

DELIVERY SPECIFICATION

ORIGIN Parallel Seam Sealer
MODEL OS-20S-2127

- ① Delivery Specification
- ② External View, Welding Machine

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DELIVERY SPECIFICATION

SPEC No. RS-113
WELDING MACHINE DEPT.,
ORIGIN ELECTRIC CO., LTD.

- 1 . Customer:

- 2 . Model Designation: Origin Parallel Seam Sealer
 Model: OS-20S-2127

- 3 . Applications Classified: To seam sealing an optical device

- 4 . Number of Pieces Treated: 1 piece per operation cycle

- 5 . Out line of Equipment

This equipment is a parallel seam sealer to hermetically seal an optical device seal frame with a lid.

The system comprises a welding head provided with a pair of roller electrodes, a transformer, a welding controller, a package carriage, a control unit, a dry box and a Vacuum Baking Oven.

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6. Applicable package

6 – 1 Type

Square type an optical device

6 – 2 Package Dimensional Range

Long and short sides: 3.5 thru 50.0 mm

Thickness: 0.9 thru 10.0 mm

* The lid shall be provided with a faucet joint, in principle. Its dimensions, moreover, shall be so shaped that it can be secured onto the seal ring without a gap.

A lid shape, a package seal ring shape, plating conditions, etc., meanwhile, are to be determined after making arrangements with you.

7. Welding appreciation

(1) A welding appreciation shall be equivalent to the sample submitted.

(2) Welding seal ability

Fine leakage: $1 \times 10^{-9} \text{Pa} \cdot \text{m}^3 / \text{sec}$ and below

(To the exclusion, however, of a defective package and/or a lid)

8. Utilities

8 – 1 Input power:

(1) Three-phase AC 415V, 50Hz, approx. 3.5kVA (for Vacuum Baking Oven)

(2) Single phase, AC 220V, 50Hz, approx. 1kVA (for Seam Sealer)

8 – 2 Compressed Air Source: pressure 0.5MPa (Max. 10N-liters per minute)

8 – 3 N₂ Gas Source: Pressure 0.2MPa (Max. 70N-liters per minute)

8 – 4 Cooling Water: 3 liters per minute (for Vacuum Baking Oven)

9. Composition

9 – 1 Seam Sealer: Model OS-20S-2127

| | Dimensions (W×D×H mm) | Weight(kg) |
|----------------------|---------------------------|------------|
| (1) Sealing machine: | Approx. 900 × 570 × 1,135 | Approx. 60 |
| (2) Control unit: | Approx. 400 × 520 × 1,021 | 40 |

9 – 2 Vacuum Baking Oven: Model UC-2007-02

| | Dimensions (W×D×H mm) | Weight(kg) |
|-------------------------|---------------------------|-------------|
| (1) Vacuum Baking Oven: | Approx. 650 × 980 × 1,210 | Approx. 250 |

1 0 . Specification for Welding Unit

- (1) Pressure System: press type with spring intervened
- (2) Electrode Force: 4.9N thru 9.8N
- (3) Welding Head Drive: AC Motor
- (4) Electrode shape: Special roller electrode
- (5) Dressing allowance: Max.2mm with 17.6 diameter
- (6) Table Carriage: AC servomotor
- (7) Welding speed: 5.0 thru 20mm/sec.

1 0 . Specifications relating to Welding Controller

- (1) Rated Input: Single phase, AC 200/220V. 0.48kVA(50% operation)
- (2) Short-circuit Current: Max.140A
- (3) Current Setting Range: effective current (20A thru 140A)
- (4) Current Control System: phase control system (with slope control)
- (5) Cooling Method: Air-cooling
- (6) Starting System: starting with external signal
- (7) Current Monitor:
With functions of detecting no current and upper/lower Limits of set current

1 1 . Specifications relating to Vacuum Baking Oven

- (1) Rated Input: Tree-phase AC415V, approx. 3.5kVA
- (2) Oven Chamber: internal dimensions (mm) 320W × 300D × 60H
- (3) Shelf step number: 3 steps
- (4) Achievable Pressure: 6.6Pa (with Pirani Vacuum Gauge)
- (5) Heating Temperature: Max. 150°C ±10% (on the self step)

1 3 . Outline of Operation

An operator shall put a work-piece into the equipment by the way of Vacuum Baking Oven in the dry Box.

After assembling the device seal ring and the lid in a fixed direction, place the assembly on a welding jig and set it in place on the turntable.

After that, press the "RUN" switch and the equipment will sequentially and automatically

Perform tack welding and permanent welding on Side "Y" and "X" as programmed in advance.

Alternately using two welding jigs, meanwhile, will allow you to combine work-pieces while simultaneously performing a welding operation.

Thus, you can improve your working efficiency.

1 4 . Control Panel

(1) Indication: English

(2) Location: top surface on the control box

*In addition to displaying a variety of messages, the control panel has the following functions performed by means of a touch switch.

① Setting weld-related parameters.

② Controlling a manual operation switch.

③ Reading a total counter (in 4 digits).

1 5 . Remarks

(1) "RUN/STOP" and "EMERGENCY STOP" switches are located in the dry

(2) A maximum of five species shall be registrable.

(3) After initially set, the species once registered may be changed by way of "File No." in the display.

(4) The welding jig package shall be of magnet-fixed type.

(5) The dry box shall be made of SUS with acrylic plate and shall be so constructed

(6) that a dew point meter can be attached.

(7) Paint Color: Munsel 5Y7/1(ivory)

1 6 . Accessories

(1) Welding Jig (2 type): 2sets each

(2) Roller Electrode: 8sets (7set for service and 1set for standby)

(3) N₂ Flowmeter: 1piece

(4) Dry box Globe: 12 pairs (11pair for service and 1pair for standby)

(5) Dew point Meter (−20°C~−80°C): 1set

(6) Standard Tools: 1set

(7) Instruction Manual (English): 2coppies

1 7 . Instruction, Wiring and Piping

The present specification shall neither cover the wiring and/or piping work between the present equipment and your factory power supplies (electricity, compressed air, and any gases) nor any foundation work to install the equipment.

1 8 . Warranty period

The present equipment shall be warranted for a period of one year or 4,000 service hours after completion of your trail run, Whichever may come earlier.

Nevertheless, it is premised that the maintenance and cleaning operations referred to in the 〈Instruction Manual〉 are being conducted without fail. In the event of any failure and/or rupture that may have taken for the reason attributable to us despite your normal use on the above-mentioned premises. We will furnish you with a replacement part or parts free of charge for the above-mentioned period of warranty only.

Nevertheless, any expenses that may be incurred on the replacement and/or adjustment involved shall be charged separately.

Those consumables, maintenance parts and/or tubes or bulbs which we may specify, moreover, shall be exempt from the warranty referred to above. And we shall be neither responsible nor liable for anything other than expressly specified here, in.

Should the information above be altered, please allow us to submit another quotation separately.