

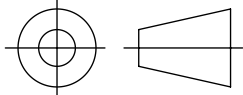
A

- WINDING PARAMETERS:
- RIGHT-HAND WIND
 - 0.010" MANDREL
 - MANDREL TENSION = 1/8" drop with 2.1 oz. (60 grams) center weight
 - FEEDER ANGLE = 5° from normal
 - FEEDER TENSION (single feed spool)
 - INITIAL 2.3 - 3.9 oz. (65 - 110 grams) for first 1/4" - 1/2"
 - FINAL 10.9 oz. (310 grams) for cable body
 - FEED RATE = 21 mils per revolution
 - FEED LENGTH = 3.3 x finished length for each helix wound on mandrel
 - FEED LENGTH = (apporx.) 4 x finsihed length after removing from mandrel (coil relaxation)

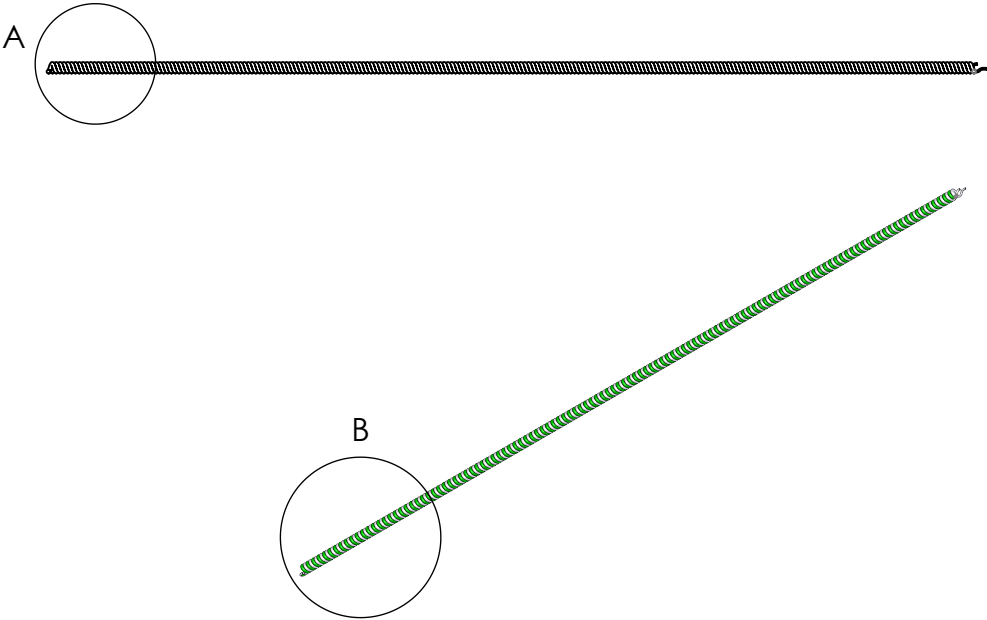
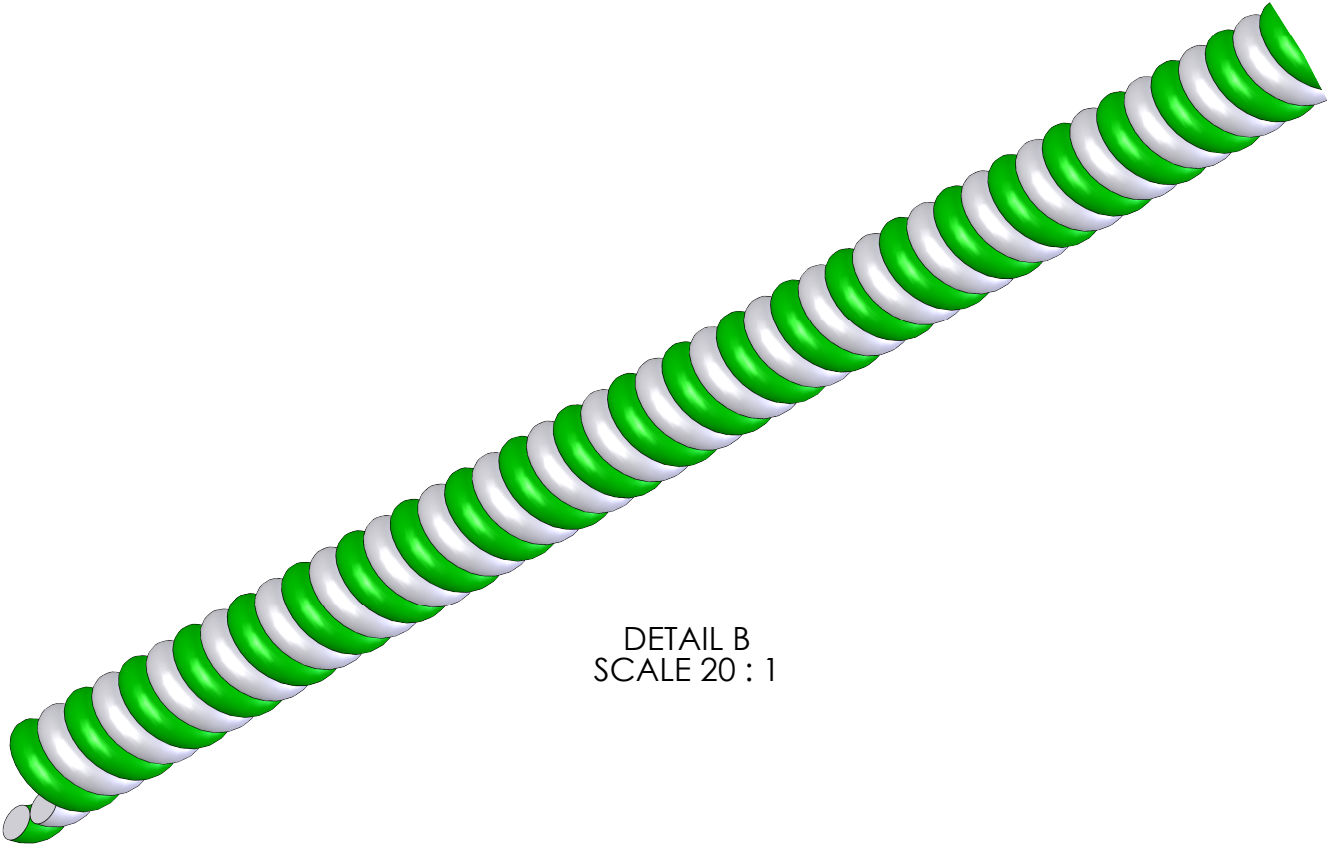
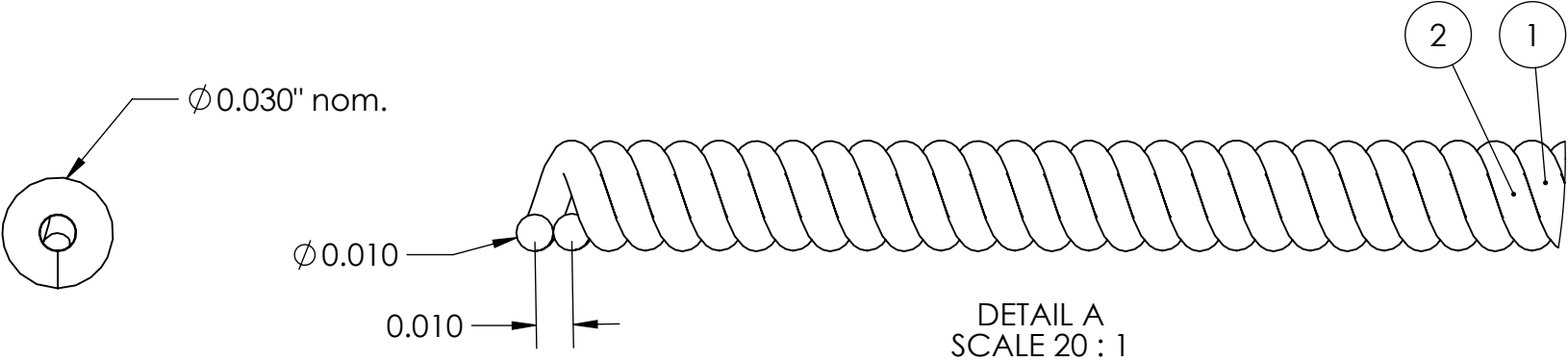
ITEM NO.	DESCRIPTION
1	PFA coated leadwire - green
2	PFA coated leadwire - clear
3	2 Filar cable, grn-clr



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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		
316 SS Wire, PFA Insulation				
DOC. NAME				
Filar, SS, Green-Clear				
PROJECT	DATE	SIZE	DOC. NUMBER	REV
NNP	6/28/2024		NNP-DWG-140-011-002	1.0
SHEET	SCALE			
1 OF 1	2:1			

B



- NOTES:
- CLOSE WOUND BIFILAR COILED CABLE. TANDEM WOUND.
 - COIL GAPS GREATER THAN 0.002" NOT ALLOWED
 - WOUND LENGTH AS NEEDED
 - WOUND LEADS MUST BE PACKAGED TO PREVENT DAMAGE OR CONTAMINATION DURING HANDLING, STORAGE, AND SHIPMENT

A

B