

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 | Tongue Width | W/3 | |
| H | Tongue Height | W/3 | |
| G | Groove Width | T + 2C | |
| D | Groove Depth | H + 0.001" (0.03mm) | |
| S | Groove 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° | |

Horn Side

Fixture Side

The tongue and groove energy director joint for ultrasonic welding is used to obtain a strong, leak tight weld.

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

Collapsed