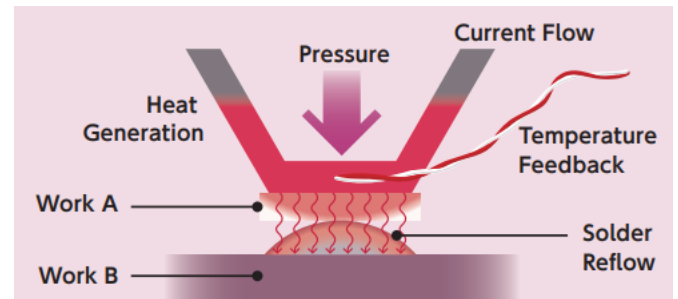


Caulking Method Comparison (Pulse Heat vs. Ultrasonic)

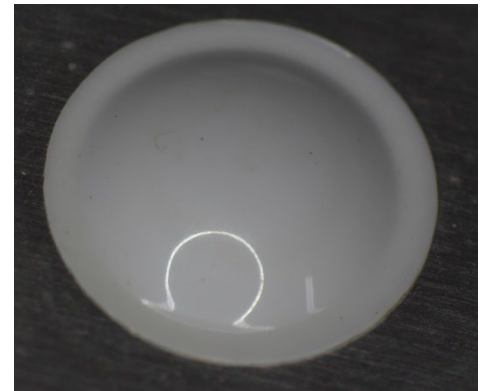
Pulse Heat

- **Temperature Control**
(Displacement control available)



Benefit

- Beautiful finish
- Threading unlikely due to maintaining of pressure through cooling
- Reduced vibration and thermal effect on peripheral parts
- Quiet
- Ideal for small boss



Why Pulse Heat?

- Appearance
- Less impact (stress) on neighboring parts
- Boss size $\Phi 4\text{mm}$ or less



Ultrasonic

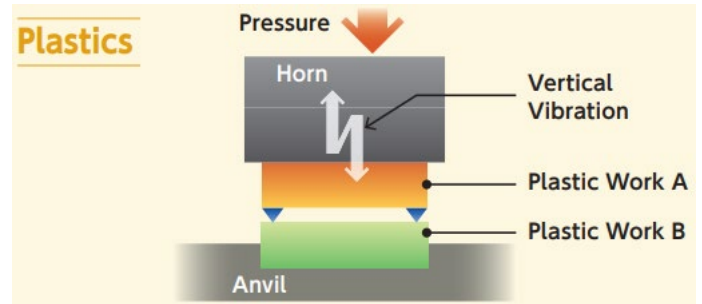
- **Peak Power Control**
(External sensor control available)

Benefit

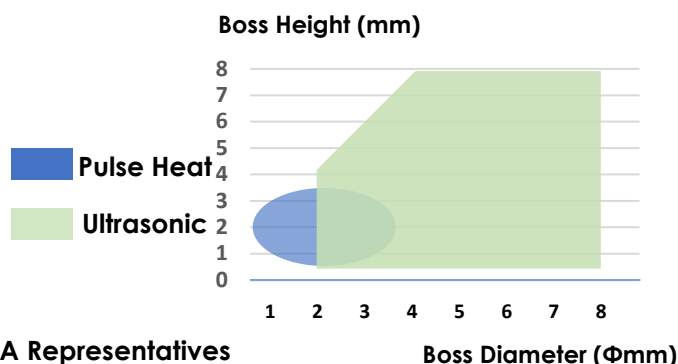
- Fast cycle time
- Threading unlikely due to low temperature weld
- Reduced thermal effect on peripheral parts
- High weld strength as clearance is easily filled
- Ideal for large boss and double-mount type caulking

Why Ultrasonic?

- Cycle time
- Strength
- Boss size Φ 2mm or more



Boss Size Comparison



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