



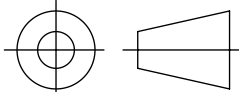
Item No.	Part No.	Description
1	NNP-DWG-110-023-000	Battery, Quallion
2	NNP-DWG-110-024-001	Large Sleeve
3	NNP-DWG-110-024-002	Small Sleeve

- NOTES:
- ASSEMBLE ITEMS 2 & 3 TO ITEM 1 AS SHOWN AND LASERWELD USING THE FOLLOWING CRITERIA:
 - ENSURE ALL WELDS ARE COMPLETE WITH NO CRACKS, PITS OR VOIDS WHEN EXAMINED AT AT 30X MAGNIFICATION.
 - WELD COLOR SHOULD APPEAR SHINY SILVER. DARK STRAW OR BLUE IS NOT ACCEPTABLE WHEN EXAMINED AT 10X MAGNIFICATION. LIGHT STRAW IS ACCEPTABLE.
 - NO SPLATTER SHOULD BE EVIDENT WHEN EXAMINED WITH THE UNAIDED EYE AT A DISTANCE OF 12-18 INCHES.
 - PULL STRENGTH FOR WELDED ITEMS 2 & 3 TO BE GREATER THAN 1LB.
-  INSPECT TO VERIFY A MINIMUM AIR GAP OF 0.010 IS MAINTAINED BETWEEN BOTTOM OF SLEEVES AND BATTERY



Open source implantable devices

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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				
SA, Battery				
PROJECT	DATE	SIZE	DOC. NUMBER	REV
NNP	8/26/2024			
SHEET	SCALE	B	NNP-DWG-115-005-000	1.0
1 OF 1	5:1			