
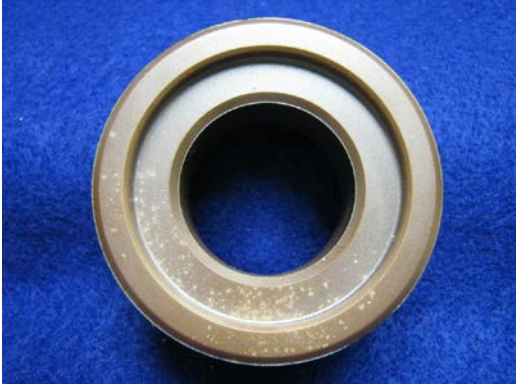
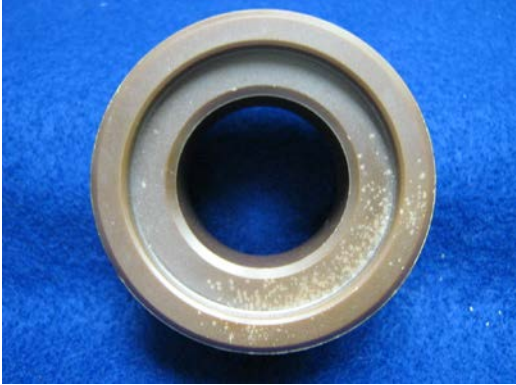


**Inspection Method Sheet**

**Part Number:** Generic  
**Drawing Number:** Generic  
**Page** 1 of 3  
**Doc. #:** TT-PC-0216 Rev. 12

**Part Name:** Class I Chip Spec PCN & B/S  
**Operation:** V/M Inspection  
**Written By:** S. Winpigler  
**Date:** 05-06-99

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

Description / Dimensions	Picture / Detail	Sample Size / Method / Standard
<p>1) Inspect for <b>Holes and Blemishes:</b></p> <p>None &gt; 0.020</p> <p>No more than 5 holes and/or blemishes total per part allowed</p> <hr/> <p><b>Nicks</b> – <i>small marks, A shallow notch, cut, or indentation on an edge or a surface.</i></p> <p>Are acceptable to a minium.</p>	 <p style="text-align: center;"><b>Rejected</b></p> <hr/>  <p style="text-align: center;"><b>Acceptable Nicks – No More</b></p> <hr/>  <p style="text-align: center;"><b>Too Many Nicks – Reject</b></p>	<p><b>Method:</b> Visual inspect under inspection light and/or inspection card. Verify with 7x magnification loupe or calipers.</p> <p><b>Sample Size:</b> 100%</p>

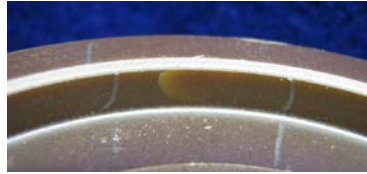
2) Inspect for **Chips:**

Any chips under 0.020" is not recognized.

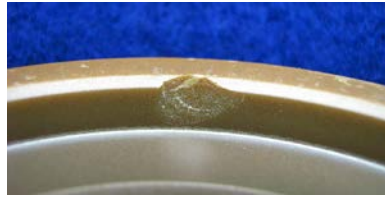
- 1 Chip = .150" x .150" x .100" depth (maximum)
- 2 Chips = .100" x .100" x .070" depth (maximum)
- 3-4 Chips = .080" x .080" x .060" depth (maximum)
- 5-8 Chips = .070" x .070" x .050" depth (maximum)
- >8 Chips not acceptable

**All Chips must be flaked out**

Note : Hanging Chip(s) Not Allowed



**Chip still attached**



**Pop-Out Chip**

**Scratches are Acceptable**



**Surface Scratch**



**Surface Scratch**

*(nothing worse than this)*

**Method:** Visual inspects under inspection light and/or inspection cards. Verify with 7x magnification loupe, inspection card or calipers.

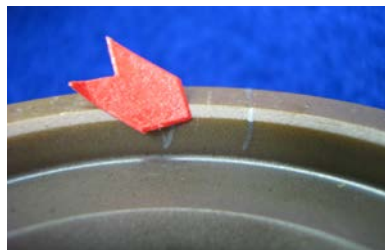
**Sample Size: 100%**

3) Inspect for **Cracks:**

None Allowed

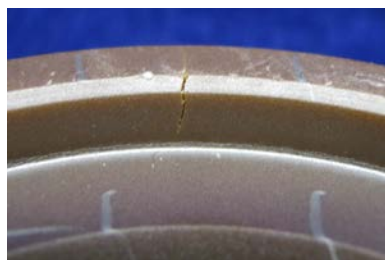
For D-29XX Material Only:

Parts must be inspected for cracks by holding parts up to high intensity light.



**Acceptable**

*(No gap in the material)*




**Rejected**

*(Gap in the material)*

**Method:** Visual inspect under inspection light and/or inspection card. Verify with 7x magnification loupe.

**Sample Size: 100%**

4) Inspect for <b>Laminations:</b>		<b>Method:</b> Visual inspect under inspection light. Verify with 7x magnification loupe. <b>Sample Size:</b> 100%
5) All Material must clean-up		<b>Method:</b> Visual inspect under inspection light. <b>Sample Size:</b> 100%
6) <b>For As Fired Parts Only:</b>  Pits in the material resulted from the bedding from the firing process is <b>Acceptable.</b>		<b>Method:</b> Visual <b>Sample Size:</b> 100%