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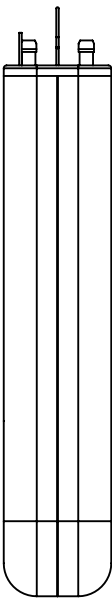
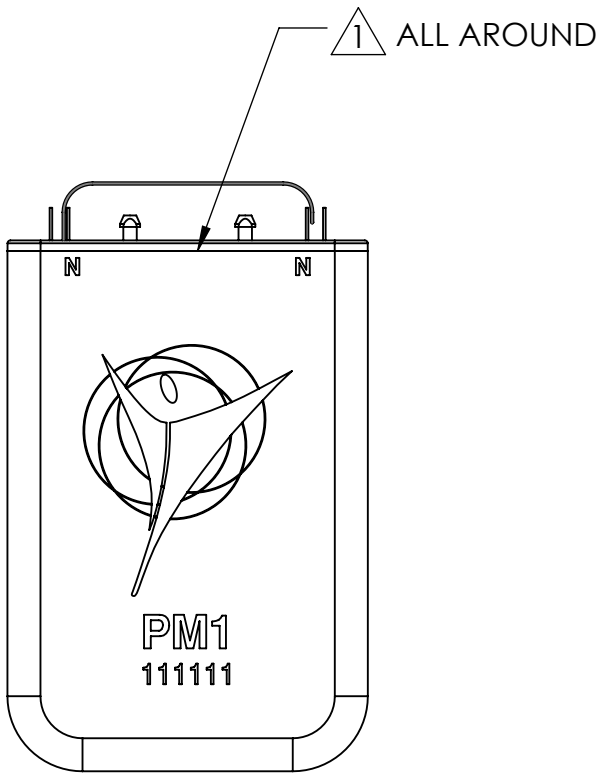
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Item No.	Part No.	Description
1	NNP-DWG-115-009-001	Tack Weld Assembly, 2 Port

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NOTES:

1.

PREBAKE FOR 20 HOURS AT 50°C AND 200 mTorr VACUUM OR LESS BEFORE LASER SEAM WELD IN A 75% ARGON, 25% HELIUM ATMOSPHERE
USING THE FOLLOWING CRITERIA:
A. A MINMUM HERMETIC BARRIER OF .003 IS REQUIRED.
B. ENSURE ALL WELDS ARE COMPLETE WITH NO CRACKS, PITS OR VOIDS WHEN EXAMINED AT 30x MAGNIFICATION.
C. WELD COLOR SHOULD APPEAR SHINY SILVER. DARK STRAW OR BLUE IS NOT ACCEPTABLE WHEN EXAMINED AT 10X MAGNIFICATION. LIGHT STRAW IS ACCEPTABLE.
D. NO SPLATTER SHOULD BE EVIDENT WHEN EXAMINED WITH THE UNAIDED EYE AT A DISTANCE OF 12-18 INCHES.
2. LEAK TEST PER LATEST REVISION OF MIL STD 2022
A. FINE LEAK PER TEST CONDITION C, STANDARD LEAK RATE IS TO BE <6.7 x 10-9ATM-CC/SEC WITH 25% HELIUM
B. GROSS LEAK TEST PER TEST CONDITION D.



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

DOC. NAME Power Module Weld Assembly				
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PROJECT NNP	DATE 8/26/2024	SIZE B	DOC. NUMBER NNP-DWG-115-009-000	REV 1.0
SHEET 1 OF 1	SCALE 1:1			

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