

※UNITING OF A SILVER ELECTRIC CONTACT AND A CONTACT SUPPORT:

Uniting methods include silver brazing, riveting and spot welding.

1. Silver Brazing:

Silver Brazing includes electric brazing, flame brazing and high frequency brazing. The specifications and properties of frequently used solder materials are shown in table 2. Please take note when operating a brazing machine.

(1) The fluxes, brazing alloys, brazing time, pressure and cooling methods should be carefully monitored.

(2) The gas and vapor produced by the flux and solder must be expelled completely.

2. Riveting:

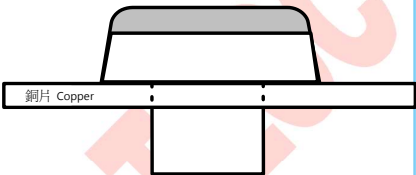
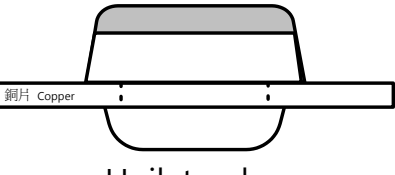
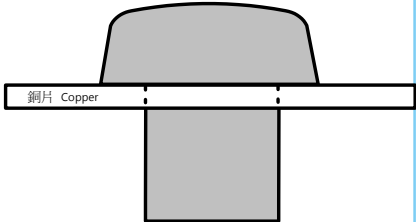
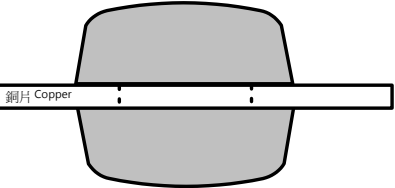
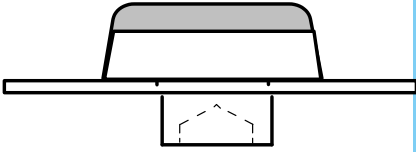
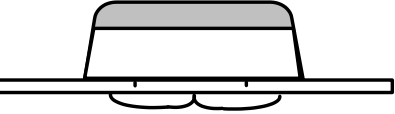
Considerations for riveting die:

(1) The cavity diameter of a riveting die should be 0.1mm larger than the head diameter of the rivet.

(2) The cavity depth of a riveting die (T') should be 0.05mm less than the head thickness of the rivet (T). If the support plate is relatively thinner, then T' is nearer to the T .

(3) The cavity angle of a riveting die should be within the ± 2 degree of the rivet head.

(4) A riveting die should be maintained in a completely clean condition and free of oil, dust, stains or other substances adhering to its surface.

Before Riveting	After Riveting
	 Unilateral use
	 Bilateral Use
	 Suitable for thin copper sheets (anti-copper deformation)

3. Spot Welding :

The so called "spot welding method" by mean of utilizing the convey of the electric current through the contact surface of parts to form a small nugget of welded metal, hence to join the materials after the current was removed.