

4

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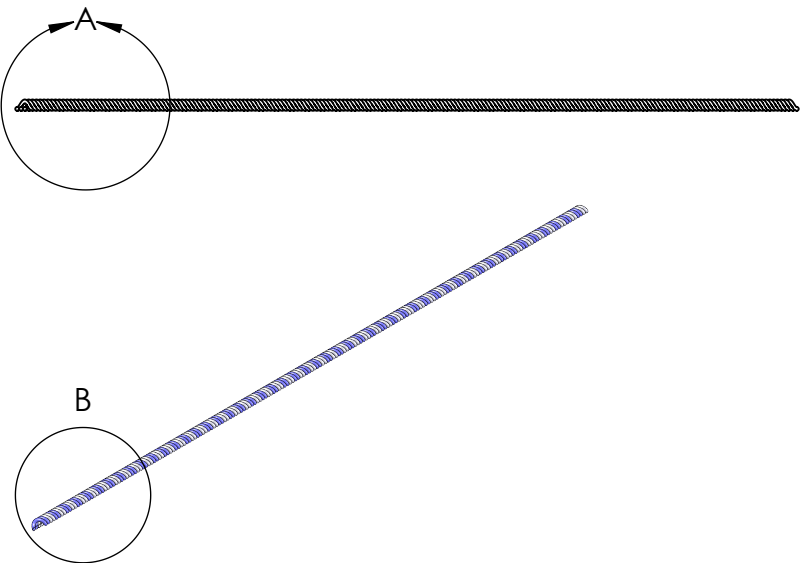
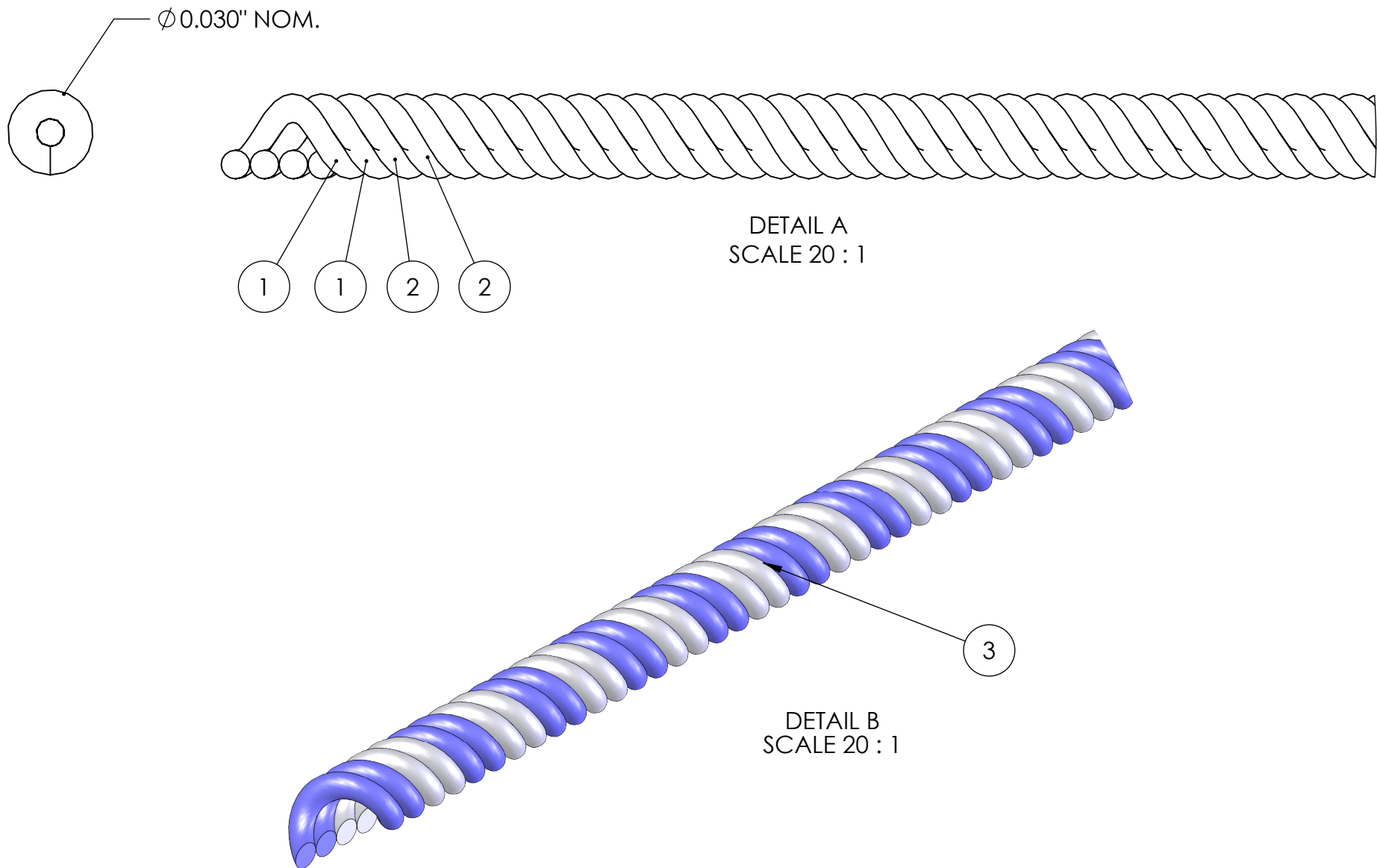
1

B

B

A

A



- NOTES:**
- CLOSE WOUND BIFLAR 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

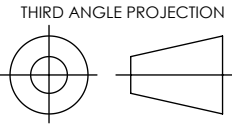
- WINDING PARAMETERS:**
- RIGHT-HAND WIND (Carraige feed - right; Mandrel direction - clockwise (right))
 - 0.010" MANDREL
 - MANDREL TENSION = 1/8" drop with 2.1 oz. (60 grams) center weight
 - Use opposed dual leadwire feed spools
 - Two leadwires per feed spool
 - FEEDER ANGLE = 20° from normal, both front and rear spools
 - FEEDER TENSION (combined for tandem feed)
 - INITIAL 2.1 oz. (60 grams) for first 1/4" - 1/2"
 - FINAL 18.0 oz. (510 grams) for cable body
 - FEED RATE = 37 mils per revolution
 - FEED LENGTH = 1.9 x finished length for each helix wound on mandrel
 - FEED LENGTH = (apporx.) **TBD** x finsihed length after removing from mandrel (coil relaxation)

ITEM NO.	DESCRIPTION
1	PFA coated leadwire - blue
2	PFA coated leadwire - clear
3	4 Filar cable, blu-blu-clr-clr



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



MATERIAL
DFT Wire, PFA Insulation

FINISH

DOC. NAME

Filar, DFT, Blue-Clear

PROJECT	DATE	SIZE	DOC. NUMBER	REV
NNP	6/27/2024	B	NNP-DWG-140-010-000	1.0
SHEET 1 OF 1	SCALE 2:1			

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