

Customer Name:

Application Number:

Project:

Material:

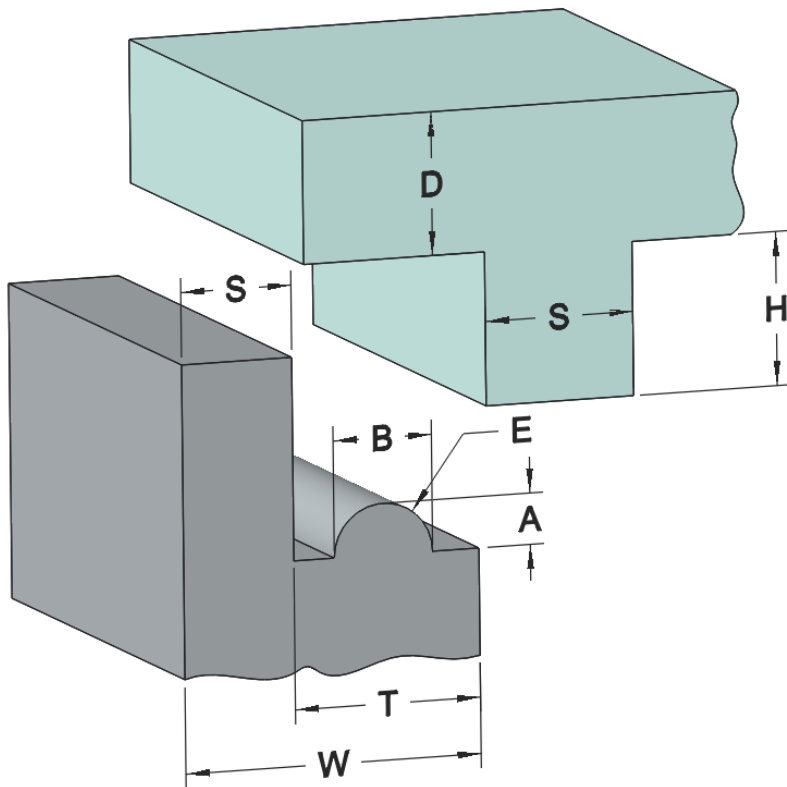
Prepared By:

Date:

Revision:

Email:

	Dimension	General Guidelines	Recommended Size
W	Wall Thickness	Minimum 0.090" (2.29mm) and/or 4B	
B	Energy Director Base Width	0.010" - 0.040" (0.25mm - 1.00mm)	
A	Energy Director Height	Less than or equal to B/2	
T	Step Width	2/3 W	
H	Side Wall Height	2/3 W	
S	Side Wall Width	Minimum 0.035" (0.89mm)	
C	Clearance	0.002" to 0.006" (0.05mm - 0.15mm)	
D	Wall Thickness	Minimum 2B	
E	Energy Director Radius	180° (Full)	



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. Performance evaluations of the round ED using Dukane's Ultrasonic Servo Welding Technology has confirmed that parts with this type of ED can be successfully welded with weld strength and consistency matching and even exceeding similar parts that have a 90-deg ED

