



Process Instructions
Die Head & Balloon Shield
Beahm Designs

Document # 10125-20
Revision: C
Rev Date: 06/06/22

1.0 Description: This procedure describes the process of sizing the Thermal Die Head tooling used on Beahm Bonders (model #'s 220B, 320B, 420B, 520B & 620B)

2.0 Scope: This document applies to Part # 6066 rev B, and 6002 Thermal Die Heads

3.0 Tools and Equipment:

3.1 Caliper or micrometer

4.0 Reference

4.1 Fig. 1.0, page 2

4.2 Drawing 6066 Rev B, and 6002

5.0 Procedure:

5.1 Assemble components to be bonded over mandrel(s), Fig 1-2

5.2 Measure bond length, tubing overlap, balloon sleeve length. Fig 1-3

5.3 Position protective sleeve (fitted PTFE, PET heat shrink or Polyolefin heat shrink) over bond location. Fig 1-4

5.4 For heat shrink sleeves (PET, Polyolefin etc.) shrink the sleeve onto the bond location.

5.5 Measure O.D. of protective sleeve at bond location. Fig 1-5.

5.6 Machine the die heads to width based on value in step 5.2

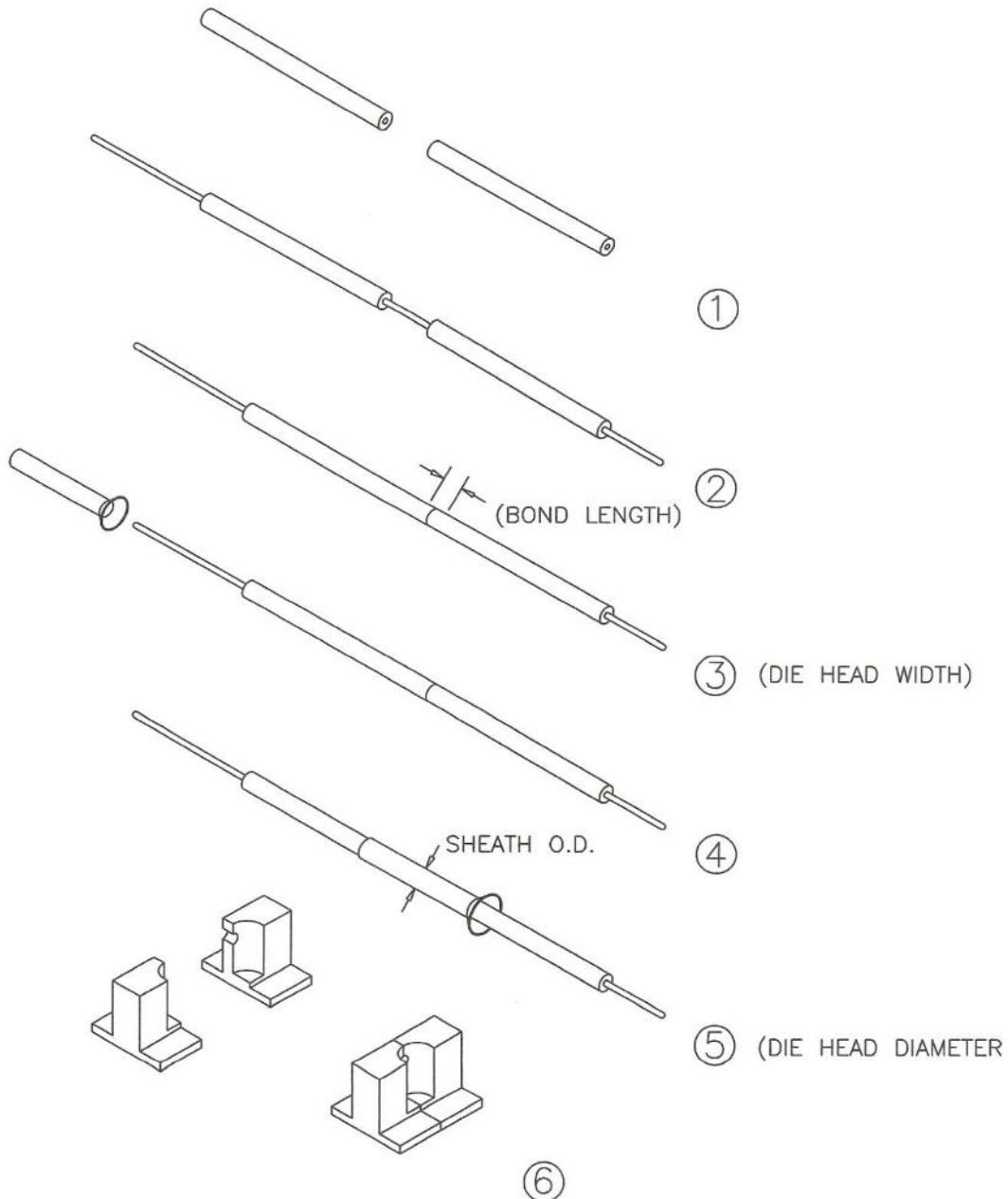
5.7 Bore hole through heads .003" less than diameter value in step 5.4

5.8 For Balloon Shield bore size add .005" to the product OD (without sleeve)

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Die Head Sizing Fig. 1.0



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6066 Rev B

