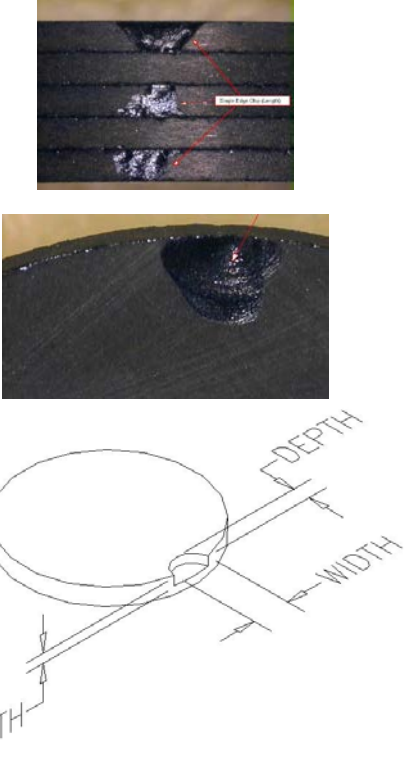
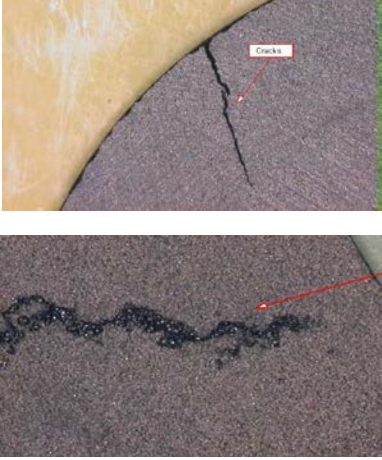


**Inspection Method Sheet**

**Part Number:** Generic  
**Drawing Number:** Generic  
**Page** 1 of 3  
**Doc. #:** TT-PC-0440, Rev. 10

**Part Name:** Disks  
**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><b>1) Inspection for Chips</b>, 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 of the chip cannot exceed 1/2 of the parts thickness</p> <p><b>Part Size – .500" and under</b>            No single edge chip ≥ .050" in length and width.</p> <p><b>Part Size – .500" up to 1.00"</b>            No single edge chip ≥ .075" in length and width.</p> <p><b>Part Size – Over 1.00"</b>            No single edge chip ≥ .100" in length and width.</p>		<p><b>Method:</b> Visual using a 4X illuminated magnification or greater.</p> <p><b>Sample Size:</b> Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p><b>2) Inspection for Cracks and Laminations:</b></p> <p>None allowed</p>		<p><b>Method:</b> Visual using a 4X illuminated magnification or greater.</p> <p><b>Sample Size:</b> Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>

**3) Inspection for Holes**, a pit on the surface of the part.

No more than 2 holes per part

**Part Size – .500” and under**

No hole to exceed 0.025”

**Part Size – .500” up to 1.00”**

No hole to exceed .030”.

**Part Size – Over 1.00”**

No hole to exceed .040”



**Method:** Visual using a 4X illuminated magnification or greater.

**Sample Size:** Refer to appropriate flow chart in TT-PC-0186 for inspection level.

**4) Inspection for Material Imperfections** (Kiln Reaction , Large Grains, Contamination):

None allowed



**Method:** Visual using a 4X illuminated magnification or greater.

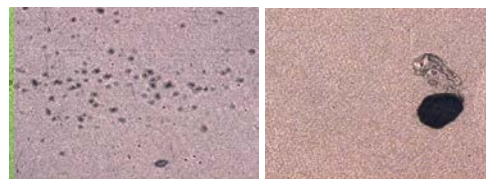
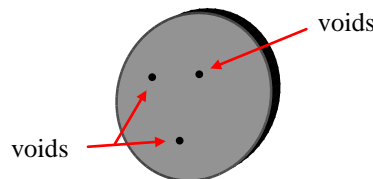
**Sample Size:** Refer to appropriate flow chart in TT-PC-0186 for inspection level.

**5) Inspection for Voids (a hole) and Divots** (a dent) in the metallization surface.

**For Voids:**

No voids  $\geq$  .040”

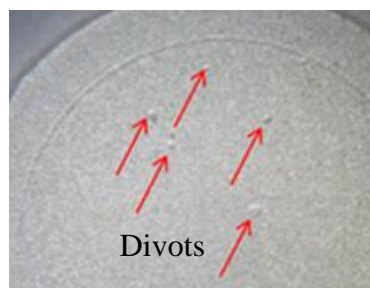
No more than 5 voids per part.



**For Divots:**

No divot  $\geq$  .100”

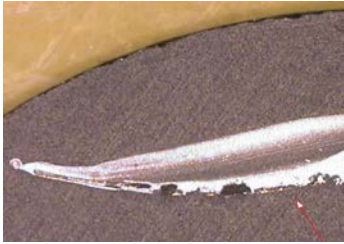
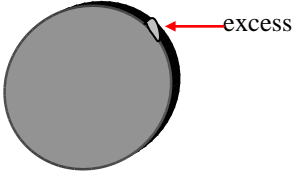
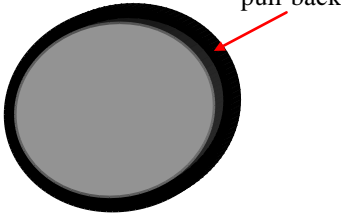
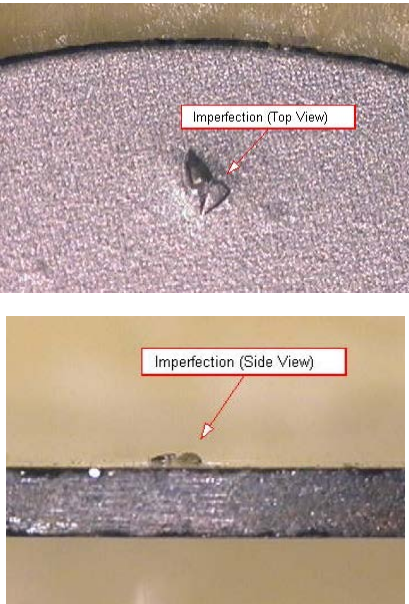
No more than 5 divots per part.



**Note:** No more than 5 of each defect allowed per part.

**Method:** Visual using a 4X illuminated magnification or greater.

**Sample Size:** Refer to appropriate flow chart in TT-PC-0186 for inspection level.

<p><b>6) Inspection for Excess metal on non-metalized surface:</b></p> <p>No metal &gt; 0.025” in greatest dimension allowed.</p>		<p><b>Method:</b> Visual using a 4X illuminated magnification or greater.</p> <p><b>Sample Size:</b> Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p><b>7) Inspection of excess metal on the O.D./edge:</b></p> <ul style="list-style-type: none"> <li>• No bridging allowed between top and bottom surfaces</li> <li>• Parts are allowed to have excess metal on 1/3 of the thickness.</li> <li>• Metal specks not allowed below 2/3 of the part thickness as measure from the metalized side.</li> </ul>		<p><b>Method:</b> Visual using a 4X illuminated magnification or greater.</p> <p><b>Sample Size:</b> Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p><b>8) Inspection for Pull-back</b> (the ceramic gap between the edge of the part and where the metal begins on the metalized surface):</p> <p><b>All Part Sizes</b> The pull back can not be &gt;0.015”</p>		<p><b>Method:</b> Visual using a 4X illuminated magnification or greater.</p> <p><b>Sample Size:</b> Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>
<p><b>9) Inspection for visual imperfections on the metallized surface:</b></p> <ul style="list-style-type: none"> <li>• No surface imperfections, blisters, debris, excess metal etc. &gt; 0.040” in greatest dimension</li> <li>• No discernable surface condition that alters the surface uniformity by producing visible peaks and build-up</li> </ul>		<p><b>Method:</b> Visual using a 4X illuminated magnification or greater.</p> <p><b>Sample Size:</b> Refer to appropriate flow chart in TT-PC-0186 for inspection level.</p>