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Item NO.	Part NO.	Description
1	NNP-DWG-135-009-000	SA, BP2 Module, Weld Assembly
2	NNP-DWG-135-005-000	SA, Remote Module, Header

NOTES:
UNLESS OTHERWISE SPECIFIED

1. LOWER BALSEAL WELD WINDOW SHALL BE POSITIONED ON LOGO SIDE OF CASE ON BOTH ENDS.
2. LASER WELD FEEDTHROUGH WIRES TO BALSEAL CONDUCTORS MUST MEET.
THE FOLLOWING CRITERIA:

A. ENSURE ALL WELDS ARE COMPLETE WITH NO CRACKS, PITS OR VOIDS WHEN EXAMINED AT 30X MAGNIFICATION.

B. WELD COLOR SHOULD APPEAR SHINY SILVER. DARK STRAW OR BLUE IS NOT ACCEPTABLE WHEN EXAMINED AT 10X MAGNIFICATION. LIGHT STRAW IS ACCEPTABLE.

C. NO SPLATTER SHOULD BE EVIDENT WHEN EXAMINED WITH THE UNAIDED EYE AT A DISTANCE OF 12-18 INCHES.

D. ANY LASER CHARRING REACHING EXTERNAL SURFACES OF ITEM 2 SHALL BE CLEANED SUCH THAT ALL CHARRING WILL BE ENTIRELY ENCAPSULATED BY BACKFILL.
3. WELDED MINIMUM TENSILE PULL STRENGTH FOR SINGLE FEEDTHROUGH/BALSEAL TO BE GREATER THAN 2LB.
4. BACKFILLED AREAS SHALL BE INSPECTED AT 10X MAGNIFICATION FOR THE FOLLOWING:

A. BACKFILL SHALL BE SMOOTH, UNIFORM AND FREE OF FLASH OR PIN HOLES.

B. ACCEPTABLE FLAWS INCLUDE:

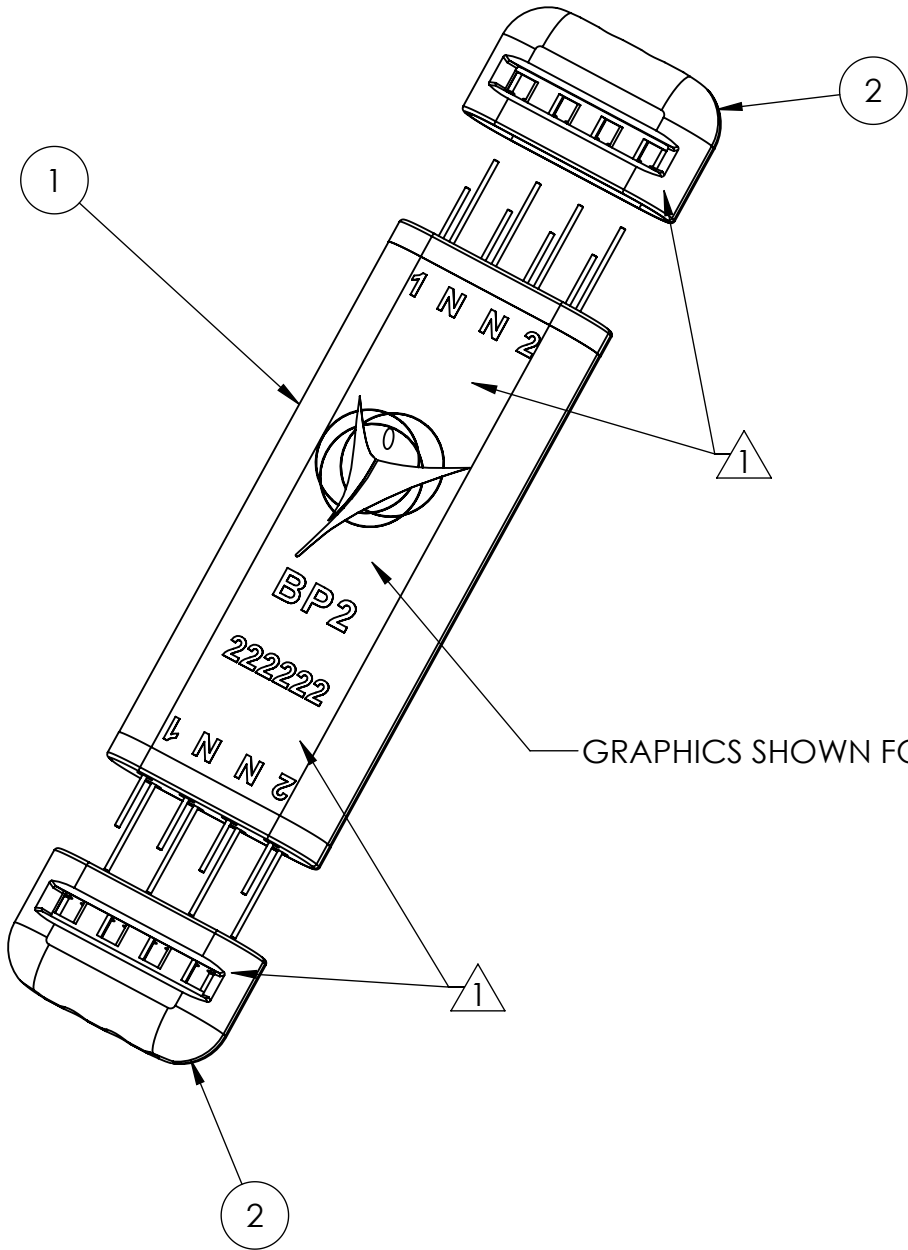
I. FOREIGN PARTICLES NO LARGER THAN .005" IN ANY DIMENSION AS LONG AS ENCAPSULATED BELOW THE SURFACE.

II. VOIDS ALONG THE PERIMETER, PROVIDING THE OTHER CRITERIA ARE MET.

III. NO TWO FLAWS MAY BE CLOSER THAN .20" OF EACH OTHER.

IV. DELAMINATION, PROVIDED IT DOES NOT CONTACT ANY ELECTRICAL SOCKET AND/OR BRIDGE TO THE EXTERIOR SURFACES OF THE DEVICE.

C. BUBBLES AND VOIDS MUST NOT BRIDGE BETWEEN ANY EXTERIOR SURFACE AND ELECTRICAL CONNECTOR OR BETWEEN ELECTRICAL CONNECTORS.
5. NO EPOXY SHALL BE APPARENT IN ANY LEAD BORES.
6. EPOXY SHALL NOT EXCEED 3MM DOWN SIDES OF CASE.



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

DOC. NAME				
BP2 Module				

PROJECT	DATE	SIZE	DOC. NUMBER	REV
NNP	8/12/2024	B	NNP-DWG-135-010-000	1.0
SHEET	SCALE			
1 OF 1	2:1			

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