
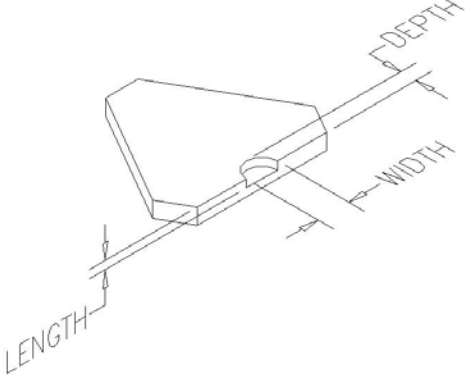




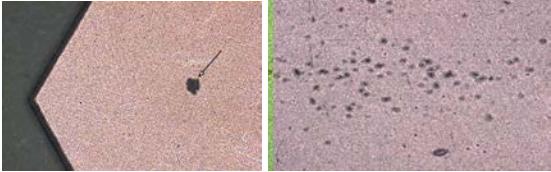
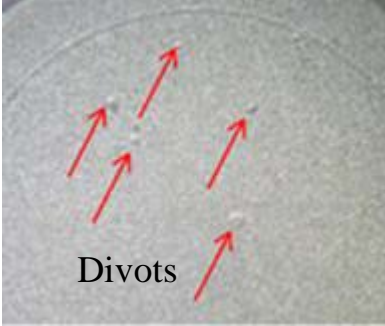

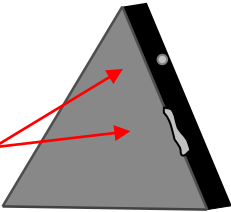
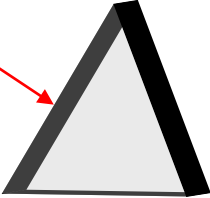
Inspection Method Sheet


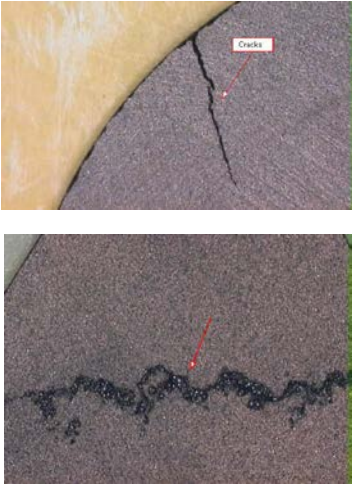
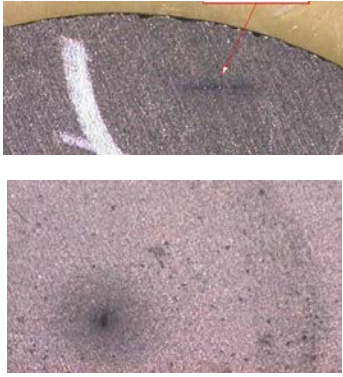
Part Number: Generic
Drawing Number: Generic
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Doc. #: TT-PC- 0439, Rev. 6

Part Name: Triangles
Operation: Final Inspection
Written By: Anna Huse
Date: 5/1/01

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

Description / Dimensions	Picture / Detail	Sample Size / Method / Standard
<p>1) Inspection for Chips (material broken off an edge or a corner):</p> <p>No more than 3 chips per part. Any chip under .020" is not recognized. The depth (surface) of the chip cannot exceed ½ of the parts length (thickness).</p> <p>Part Size – .500" and under No single edge chip ≥ .040" in width.</p> <p>Part Size – .500" up to 1.00" No single edge chip ≥ .075" in width.</p> <p>Part Size – Over 1.00" No single edge chip ≥ .100" in width.</p>	 	<p>Method: Visual using a 4X illuminated magnification or greater.</p> <p>Sample Size: Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p>2) Inspection for Holes (a pit on the surface of the part):</p> <p>No more than 2 holes per part</p> <p>Part Size – .500" and under No hole to exceed 0.025"</p> <p>Part Size – .500" up to 1.00" No hole to exceed .030".</p> <p>Part Size – Over 1.00" No hole to exceed .040"</p>	 	<p>Method: Visual using a 4X illuminated magnification or greater.</p> <p>Sample Size: Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>

<p>3) Inspection for Voids (a hole) and Divots (a dent) in the metallization surface.</p> <p>For Voids: No voids $\geq .030''$ No more than 5 voids per part.</p> <p>For Divots: No divot $\geq .100''$ No more than 5 divots per part.</p> <p>Note: No more than 5 of each defect allowed per part.</p>	<p style="text-align: center;">Voids</p>  <p style="text-align: center;">Divots</p> 	<p>Method: Visual using a 4X illuminated magnification or greater.</p> <p>Sample Size: Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p>4) Inspection for Excess metal on non-metalized surface:</p> <p>No metal $> 0.025''$ in greatest dimension allowed.</p>		<p>Method: Visual using a 4X illuminated magnification or greater.</p> <p>Sample Size: Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p>5) Inspection of excess metal on the O.D./edge:</p> <ul style="list-style-type: none"> No bridging allowed between top and bottom surfaces Parts are allowed to have excess metal on 1/3 of the thickness. Metal specks not allowed below 2/3 of the part thickness as measure from the metallized side 		<p>Method: Visual using a 4X illuminated magnification or greater.</p> <p>Sample Size: Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p>6) Inspection for Pull-back (the ceramic gap between the edge of the part and where the metal begins on the metallized surface):</p> <p>All Part Sizes The pull back can not be $> 0.015''$</p>	<p style="text-align: center;">Pull-back</p> 	<p>Method: Visual using a 4X illuminated magnification or greater.</p> <p>Sample Size: Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>

<p>7) Inspection for Visual Imperfections on the metalized surface:</p> <ul style="list-style-type: none"> No surface imperfections, blisters, debris, excess metal etc. > 0.040" in greatest dimension No discernable surface condition that alters the surface uniformity by producing visible peaks and build-up 		<p>Method: Visual using a 4X illuminated magnification or greater.</p> <p>Sample Size: Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p>8) Inspection for Cracks and Laminations:</p> <p>None allowed</p>		<p>Method: Visual using a 4X illuminated magnification or greater.</p> <p>Sample Size: Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p>9) Inspection for Material Imperfections (Kiln Reaction , Large Grains, Contamination):</p> <p>None allowed</p>		<p>Method: Visual using a 4X illuminated magnification or greater.</p> <p>Sample Size: Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>