

4

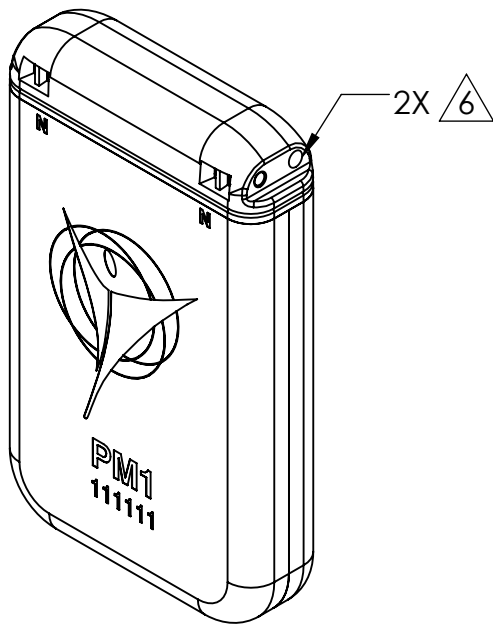
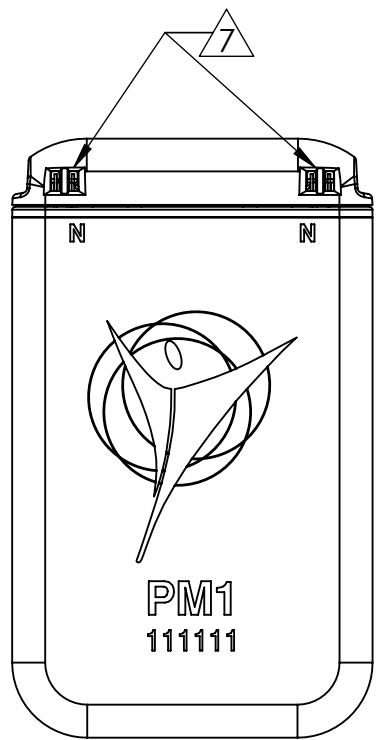
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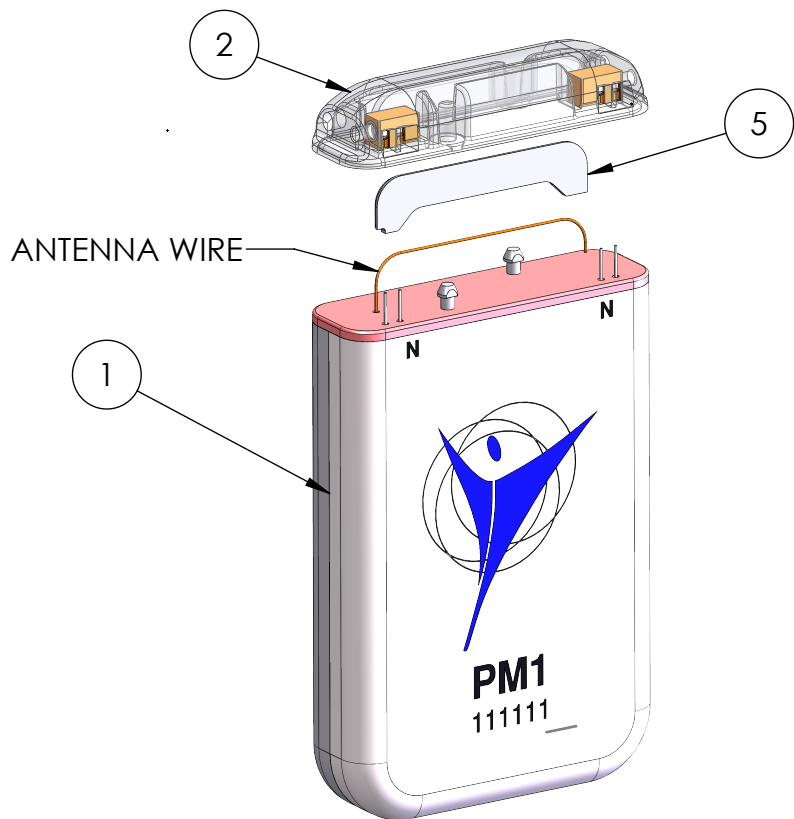
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NOTES:

1. APPLY ITEM 4 TO LID OF ITEM 1 AND TO ALL INSIDE SURFACES AND ALL WINDOWS/PORTS OF ITEM 2 PER MANUFACTURERS SPECIFICATIONS.
POSITION ITEM 5 UNDER THE FORMED ANTENNA WIRE
2. PRESS ITEMS 2 TO ITEM 1 AS DIRECTED IN THE FABRICATION PROCEDURE.
3. LASER WELD FEEDTHROUGH WIRES (4X) TO CONDUCTORS THROUGH ACCESS WINDOWS ON HEADER.
4. INSPECT USING THE FOLLOWING VISUAL 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.
5. WELDED MINIMUM TENSILE PULL STRENGTH FOR SINGLE LID THROUGH WIRE TO BALSEAL MUST BE GREATER THAN 2 LB.
6. BACKFILL HEADER USING ITEM 3 THROUGH THE INDICATED ACCESS HOLES.
7. BACKFILL WINDOWS (4X) USING ITEM 6. ITEM 6 MUST BE FLUSH WITH THE SURFACE OF ITEM 2.
8. 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.
9. NO SHARP EDGES BETWEEN CASE AND HEADER
10. LEAD BORES SHALL BE FREE OF BACKFILL AND OTHER OBSTRUCTIONS
11. SILICONE BACKFILL (ITEM 3) SHALL NOT EXCEED 3MM DOWN SIDES OF CASE



Item No.	Part No.	Description
1	NNP-DWG-115-009-000	Power Module Weld Assembly
2	NNP-DWG-115-008-000	Header Assembly, 2 Port
3	NNP-MAT-150-009-000	MED1-4213
4	NNP-MAT-150-002-000	Primer, MED6-161
5	NNP-DWG-110-004-000	Antenna Support
6	NNP-MAT-150-010-000	MED-6215



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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				
Power Module				

PROJECT	DATE	SIZE	DOC. NUMBER	REV
NNP	8/26/2024	B	NNP-DWG-115-010-000	1.0
SHEET	SCALE			
1 OF 1	1:2			

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