

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



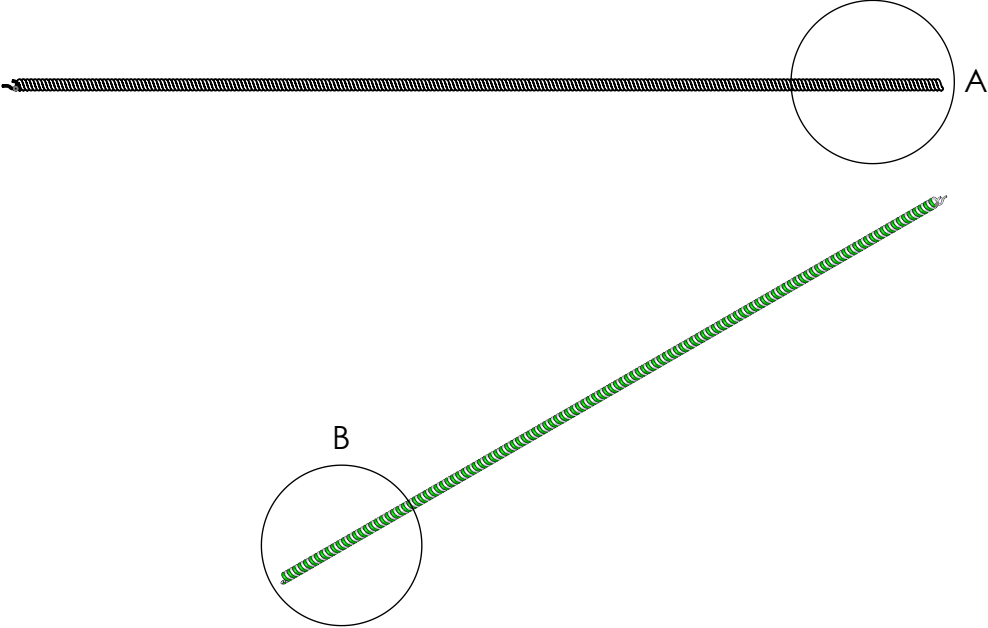
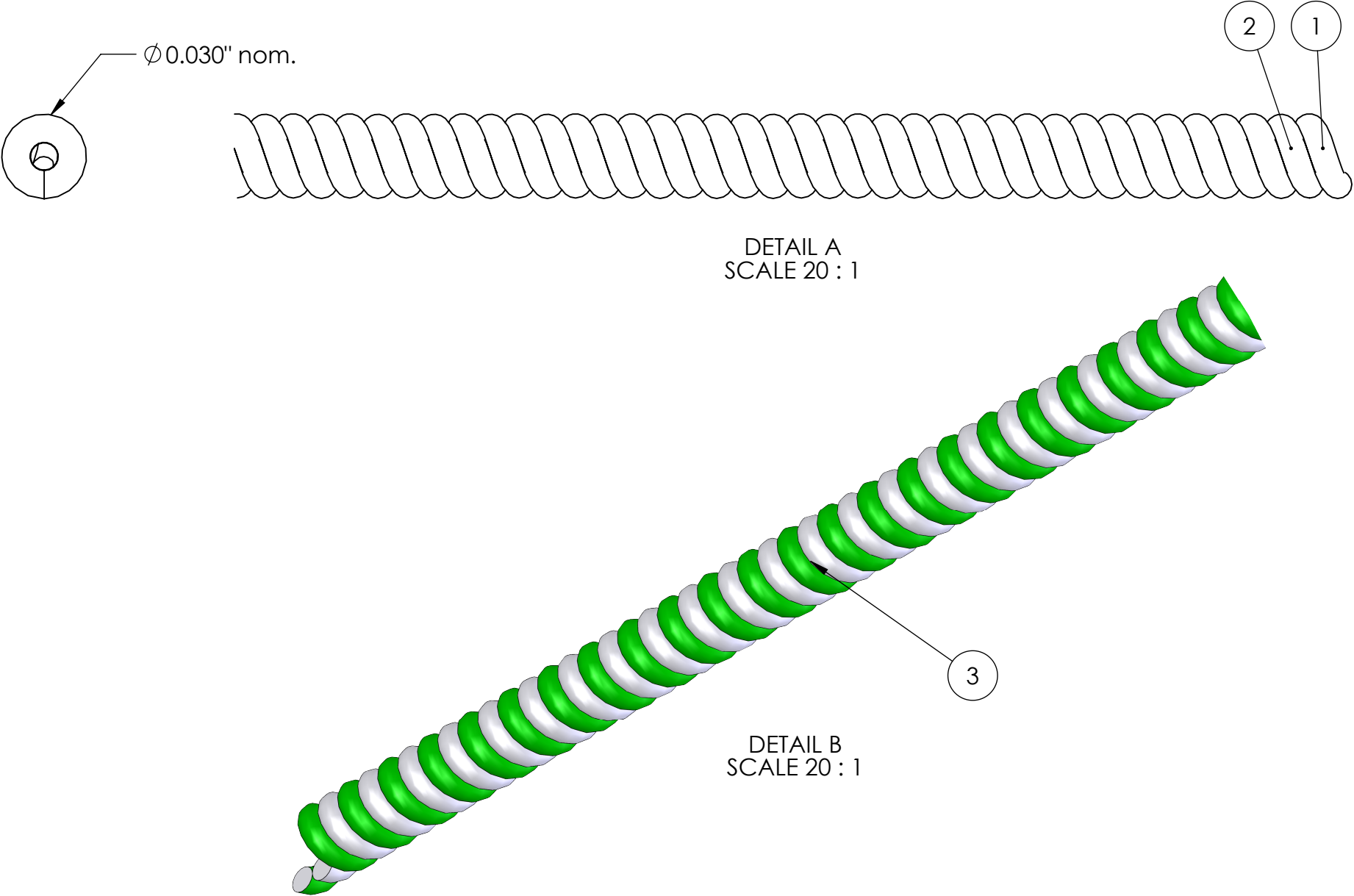
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DO NOT SCALE DRAWING	THIRD ANGLE PROJECTION
INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 2018	
DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED	
MATERIAL SS	FINISH

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

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B