

Sub-D Feedthroughs, weldable versions

Allectra offers Sub-miniature D feedthroughs also as weldable versions..
Nevertheless, these types are more difficult to weld than circular feethroughs.

Dimensions:

All sizes require a slit of width „A“, which is terminated by a full radius. The total slit length is „B“.
The height of all Sub-D feedthroughs is 17mm.
The gap between feedthrough and flange should be as small as possible (5/100 mm or less)

Type	Width A (mm)	Length B (mm)
9-Pin	14,5	33,0
15-Pin / 26 Pin HD	16,5	38,0
25-Pin	19,0	55,0
37-Pin	19,0	70,0
50-Pin / 72 Pin HD	19,0	68,0
25-Pin Special version	16,5	42,0
9-Pin Special version	∅ 40	(KF25)



All weldable types have a weld prep on the vacuum side.
All weldable feedthroughs are tested to a leak rate $< 1 \times 10^{-9}$ mbar /l s He.

Important: Avoid overheating during the weld process. The temperature gradient should not exceed 20 - 25K /min.

Welding in the feedthrough in several steps / segments is recommended.
The area of welding must be clean, grinding the area prior to welding is recommended.

Allectra recommends TIG welding without filler. Laser beam welding or electron beam welding is possible as well.
Please be aware, that damage caused by welding is not covered by the warranty.

Allectra offers the manufacturing of special assemblies according your requirements. !
Examples:



ISO400 with Threads and 9 Feedthroughs



3x 50 Pin and 40CF on 160CF Flange



40CF with 9-pin Sub-D and SMA Floating shield



14 x 15-pin Sub-D on 160CF Flange