

Customer Name:

Application Number:

Project:

Material:

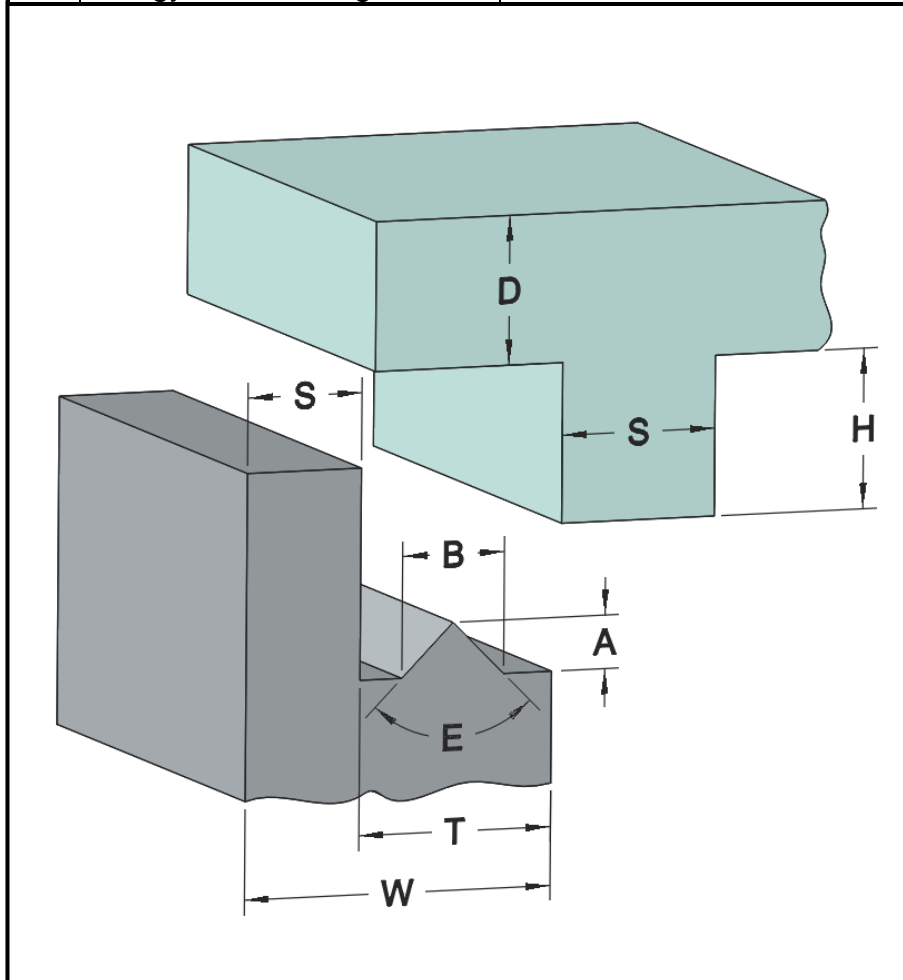
Prepared By:

Date:

Revision:

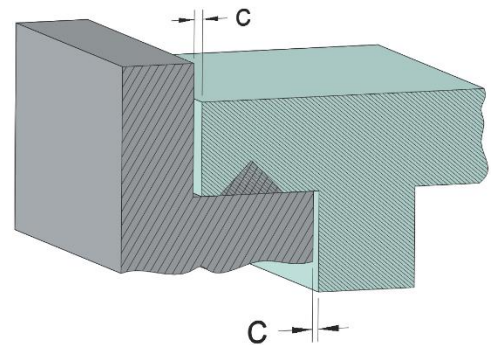
Email:

	Dimension	General Guidelines	Recommended Size
W	Wall Thickness	Minimum 0.090" (2.29mm) and/or 4B	
B	Energy Director Base Width	0.006" - 0.030" (0.15mm - 0.76mm)	
A	Energy Director Height	B/2 or 0.866B	
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 0.004" (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