
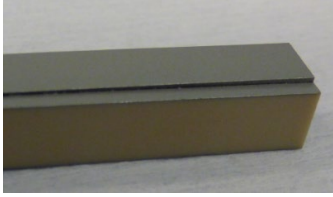
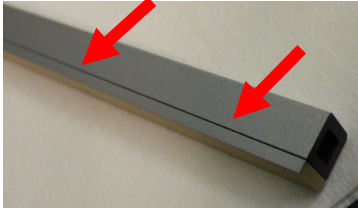
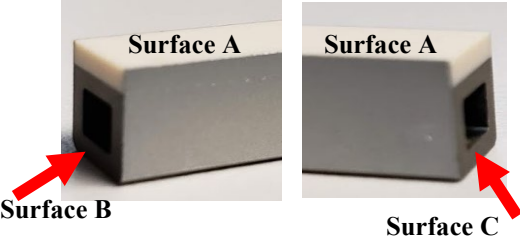


Inspection Method Sheet

Part Number: Generic
Drawing Number: Generic
Page 1 of 4
Doc. #: TT-PC-0827, Rev. 5

Part Name: Plated Assembly Toroid
Operation: Final Inspection
Written By: Myra Cope
Last Update: 12-15-21

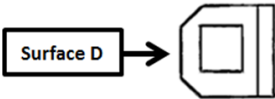

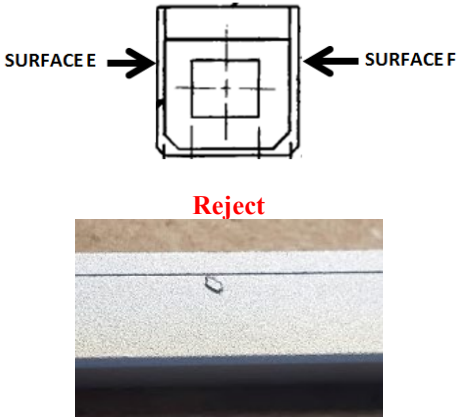
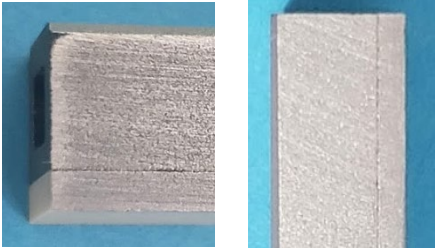
Applicable customer specifications take precedence over this procedure (reference customer drawing).

Description / Dimensions	Picture / Detail	Sample Size / Method / Standard
1) Verify Marking:	Example: Orange Line Across Dielectric Material 	Method: Visual Sample Size: 100%
2) Inspection for Mismatched Garnet and Dielectric: None allowed		Method: Visual using a 4X magnification Sample Size: 100%
3) Inspection for Cracks and Laminations: None allowed		Method: Visual using a 4X magnification Sample Size: 100%
4) Inspection bond line: <ul style="list-style-type: none"> Must be even from one end to another No visible separation between rib and toroid 		Method: Visual using a 4X magnification Sample Size: 100%
5) Inspection for Plating: No plating allow on Surface A (<i>top</i>), B (End), C (End) and Inside the toriod cavity <i>(Reference Note 2)</i>		Method: Visual using a 4X magnification Sample Size: 100%

Inspection Method Sheet

Part Number: Generic
Drawing Number: Generic
Page 2 of 4
Doc. #: TT-PC-0827, Rev. 5

Part Name: Plated Assembly Toroid
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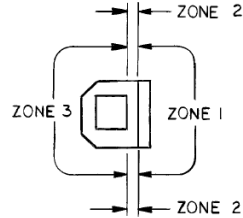
<p>6) Inspect for Voids on Surface D :</p> <ul style="list-style-type: none"> Voids $\leq 0.025''$ Metallization not to extend into the chamfer. <p style="text-align: center;"><i>(Reference Note 2)</i></p>		<p>Method: Visual using a 4X magnification</p> <p>Sample Size: 100 %</p>
<p>7) Inspect for plating surface defects:</p> <ul style="list-style-type: none"> None Allowed No Missing Chromate No Contamination, Ridges, Fins, Burrs. <p>Do Not Use Eraser On Plating</p>		<p>Method: Visual using a 4X magnification</p> <p>Sample Size: 100 %</p>
<p>8) Inspect for Plating Nodules or Burr:</p> <ul style="list-style-type: none"> None Allowed <p>Plated Surface, E and F, shall be smooth to touch.</p> <p style="text-align: center;"><i>(Reference Note 10)</i></p>		<p>Method: Visual using a 4X magnification</p> <p>Sample Size: 100 %</p>
<p>9) Inspect for Scratches or Fixture rub:</p> <ul style="list-style-type: none"> No more than 3 scratch allowed to exceed 0.250'' No exposed ceramic allowed 		<p>Method: Visual using a 4X magnification</p> <p>Sample Size: 100 %</p>
<p>10) Inspect for Foreign Object Deris (OD):</p> <p>Examples but not limited to:</p> <ul style="list-style-type: none"> Manufacturing by products and materials No Small debris Dust/Dirt from bend tops or equipment Figure oils or lotion Fibers or hair 		<p>Method: Naked Eye, verify with 4x</p> <p>Sample Size: 100 %</p>

Inspection Method Sheet

Part Number: Generic
Drawing Number: Generic
Page 3 of 4
Doc. #: TT-PC-0827, Rev. 5

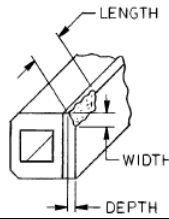
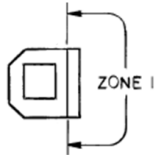
Part Name: Plated Assembly Toroid
Operation: Final Inspection
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Last Update: 12-15-21

Zone Diagram: (Reference page 10)



11) Inspection for Zone 1 Chip-Rib
 (Longitudinal or Lengthwise):

Length: 0.200"
Depth: 0.040"
Width: 0.020"

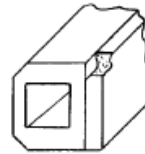


Method: Visual using a 4X magnification

Sample Size: 100 %

12) Inspection for Zone 1 Chip-Rib (End):

Length: 0.030"
Depth: 0.064"
Width: 0.020"

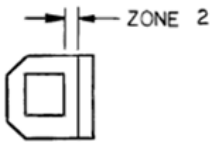


Method: Visual using a 4X magnification

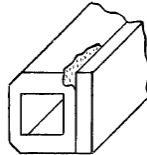
Sample Size: 100 %

13) Inspection for Zone 2 Chip-Toroid
 (Longitudinal or Lengthwise):

Length: 0.200"
Depth: 0.063"
Width: 0.020"



Toroid Wall Adjacent To Rib

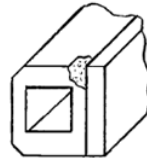


Method: Visual using a 4X magnification

Sample Size: 100 %

14) Inspection for Zone 2 Chip-Toroid
 (End):

Length: 0.030"
Depth: 0.047"
Width: 0.050"

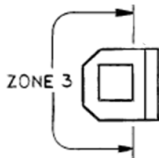


Method: Visual using a 4X magnification

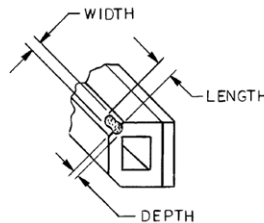
Sample Size: 100 %

15) Inspection for Zone 3 Chip-Toroid
 (Longitudinal or Lengthwise):

Length: 0.400"
Depth: 0.125"
Width: 0.030"



Zone 3 Lognitudinal or Lenthwise



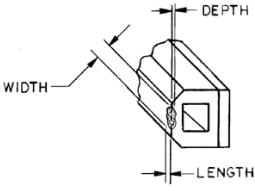


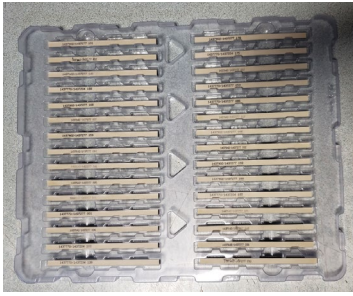
Method: Visual using a 4X magnification

Sample Size: 100 %

Inspection Method Sheet

Part Number: Generic
Drawing Number: Generic
Page 4 of 4
Doc. #: TT-PC-0827, Rev. 5

Part Name: Plated Assembly Toroid
Operation: Final Inspection
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<p>16) Inspection for Zone 3 Chip-Toroid (End):</p> <p>Length: 0.020" Depth: 0.060" Width: 0.025"</p>	<p style="text-align: center;"><u>Zone 3 End</u></p>  <p>The diagram shows a 3D perspective view of a chip-toroid. Three dimensions are labeled with arrows: 'WIDTH' points to the side edge, 'DEPTH' points to the top edge, and 'LENGTH' points to the front edge.</p>	<p>Method: Visual using a 4X magnification</p> <p>Sample Size: 100 %</p>
<p>17) Hanging Chips (Attached chip):</p> <p>None Allowed</p>	<p style="text-align: center;">Hanging Chip Example</p>  <p>A close-up photograph of a circular toroid with a small, irregularly shaped chip protruding from its surface.</p>	<p>Method: Visual using a 4X magnification</p> <p>Sample Size: 100 %</p>
<p>18) Inspection for Feathering:</p> <p>None Allowed</p>	 <p>A photograph showing a rectangular toroid with a light-colored, irregular, feathered edge on one side, set against a blue background.</p>	<p>Method: Visual using a 4X magnification</p> <p>Sample Size: 100 %</p>
<p>19) Inspect All Trays:</p> <p>Ensure trays are clean of FOD. Trays must be cleaned prior to packaging parts.</p> <p>Examples but not limited to:</p> <ul style="list-style-type: none">• No Small debris• Dust/Dirt• Figure oils or lotion• Fibers or hair	 <p>A photograph of a rectangular tray filled with numerous small toroids arranged in rows.</p>	<p>Method: Visual</p> <p>Sample Size: 100 %</p>