

Solderable Pressure Window Inserts

These pressure windows are designed for installation into flange castings or bulkheads. A machined recess must be prepared to the specified tolerance. Windows may be installed into the recess by using either soft solder or conductive epoxy. If epoxy is used, special notice must be given to the epoxy's temperature characteristics. We recommend Ecco-Bond 45C, manufactured by Emerson and Cummings.

Soft Solder Installation

Pre-tin recess into which the window is to be soldered. Lead tin eutectic soldering is recommended. Heat should be applied uniformly through the flange. (Caution: Do not apply torch directly to the glass.) Flow the solder obtaining a uniform joint over the entire recess area. A poorly soldered joint will result in non-uniform compression the glass when cooled to room temperature.

Conductive Epoxy Installation

Apply thin coat of conductive epoxy to the recess and to the backside and outer edge of the pressure window. Insert the pressure window and cure the epoxy at the lowest temperature recommended by the epoxy manufacturer. The low temperature results in a uniform bubble-free seal.

Mechanical Specifications

The following table shows the mechanical and recess specifications for each window.

Model	Window Dimensions (Inches)					Recess Dimensions (Inches)			
	A	B	C	D	E	F	G	H	R
MA1325	3.00	1.50	0.12	0.06	-- --	3.00	1.50	0.08	0.03
MA1361	3.00	1.50	0.12	0.06	-- --	3.00	1.50	0.08	0.03
MA1398	2.42	1.27	0.12	0.06	-- --	2.42	1.20	0.13	0.09
MA1397	1.82	1.00	0.09	0.05	-- --	1.82	1.00	0.09	0.06
MA1301	0.99	0.49	0.05	0.02	-- --	1.00	0.50	0.04	0.03
MA1338	1.10	0.60	0.05	0.03	-- --	1.10	0.60	0.06	0.03
MA1350	1.50	0.75	0.05	0.03	-- --	1.50	0.76	0.05	0.03
MA1302	1.00	0.50	0.08	0.03	0.01	1.00	0.50	0.05	0.03
MA1312	1.00	0.50	0.08	0.03	0.01	1.00	0.50	0.05	0.03
MA1317	1.10	0.60	0.05	0.03	-- --	1.10	0.60	0.06	0.03
MA1331	1.00	0.49	0.07	0.02	0.01	1.00	0.50	0.04	0.03

Model	Window Dimensions (Inches)					Recess Dimensions (Inches)			
	A	B	Model	A	B	Model	A	B	Model
MA1350A	1.50	0.75	0.05	0.03	-- --	1.51	0.70	0.06	0.03
MA1311	1.10	0.60	0.05	0.03	-- --	1.10	0.60	0.06	0.03
MA1354	1.00	0.50	0.08	0.03	0.01	1.00	0.50	0.05	0.03
MA1328	1.00	0.50	0.07	0.02	0.01	1.00	0.50	0.04	0.03
MA1332	0.95	0.58	0.05	0.03	-- --	1.00	0.58	0.06	0.03
MA1336	0.69	0.38	0.05	0.02	0.01	0.70	0.39	0.04	0.03
MA1337	0.69	0.38	0.05	0.02	0.01	0.70	0.39	0.04	0.03

