

Ultrasonic Step Energy Director Joint Variation

Customer Name: _____ Date: _____

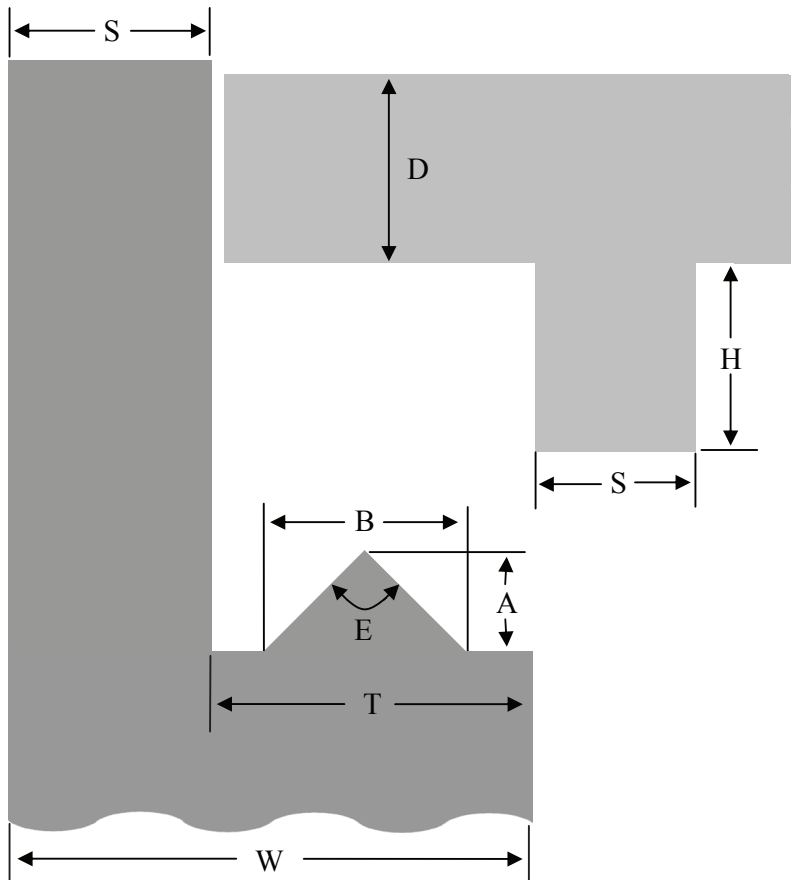
Application Number: _____ Revision: _____

Project: _____

Material: _____

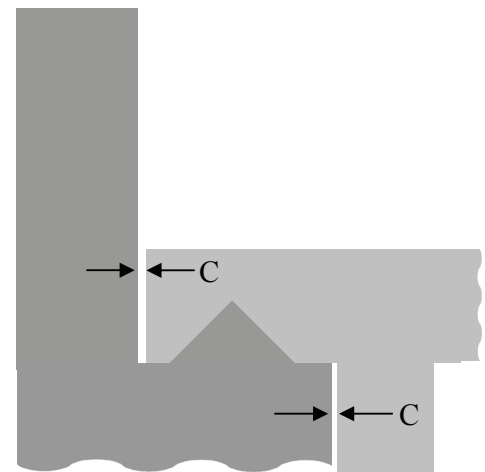
Prepared By: _____ Email: _____

	Dimension	General Guidelines	Recommended Size
W	Wall Thickness	Minimum 0.090" (2.29mm) and/or 4B	
B	Energy Director Base Width	0.006" - 0.030" (0.15mm - 0.76mm)	
A	Energy Director Height	B/2 or 0.866B	
T	Step Width	T+C	
H	Side Wall Height	2/3 W	
S	Side Wall Width	Minimum 0.035" (0.89mm)	
C	Clearance	0.002" to 0.004" (0.05mm - 0.10mm)	
D	Wall Thickness	Minimum 2B	
E	Energy Director Angle	60° or 90°	



The step energy director variation joint for ultrasonic welding is used to obtain a strong, leak tight weld on parts with a thin wall thickness, less than 0.050" (1.27mm).

This type of weld joint contains flash well and can produce a clean, strong weld.



Collapsed

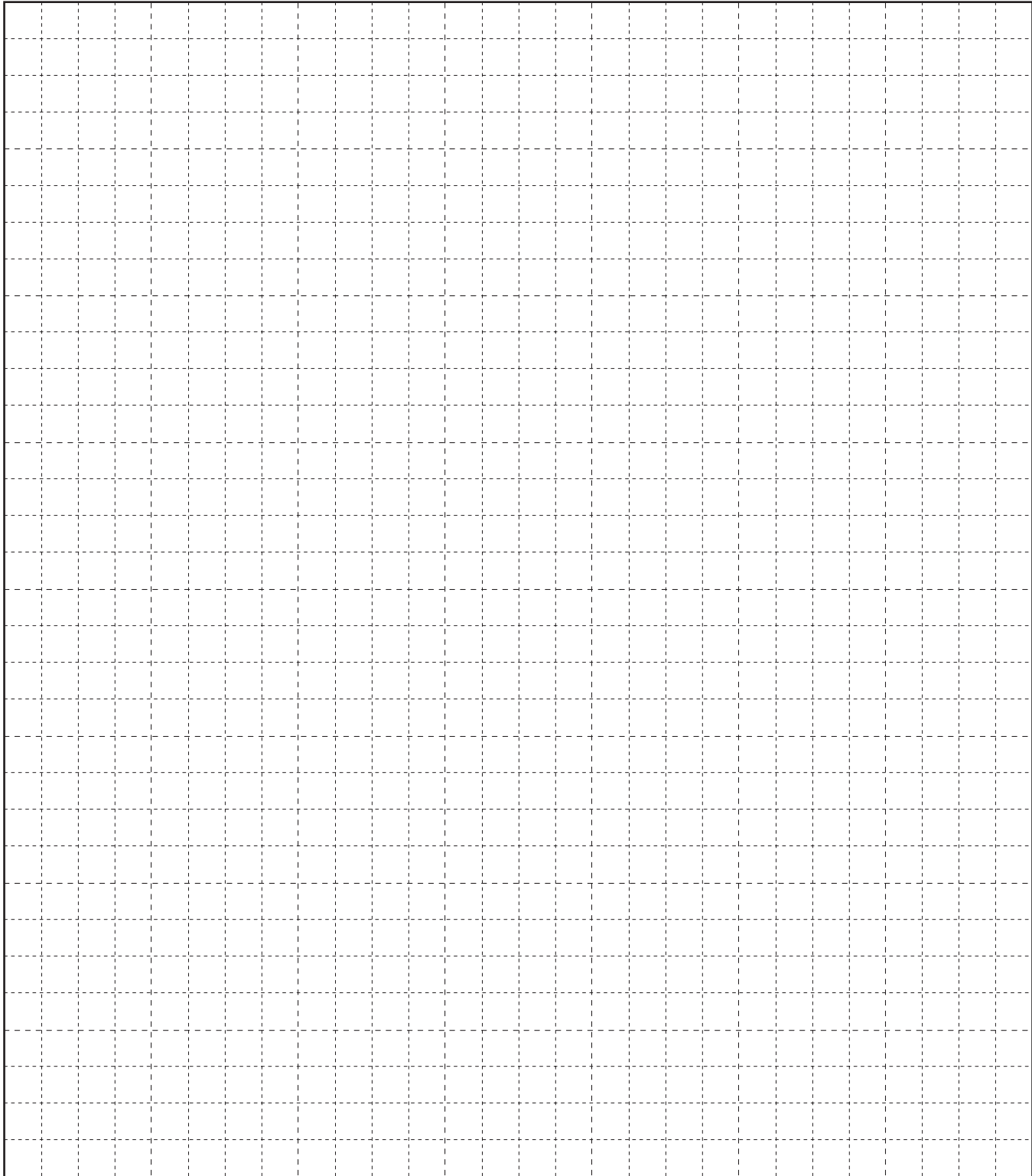
www.dukane.com/us • e-mail: ussales@dukane.com • us_caddata@dukane.com

Dukane Corporation • Ultrasonics Division • 2900 Dukane Drive • St. Charles, Illinois 60174 USA • TEL (630) 797-4900 • FAX (630) 797-4949

Note: All specifications are subject to change without notice. Please consult Dukane Ultrasonics for any updated information.

--

Part Name/Description



Use this grid to sketch the specific part design showing joint dimensions and location.