

WHAT IS THIS REFERENCE GUIDE FOR?

Litron's Laser Welding Guideline manual is meant for those customers who are looking for assistance with how to engineer a part to be as weld friendly as possible.

The following pages give a brief overview of each weld as well as a diagram to further illustrate each type.

Upon reviewing these guidelines, please don't hesitate to call or email Litron with any questions regarding your component. We are always happy to assist in the design and development of parts to ensure the best possible weld.

These guidelines are meant as general best practices, and certain parts or projects may require further discovery. If you're not sure about your part please feel free to call or email Litron to discuss.

Laser Services

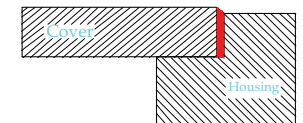
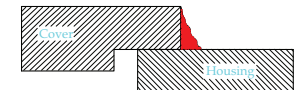
Laser Systems

Hermetic Services

Electronic Packaging

L I T R O N

Laser Welding Guidelines



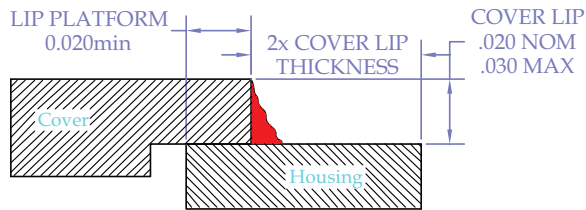
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Fillet Weld

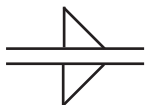


General Description:

A fillet weld is the easiest type of weld to produce. It's typically done at a reasonable cost, and is the easiest to de-lid.

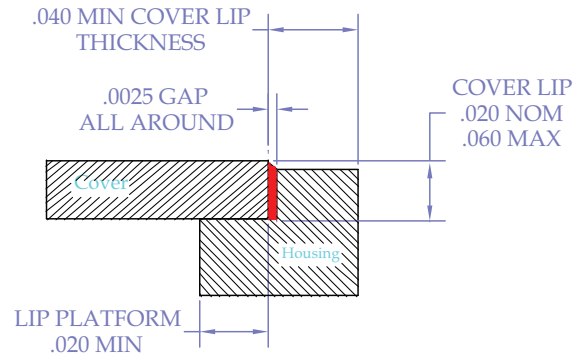
Specifications:

LIP PLATFORM	0.020 MIN
COVER LIP THICKNESS	0.020 NOM 0.030 MAX
FROM LID TO EDGE OF PACKAGING	2x COVER LIP



Typical Symbol for Fillet Weld

Butt Weld



General Description:

The butt weld is typically done at a higher cost, and is more difficult to de-lid.

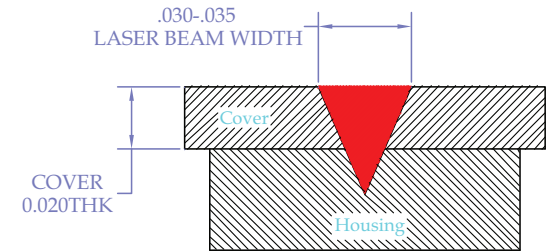
Specifications:

LIP PLATFORM	0.020 MIN
COVER LIP	0.020 NOM 0.060 MAX
FROM LID TO EDGE OF PACKAGING	0.040 MIN
ALL AROUND GAP	0.0025 MAX



Typical Symbol for Butt Weld

Penetration Weld

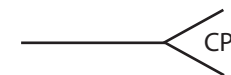


General Description:

The penetration weld is the strongest weld, but least likely to guarantee a hermetic seal.

Specifications:

LASER BEAM WIDTH	0.030-0.035
COVER	0.020 THICK



Typical Symbol for Penetration Weld