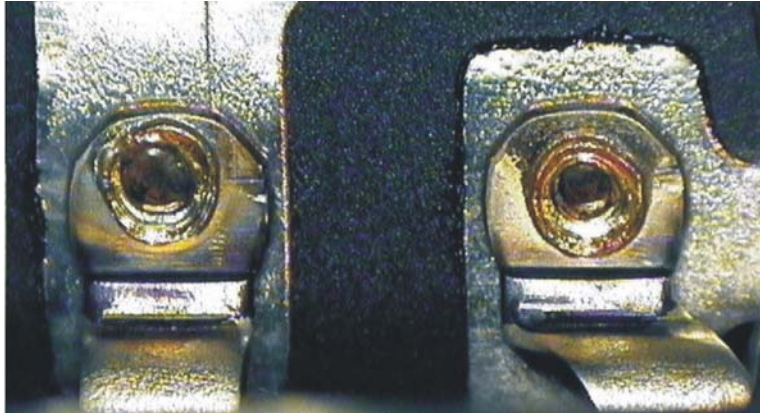


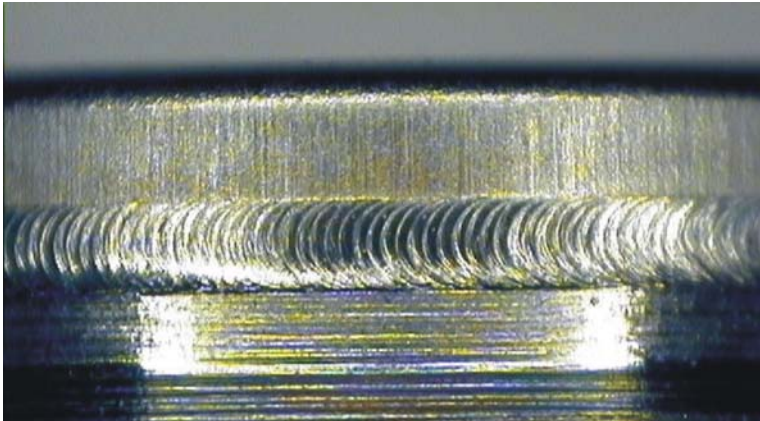
Miyachi Unitek Lasers

Welding Applications

LW50A & 70A welders



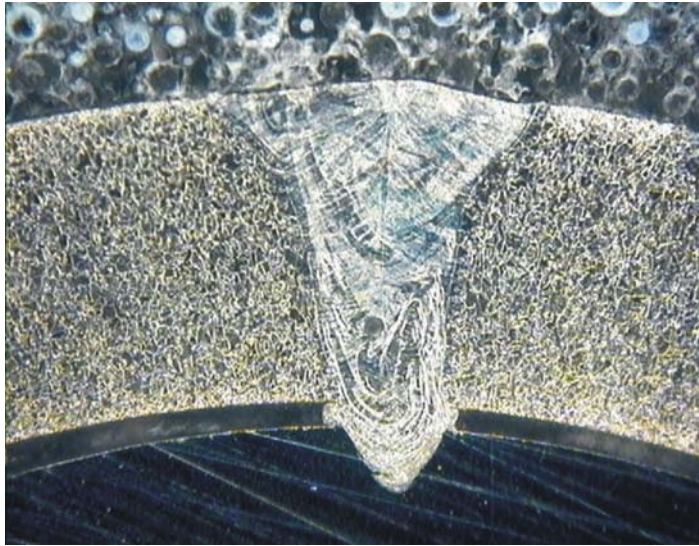
| | |
|--------------------|-------------------|
| Application | Relay tab weld |
| Laser | LW70A |
| Materials | Tin coated copper |
| Weld type | Lap |
| Focus head | CCTV 120/100 FX |
| Fiber | 600 SI |
| Penetration | 0.02" |
| Spot size | 0.02" |
| Pulse width | 11.0 ms |
| Energy | 53 J |
| Gas shroud | Argon |



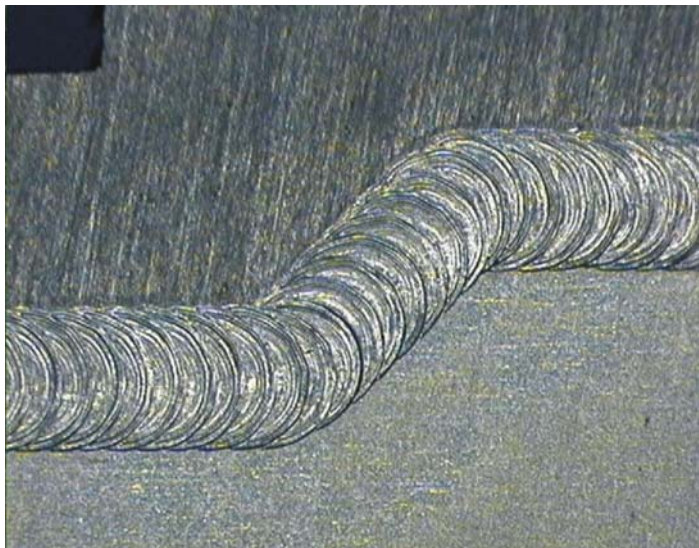
| | |
|--------------------|------------|
| Application | Lid Attach |
| Laser | LW70A |
| Materials | 304 SS |
| Weld type | Seam lap |
| Focus head | CCTV 70mm |
| Fiber | 600 SI |
| Penetration | 0.01" |
| Spot Size | 0.025" |
| Pulse width | 3.5 ms |
| Energy | 2.8 J |
| Rep rate | 25 Hz |
| Gas shroud | Argon |



| | |
|--------------------|--------------------------|
| Application | Solar conductor attach |
| Laser | LW70A |
| Materials | Tin coated copper to 430 |
| Weld type | Spot |
| Focus head | CCTV 100/100 H FX |
| Fiber | 600 SI |
| Penetration | 0.008" |
| Spot Size | 0.02" |
| Pulse width | 5.0 ms |
| Energy | 7 J |



| | |
|--------------------|------------------|
| Application | Tube attach |
| Laser | LW50A |
| Materials | Invar and 304 SS |
| Weld type | Lap |
| Focus head | CCTV 100mm |
| Fiber | 300 SI |
| Penetration | 0.03" |
| Spot size | 0.015" |
| Pulse width | 3.5 ms |
| Energy | 4 J |
| Gas shroud | None |



| | |
|--------------------|----------------|
| Application | Diaphragm seal |
| Laser | LW50A |
| Materials | 304 SS |
| Weld type | Seam butt |
| Focus head | CCTV 100mm |
| Fiber | 600 SI |
| Penetration | 0.015 |
| Spot size | 0.03" |
| Pulse width | 2 ms |
| Rep rate | 20 Hz |
| Energy | 1.5 J |
| Gas shroud | Argon |