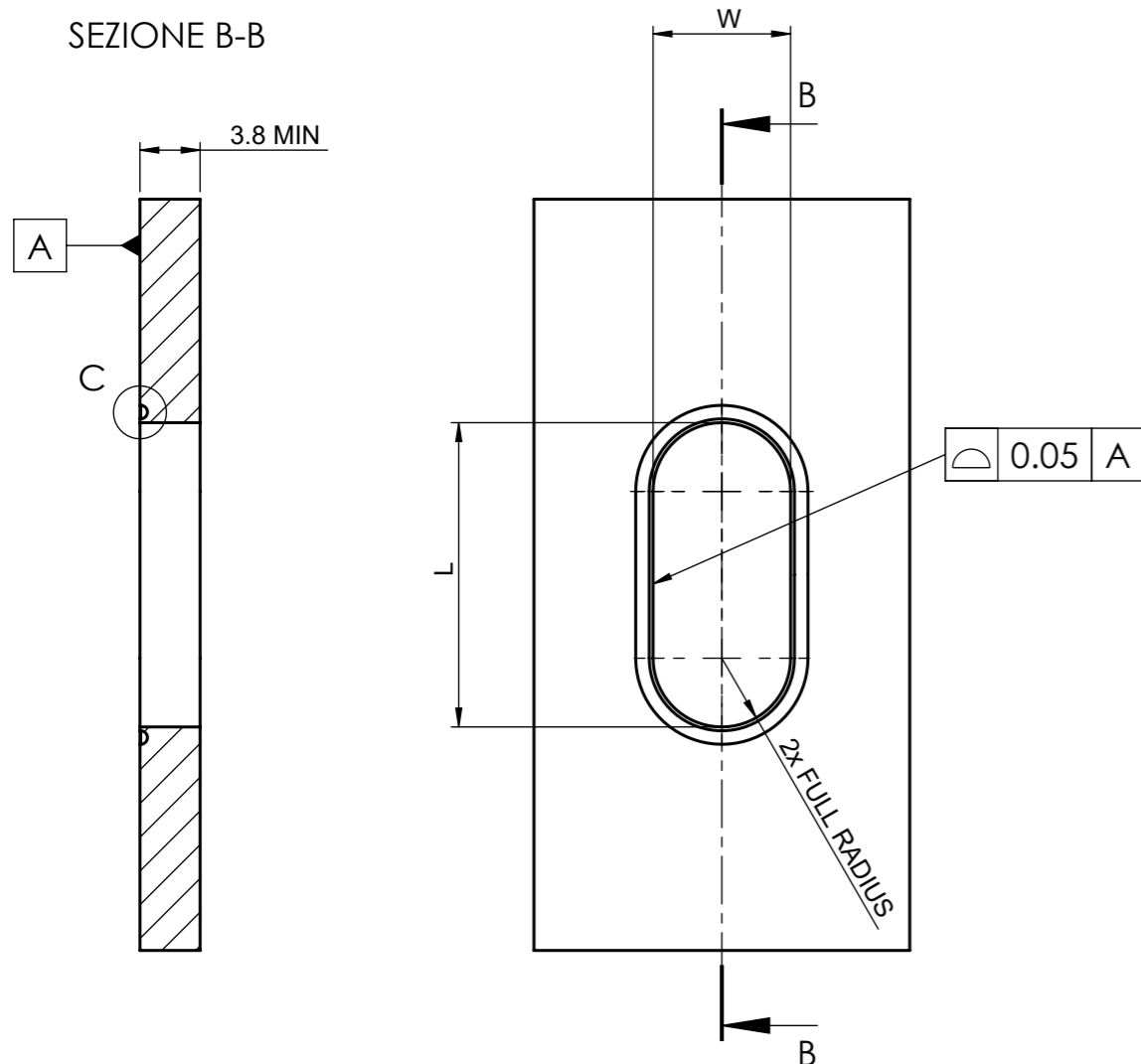
DETTAGLIO D  
SCALA 2 : 1



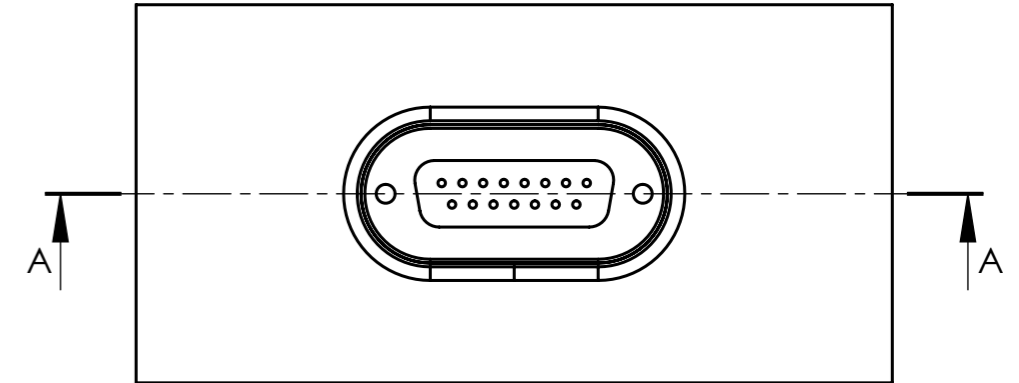
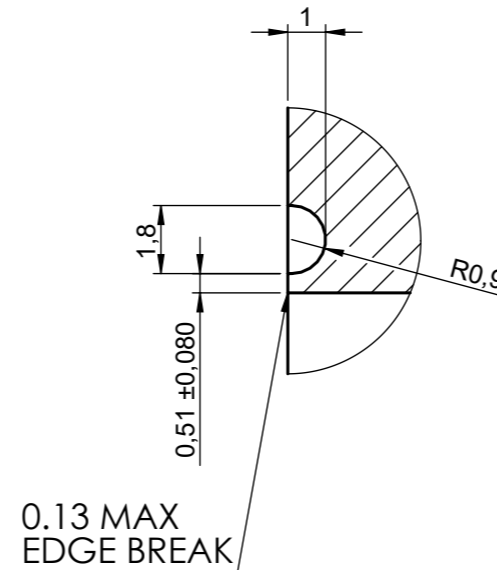
SEZIONE A-A



SEZIONE B-B



DETTAGLIO C  
SCALA 5 : 1



W and L are basic dimensions

Feedthrough part no.	Feedthrough # of pins	L	W <sup>+0</sup> <sub>-0.05</sub>
# 240009	9	31.3	18.3
# 240015	15	40.5	18.3
# 240025	25	53.6	18.3
# 240037	37	69.1	18.3

TREATMENT	DIMENSIONAL TOLERANCE					EDGE TOLERANCE						CONTROLLED BY	FORMAT	QUANTITY
	>0 50	>50 250	>250 800	>800 2000	>2000	0.2	0.2	0.2	0.2	0.2	0.2	VS	A3	
	±0.1	±0.2	±0.4	±0.8	±1.0	0.2	0.2	0.2	0.2	0.2	0.2	VS	A3	
	MATERIAL					WEIGHT (kg)	CHAMFER	Ra (um)		CREATED BY	SCALE	1:1		
						338.23	1x45°	N5 (0.4)		VS	PAGE	1 / 1		
ASSEMBLY	NOTE											REV.	DATE	
GROUP												A	20/05/2022	
DESCRIPTION											DRAWING			
WELDING INSTRUCTION SUB-D											VD0044317			

