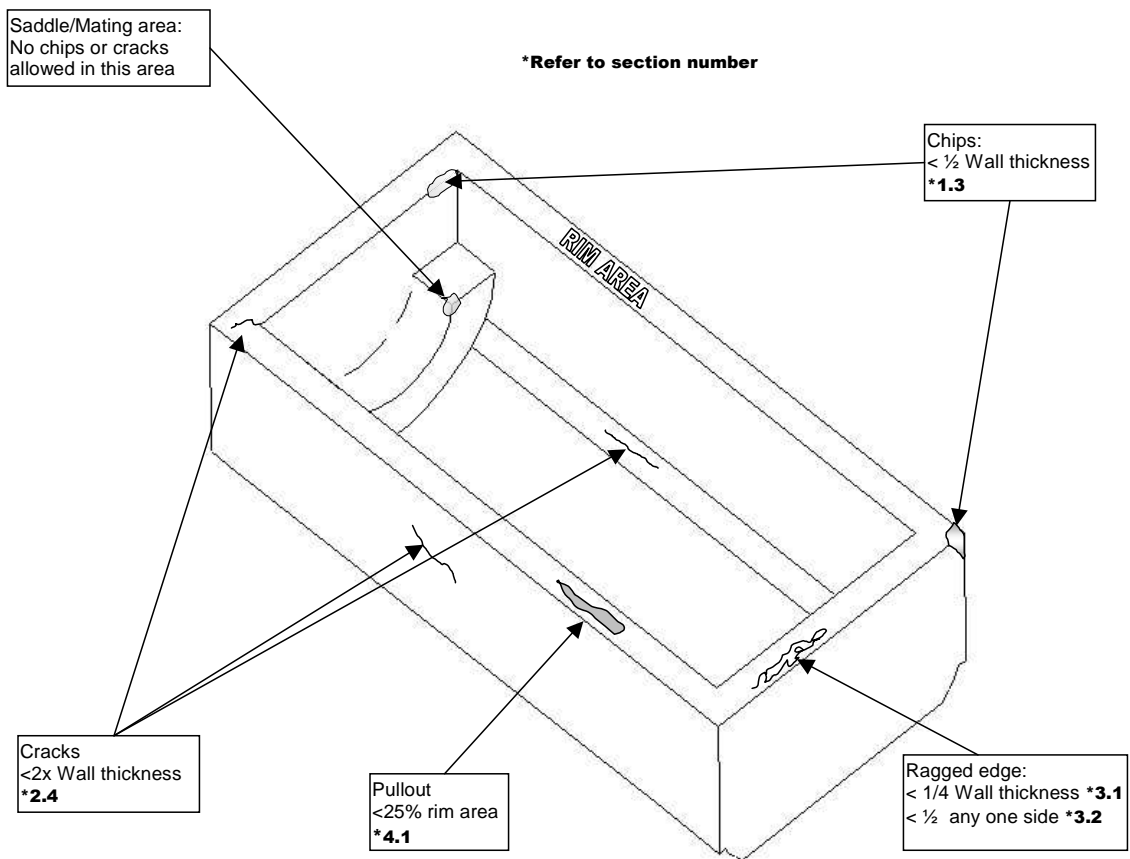
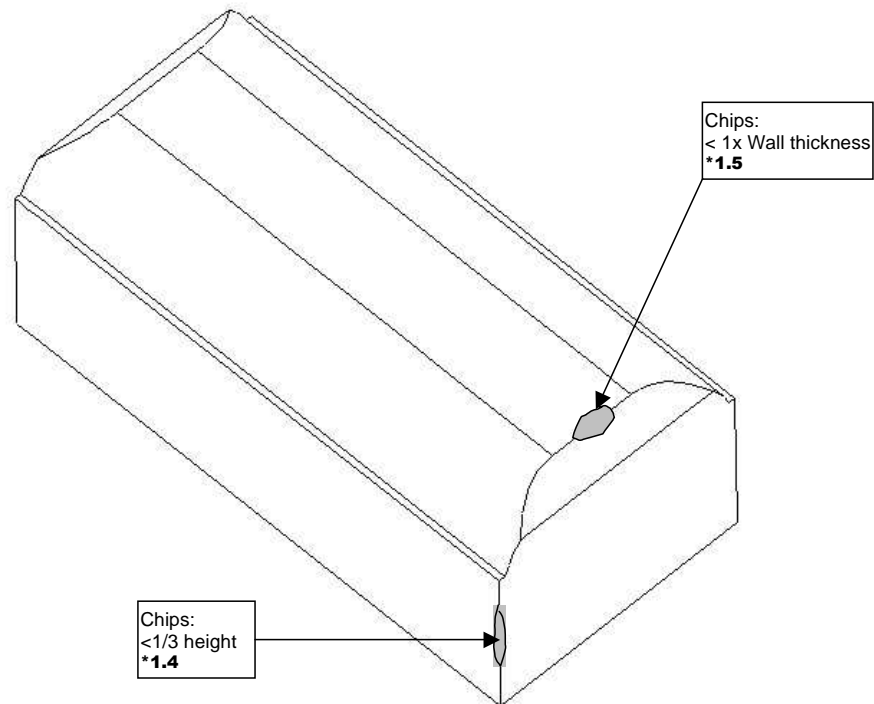


TITLE: BASKET CORES	EFFECTIVE: 02/25/03 Rev.0
DEVELOPED BY: Ginny Jacob	SUPERSEDES: Rev NONE
UPDATE RESPONSIBILITY: QUALITY ASSURANCE TECHNICIAN	APPROVAL:

Basket Cores – Generic



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1.0 Chips:

- 1.1 Parts with more than three (3) chips are unacceptable.
- 1.2 Parts with more than two (2) chips on any one (1) surface are unacceptable
- 1.3 Chips on the rim which are either longer or wider than 1/2 of the wall thickness are unacceptable.
- 1.4 Chips on the Corners which are longer than 1/3 of the overall height of the core are unacceptable.
- 1.5 Chips on the Back wall cannot exceed the thickness of the Wall
- 1.6 Chips on the Saddle are unacceptable

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2.0 Cracks:

- 2.1 Parts with more than three (3) cracks are unacceptable.
- 2.2 Cracks on the Back wall are unacceptable.
- 2.3 More than two (2) cracks on any one (1) surface are unacceptable.
- 2.4 The Length of any Crack cannot exceed Twice the wall thickness.
- 2.5 Cracks on the Saddle are unacceptable.
- 2.6 A single continuous crack cannot extend into two (2) surfaces.

3.0 Ragged Edges:

- 3.1 Ragged edges that penetrate more than 1/4 into the thickness of the part are unacceptable.
- 3.2 Ragged edges that extend around more than 1/2 of any one (1) side are unacceptable.
- 3.3 Sharp edges are unacceptable.

4.0 Pullouts:

- 4.1 Pull-Outs on any one (1) surface cannot exceed 25% of the surface area.
- 4.2 Pull-Outs cannot exceed .005 inches in depth.

5.0 Pits and Bumps:

- 5.1 Pits /Bumps with diameters greater than .025 inches are unacceptable and are to be considered chips.
- 5.2 Parts with more than three pits / bumps are unacceptable.

6.0 Cleanliness:

- 6.1 Stains and discolorations that do not affect the performance of the part are acceptable.
- 6.2 All surfaces of the core should be free of loose particles or any other matter.

7.0 Note: Cores to be inspected under good light conditions, but without any visual magnification.

8.0 Revision History:

Revision Number	Reason for Change	Revision Date