

Customer Name:

Application Number:

Project:

Material:

Prepared By:

Date:

Revision:

Email:

	Dimension	General Guidelines	Recommended Size
W	Wall Thickness	Minimum 0.060" (1.52mm) 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	Energy Director Wall Width	2/3 W	
H	Energy Director Wall Height	2/3 W	
G	Step Width	T + C	
D	Step Depth	H + 0.001" (0.03mm)	
S	Step Side Wall Width	Minimum 0.035" (0.89mm)	
C	Clearance	0.002" to 0.004" (0.05mm - 0.10mm)	
E	Energy Director Angle	60° or 90°	

The step energy director joint for ultrasonic welding is used to obtain a strong and sometimes leak tight weld.

This type of weld joint contains melt well on one side for parts where flash is acceptable on one side of the joint but not on the other.

Collapsed