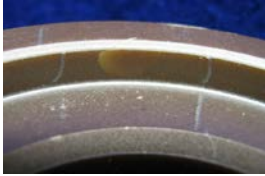






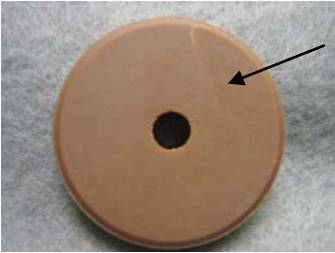
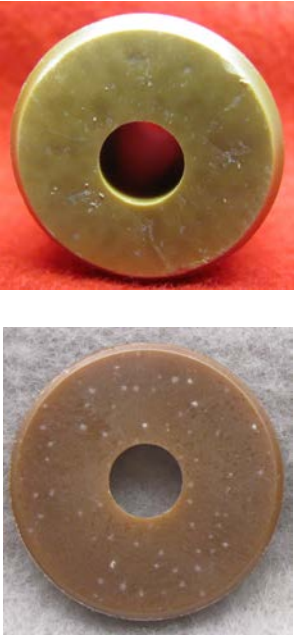
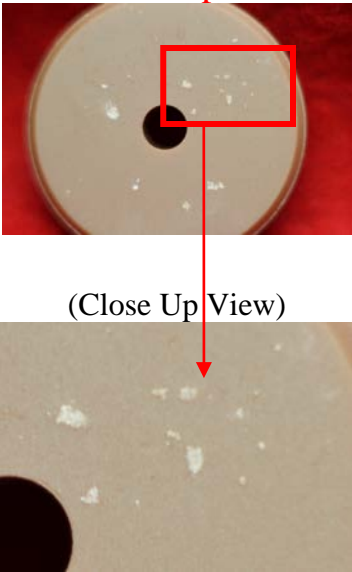
**Inspection Method Sheet**

**Part Number:** Generic  
**Drawing Number:** Generic  
**Page** 1 of 2  
**Doc. #:** TT-PC-0215 Rev. 14

**Part Name:** Class III Chip Spec  
**Operation:** V/M Inspection  
**Written By:** S. Winpiger  
**Date:** 05-06-1999

**Applicable customer specifications take precedence over this procedure (reference customer drawing).**

Description / Dimensions	Picture / Detail	Sample Size / Method / Standard
<p>1) Inspect part for <b>Chips</b>:</p> <p>Any chips under 0.020" is not recognized.</p> <p>1 Chip = .090" x .090" x .060" depth (maximum)                      2 Chips = .070" x .070" x .050" depth (maximum)                      3-4 Chips = .055" x .055" x .040" depth (maximum)                      5-8 Chips = .045" x .045" x .030" depth (maximum)                      &gt;8 Chips not acceptable</p> <p><b>All Chips must be flaked out</b>                      Note : Hanging Chip(s) Not Allowed</p>	<p align="center"><b>Chip still attach</b></p>  <p align="center"><b>Chip popped out</b></p>  <hr/> <p align="center"><b>Scratches are Acceptable</b></p>  <p align="center"><b>Surface Scratch</b></p>  <p align="center"><b>Surface Scratch</b>                      (nothing worse than this)</p>	<p><b>Method:</b> Visual inspect under inspection light. Verify with 7x magnification loupe, inspection card or caliper.  <b>Sample Size:</b> 100%</p>
<p>2) Inspect <b>Holes and Blemishes</b>:</p> <p>None &gt; 0.020"                      No more than 5 holes and/or blemishes <b><u>total</u></b> per part allowed</p>		<p><b>Method:</b> Visual inspect under inspection light. Verify with 7x magnification loupe, inspection card or caliper.  <b>Sample Size:</b> 100%</p>

<p>3) Inspect for <b>Cracks:</b></p> <p>None Allowed</p> <p><i>For D-29XX Material Only:</i>  <i>Parts must be inspected for cracks by holding parts up to high intensity light.</i></p>		<p><b>Method:</b> Visual inspect under inspection light. Verify with 7x magnification loupe</p> <p><b>Sample Size:</b> 100%</p>
<p>4) Inspect for <b>Laminations:</b></p> <p>None Allowed</p>		<p><b>Method:</b> Visual inspect under inspection light.</p> <p><b>Sample Size:</b> 100%</p>
<p>5) All materials must clean-up</p>		<p><b>Method:</b> Visual</p> <p><b>Sample Size:</b> 100%</p>
<p><b>6) For As Fired Parts Only:</b></p> <p><b>Pits</b> in the material resulted from the bedding from the firing process is <b>Acceptable.</b></p> <p>No Pits <math>\geq 0.040''</math> resulting from plate reaction.</p>		<p><b>Method:</b> Visual</p> <p><b>Sample Size:</b> 100%</p>
<p><b>6) For As Fired Parts Only (continue):</b></p> <p><b>Grit</b> – Minute rough granules, as of sand or stone</p> <p>Grit resulting from plate reaction must be removed prior to shipping.</p>	<p style="color: red; text-align: center;"><b>Not Acceptable</b></p>  <p style="text-align: center;">(Close Up View)</p>	<p><b>Method:</b> Visual</p> <p><b>Sample Size:</b> 100%</p>