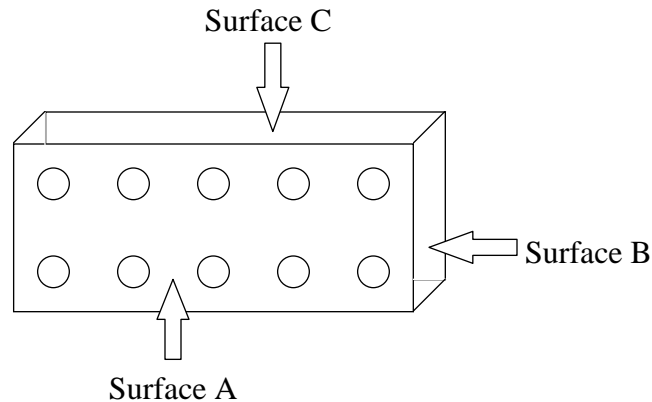


TITLE: MULTIHOLE PLATES	EFFECTIVE: June 6, 2014 Rev. 3
DEVELOPED BY: FRANKLIN DEMUTH	SUPERSEDES: Rev. 2
UPDATE RESPONSIBILITY: QUALITY DEPARTMENT	

0.0 Multihole Plates - Generic



1.0 Chips:

- 1.1 Chips which are deeper than .020 inches are unacceptable.
- 1.2 Chips which penetrate the holes on Surface A are unacceptable.
- 1.3 Chips which extend more than 1/2 of the way down the corner of a part are unacceptable.
- 1.4 Chips on Surface A which are longer or wider than 1/5 of the width of the part (B dimension) are unacceptable.
- 1.5 Parts with more than two chips are unacceptable.

2.0 Cracks:

- 2.1 Cracks radiating from the holes on Surface A are unacceptable.
- 2.2 Cracks which run up and down the C dimension on Surface B or Surface C are unacceptable.
- 2.3 Surface crazing is acceptable.

3.0 Ragged Edges:

- 3.1 For parts which are shorter than 1.000 inches, ragged edges which penetrate more than .010 inches into the part are unacceptable.
- 3.2 For parts which are not shorter than 1.000 inches, ragged edges which penetrate more than .025 inches into the part are unacceptable.

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3.3 Ragged edges which penetrate the holes on Surface A are unacceptable.

4.0 Pits and Bumps:

4.1 Pits which do not exceed .025 inches in diameter are acceptable.

4.2 Bumps which do not exceed .010 inches in height are acceptable.

5.0 Stains and Discolourations:

5.1 Stains and discolourations which do not affect the performance of the part are acceptable.

6.0 Faced Multihole Plates:

6.1 On faced multihole plates, parts with visibly discernable slants are unacceptable.

6.2 Questionable parts should be referred to the team leader responsible for the part or a QC Inspector.

7.0 Pullout:

7.1 Minor to moderate pullout on surfaces to be faced is acceptable. Parts with major or questionable pullout should be referred to a QC Inspector.

8.0 Blocked ID's

8.1 Blocked ID's are unacceptable.

9.0 Revision History:

Revision Number	Reason for Change	Revision Date
1	Tightened spec in 1.4; added 4.2	4/1/98
2	Removed section 7.2	10/12/12
3	Added section 8.0 and 8.1	6/6/14