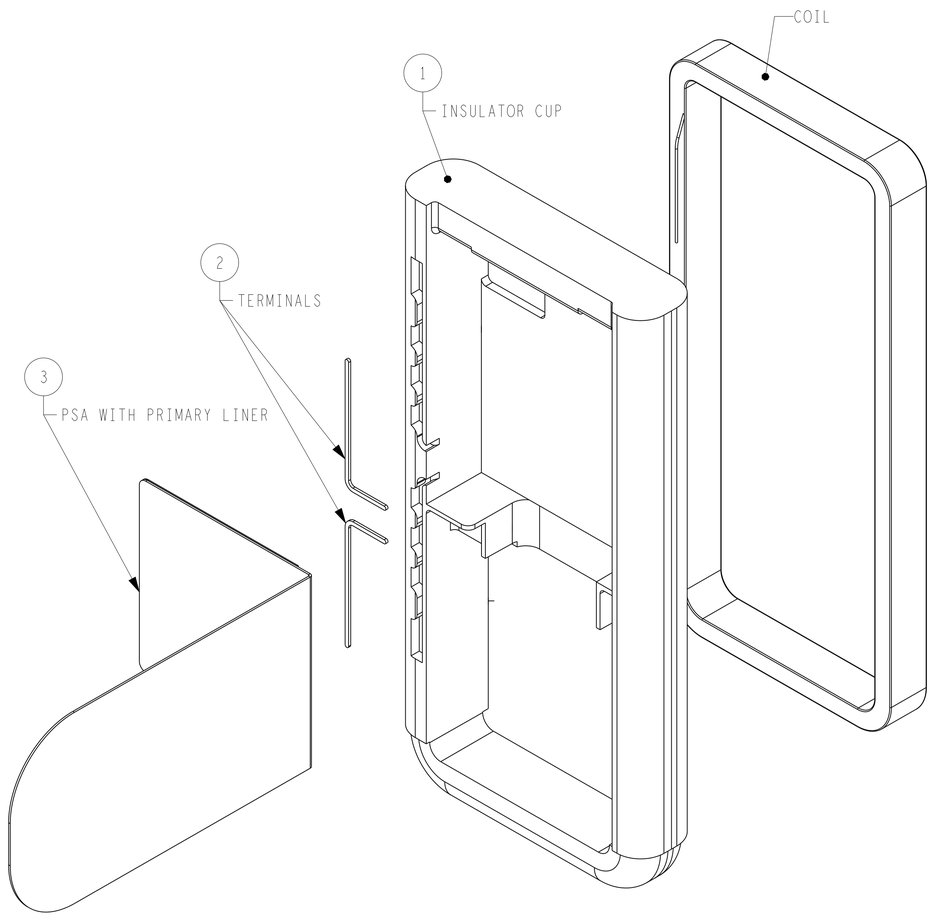
REVISIONS					
REV	DESCRIPTION	CHANGE NO.	DATE	DFTG	APVD
A	DOCUMENT RELEASE	17-000071	2JAN2017	JEL	BJT
B	UPDATE NOTES 5-18, ADD NOTE 19, DELETE NOTE 11, SEE CA	17-029040	4OCT2017	LAM	BT
C	NOTES & DOCUMENTATION REVISION; SEE CA	18-001793	0JAN2018	LAM	BT
D	DOCUMENTATION REVISION, SEE CA	19-014412	8JUN2019	JWS	BJT



NOTES

1 ASSEMBLY SHALL MEET ALL REQUIREMENTS CONTAINED IN THE RELATED ENGINEERING BILL OF MATERIALS AND SPECIFICATIONS.

2 COIL MATERIAL: 38 AWG BONDABLE MAGNET WIRE PER NEMA MW 131-C.
SOLDER MATERIAL: 63% Sn, 37% Pb

△3 COIL START AND END TERMINATIONS TO BE LOCATED WITHIN SLOTS SHOWN AND BELOW TOP SURFACE OF THE INSULATOR CUP. NO EXPOSED COPPER WHEN COIL ASSEMBLY IS VIEWED AT 10X MAGNIFICATION.

△4 COIL START AND END TERMINATIONS TO BE SOLDERED IN LOCATION SHOWN. MINIMUM WETTING .050

△5 EPOXY SHALL MEET THE FOLLOWING TYPICAL MATERIALS PROPERTIES:
- GLASS TRANSITION TEMPERATURE SHALL BE EQUAL TO OR GREATER THAN 53C.
- HARDNESS PER DUROMETER MEASUREMENT SHALL BE EQUAL TO OR GREATER THAN 85D PER ASTM D2240.

△6 COIL AND COIL TERMINATIONS TO BE PROTECTED WITH EPOXY. DISPENSE EPOXY OVER START AND END TERMINATIONS. EPOXY COVERAGE IS REQUIRED IN AREA SHOWN. ADDITIONAL EPOXY OUTSIDE OF AREA SHOWN IS ACCEPTABLE PROVIDED ALL OTHER REQUIREMENTS ARE MET. EPOXY MUST BE FLUSH OR BELOW THE EDGE OF THE INSULATOR CUP.

△7 COIL TO BE PROTECTED WITH EPOXY. DISPENSE EPOXY OVER ENTIRE COIL. COIL AND EPOXY MUST BE FLUSH OR BELOW THE EDGE OF THE INSULATOR CUP.

△8 NO EPOXY, SOLDER OR FLUX ALLOWED ON INDICATED SURFACE.

◈9 ELECTRICAL SPECIFICATION: 100% ELECTRICAL INSPECTION REQUIRED BY SUPPLIER ON THE FOLLOWING:
- DC RESISTANCE = 19.06 OHM MAX, MEASURED AT 20°±5°C
- INDUCTANCE (L) = .460±.010 mH MEASURED AT 100 KHz
- SELF RESONANT FREQUENCY = 1 MHz MINIMUM

◈10 IONIC CONTAMINATION NOT TO EXCEED 0.51 EQUIVALENT MICRO GRAMS NaCL/CM^2 FOR EACH PART PRIOR TO PSA APPLICATION. SURFACE AREA IS 31.81 CM^2. PART TO BE CLEANED PER MEDTRONIC APPROVED PROCESS.

11 DELETED

△12 INDICATED DIMENSIONS FOR SUPPLIER REFERENCE ONLY.

△13 PSA MUST BE FULLY ADHERED IN LOCATION SHOWN WITH PRIMARY RELEASE LINER IN ORIENTATION INDICATED. NO WRINKLES OR FOLDS.

14 REMAINING SHELF LIFE OF PSA TO BE AT LEAST 12 MONTHS FROM DATE OF SHIPMENT.

15 ASSEMBLY SHALL BE PACKAGED AND DOUBLE BAGGED TO PREVENT DAMAGE AND CONTAMINATION DURING SHIPPING.

16 SUPPLIER SHALL PROVIDE CERTIFICATION OF COMPLIANCE WITH EACH LOT, WHICH INCLUDES:
- MEDTRONIC PART NUMBER, REVISION AND PURCHASE ORDER NUMBER;
- MANUFACTURER NAME AND LOT NUMBER, LOT QUANTITY, AND LOT NUMBER(S) OF RAW MATERIAL(S) USED;
- MANUFACTURING AND EXPIRATION DATE;
- SUPPLIER REPRESENTATIVE'S NAME, SIGNATURE, AND DATE;
- STATEMENT OF CONFORMANCE TO DRAWING/SPECIFICATION REQUIREMENTS;
- KEY DESIGN CHARACTERISTICS VERIFIED BY CERTIFICATION LISTED INDIVIDUALLY.

17 EACH PACKAGE OF COMPONENTS SHALL BE PERMANENTLY AND LEGIBLY MARKED WITH A MEDTRONIC PART NUMBER, SUPPLER LOT NUMBER, QUANTITY, AND PSA EXPIRATION DATE.

18 NOTIFICATION OF CHANGE: UPON APPROVAL BY MEDTRONIC OF THE INITIAL DESIGN, ANY PROCESS CHANGE, DESIGN CHANGES OR DEVIATIONS CONSIDERED BY THE MANUFACTURER SHALL BE SUBMITTED TO MEDTRONIC IN WRITING FOR REVIEW. IF CHANGES ARE SUBMITTED FOR APPROVAL, THE INFORMATION SUBMITTED SHALL INCLUDE COMPLETE DESCRIPTION OF THE CHANGE AND THE EFFECT THE CHANGE SHALL HAVE ON ALL CHARACTERISTICS OF THE DEVICE/MATERIAL. UPON REQUEST, THE MANUFACTURER SHALL SUBMIT SAMPLES OF THE PROPOSED DEVICE/MATERIAL FOR THE EVALUATION AND APPROVAL BY MEDTRONIC.

19 THIS DRAWING AND THE ASSOCIATED ASSEMBLY BILL OF MATERIALS HAS BEEN ASSESSED FOR KEY DESIGN CHARACTERISTICS WHICH ARE DEFINED AS:
◈ - IDENTIFIED CHARACTERISTIC IS CLASSIFIED AS CRITICAL AND IMPACTS SAFETY.
▽ - IDENTIFIED CHARACTERISTIC IS CLASSIFIED AS MAJOR AND IMPACTS SAFETY.

Medtronic

TITLE: INSULATOR CUP ASSEMBLY

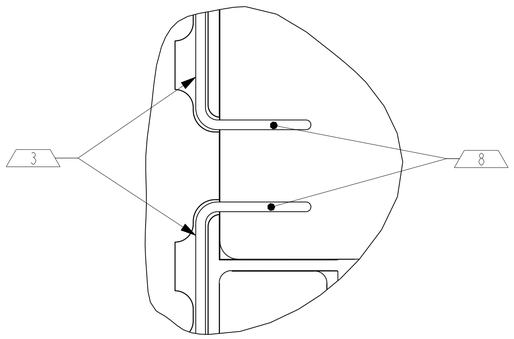
DATE CREATED: 21DEC2016 | DO NOT SCALE PRINT | DIMENSIONS ARE IN **INCHES**
DRAFTING: J.LOVINS
ENGINEERING: B.TORGERSON

DRAWING INTERPRETATION PER ASME Y14.100-2004 AND ASME Y14.5M-1994
THIRD ANGLE PROJECTION

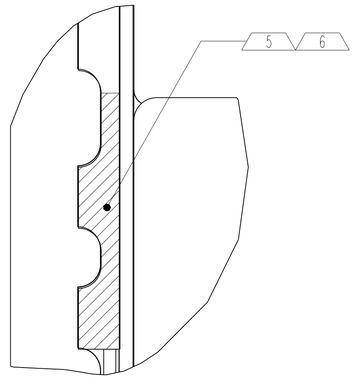
.X ± .1
.XX ± .01
.XXX ± .005
.XXXX ± .0005
∠ X ± 1°
∠ .X ± 1.0°

DESIGNED FOR MODEL: - - - -
DOCUMENT NUMBER: M968994A | REV: D
CREO PARAMETRIC | SIZE D | SHEET 1 OF 3

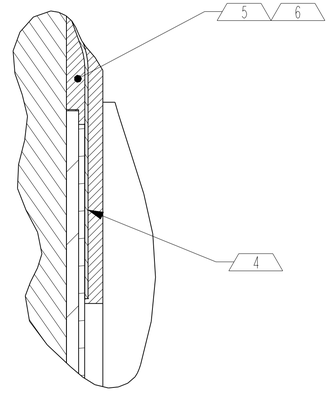
MODEL: M968994A001
DRW: M968994A



DETAIL F



DETAIL G
2 PLACES



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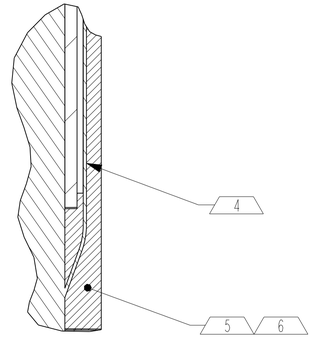

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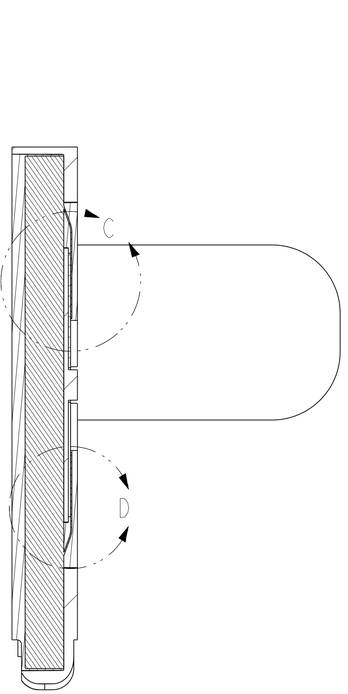
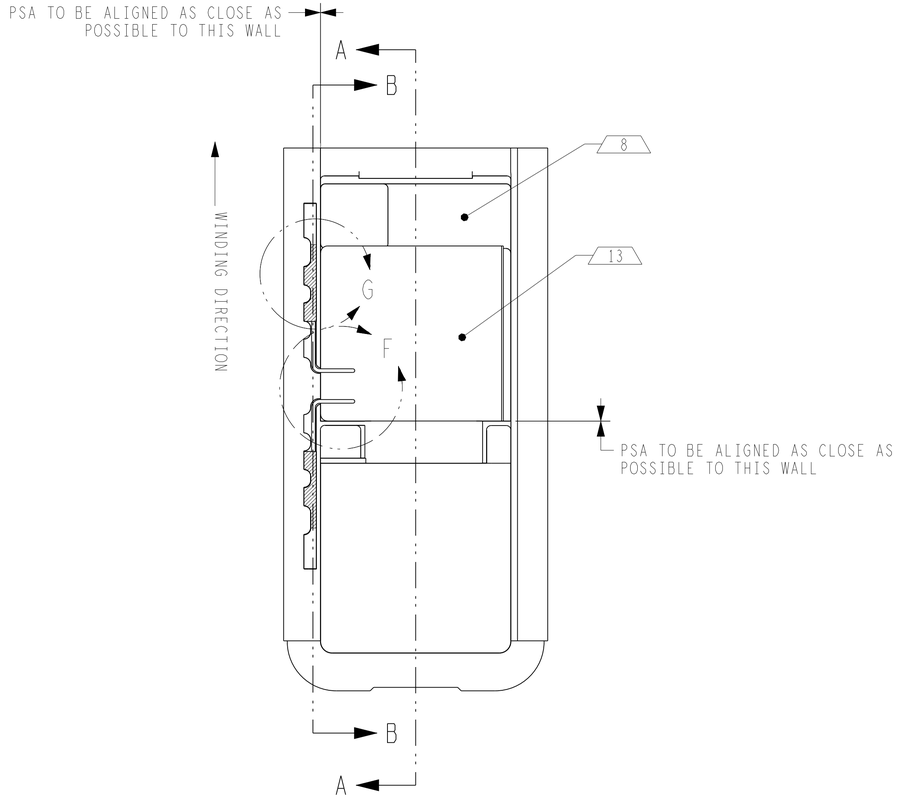
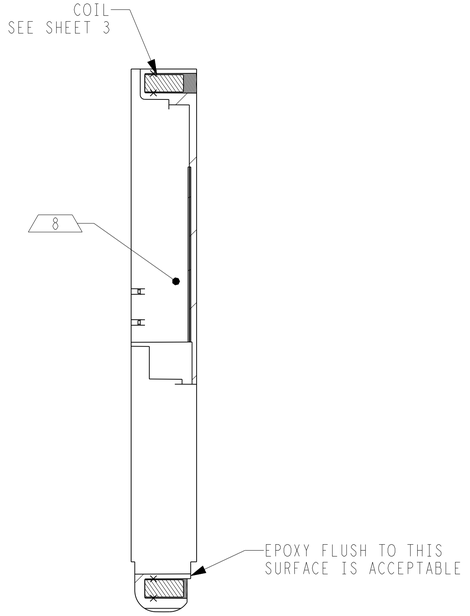
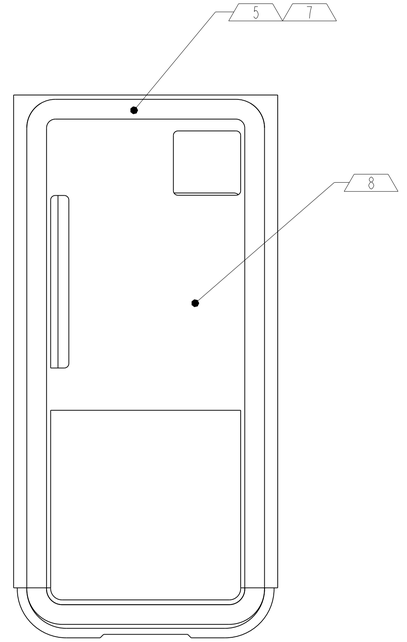


SECTION B-B



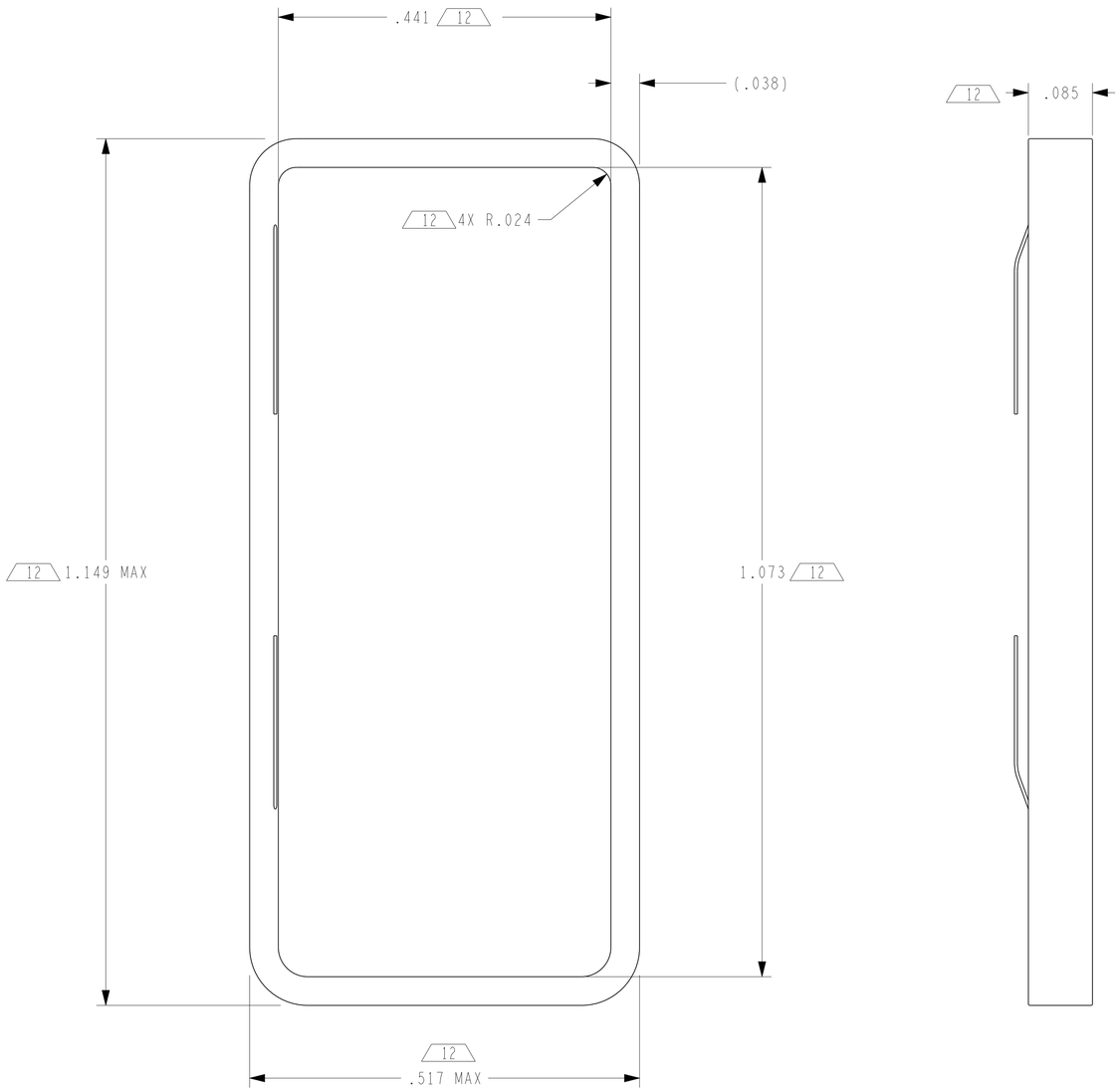


SECTION A-A



Medtronic	CONFIDENTIAL	
DOCUMENT NUMBER M968994A		REV D
CREO PARAMETRIC	SIZE D	SHEET 2 OF 3

MODEL: M968994A001
DRW: M968994A



COIL

Medtronic	CONFIDENTIAL	
DOCUMENT NUMBER		REV
M968994A_S01		D
CREO PARAMETRIC	SIZE D	SHEET 3 OF 3

MODEL: M968994A01_S01
DRW: M968994A