

Customer Name:

Application Number:

Project:

Material:

Prepared By:

Date:

Revision:

Email:

	Location Description	General Dimensional Guidelines	Recommendations
W	Wall Thickness	Minimum 0.060" (1.52mm) 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	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" (H + 0.03mm)	
S	Step Side Wall Width	Minimum 0.035" (0.89mm)	
C	Clearance	0.002" to 0.006" (0.05mm - 0.15mm)	
E	Energy Director Radius	180° (Full)	

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.

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.

Collapsed