

4

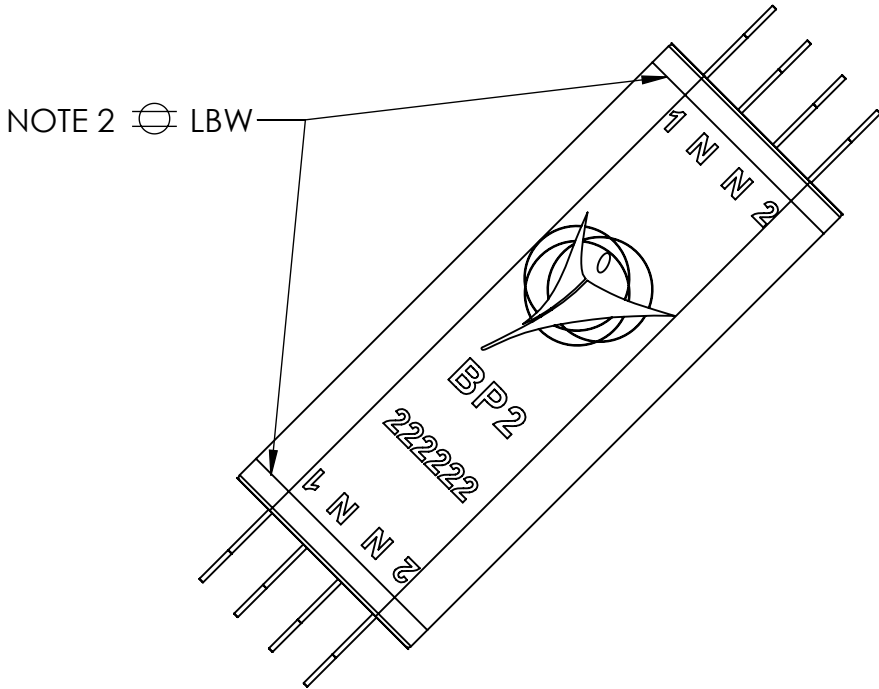
3

2

1

Item NO.	Part NO.	Part Description
1	NNP-DWG-135-009-001	SA, BP2 Module, Tack Weld Assembly

NOTES:
1. APPROVED SEAM WELDING SUPPLIER: EB INDUSTRIES
2. PREBAKE FOR 20 HOURS AT 50°C AND 200 mTorr VACUUM OR LESS BEFORE LASER SEAM WELD IN A 75% ARGON, 25% HELIUM ATMOSPHERE
USING THE FOLLOWING CRITERIA:
A. A MINMUM HERMETIC BARRIER OF .003 IS REQUIRED.
B. ENSURE ALL WELDS ARE COMPLETE WITH NO CRACKS, PITS OR VOIDS WHEN EXAMINED AT AT 30x MAGNIFICATION.
C. WELD COLOR SHOULD APPEAR SHINY SILVER. DARK STRAW OR BLUE IS NOT ACCEPTABLE WHEN EXAMINED AT 10X MAGNIFICATION. LIGHT STRAW IS ACCEPTABLE.
D. NO SPLATTER SHOULD BE EVIDENT WHEN EXAMINED WITH THE UNAIDED EYE AT A DISTANCE OF 12-18 INCHES.
3. HERMETIC SEAL 2 PLACES:
a. FINE LEAK TEST @ 2.7×10^{-9} cc HELIUM PER SECOND
b. WEIGHT GAIN TEST AS PER MIL STD 883, METHOD 1014.15, TEST CONDITION E
c. EB INDUSTRIES LASER WELDING SPECIFICATION: 7.5.P116. ALL REWELDS MUST BE PREAPPROVED BY SYNAPSE BIOMEDICAL INC.
4. FOLLOW TABULATION TABLE FOR TESTING REQUIREMENTS



THE INFORMATION CONTAINED IN THIS DRAWING IS PUBLICLY RELEASED BY COSMIC UNDER AN OPEN SOURCE LICENSE. COSMIC IS NOT LIABLE FOR ANY ASPECT OF USE OF THIS DRAWING, INCLUDING EDITS, FABRICATION, AND REPRODUCTION OF THIS DESIGN.

DO NOT SCALE DRAWING INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 2018 DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED	THIRD ANGLE PROJECTION
--	----------------------------

MATERIAL	FINISH
----------	--------

DOC. NAME SA, BP2 Module, Weld Assembly				
--	--	--	--	--

PROJECT NNP	DATE 8/12/2024	SIZE B	DOC. NUMBER NNP-DWG-135-009-000	REV 1.0
SHEET 1 OF 1	SCALE 2:1			

4

3

2

1