

TITLE: TACK BOBBINS	EFFECTIVE: March 21, 2011 Rev. 1
DEVELOPED BY: John Lynch	SUPERSEDES: 0
UPDATE RESPONSIBILITY: Quality Department	

## 0 Tack Bobbins – General

0.1 Refer to the most current revision of the Fair-Rite Products document *Visual Inspection – Definitions & General Criteria* for irregularity definitions.

## 1 Tack Bobbins

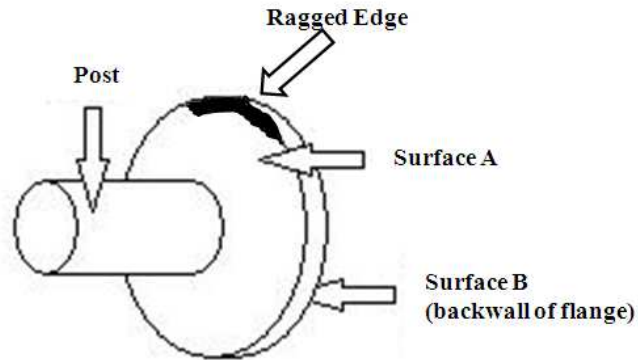


Figure 1

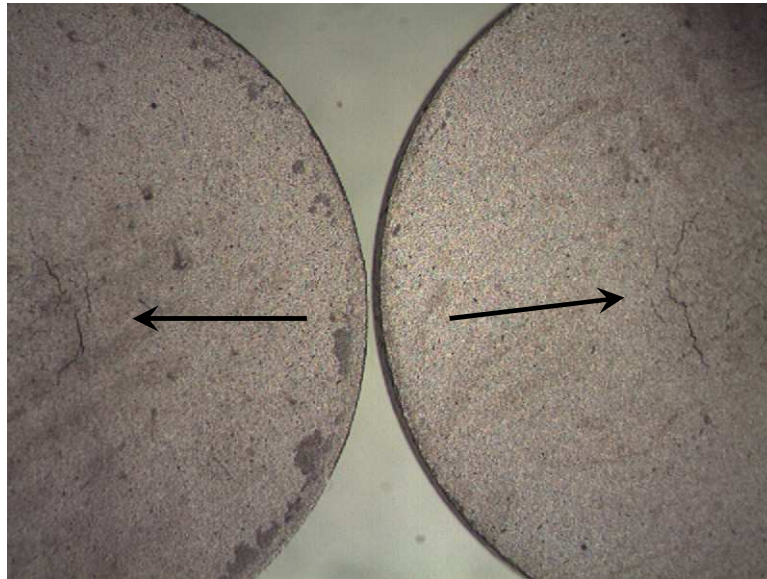


Figure 2 (particle separation)

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### 1.1 Limits for Irregularities:

Type	Location	Max. Size Allowed	Max Count Allowed
Chips	Post top & wall	Longer or wider than 1/2 the post OD for post OD<.250", 1/3 the post OD for OD>.250" are unacceptable.	2 on each surface, 3 total
	Surface A, B, & between A & B	Longer or wider than 1/3 of the diameter of the post are unacceptable.	2 on each surface, 3 total
Cracks	Surface A, B	Cracks which radiate more than 1/4 of the way from the post (or the centre of the part) to the edge of the part are unacceptable.	2 total
	Interface between post and flange	Unopened cracks in this area are acceptable.	NA
	Between surface A & B	Cracks which extend more than 1/2 of the way around the circumference of the part are unacceptable	2 total
Particle Separation	Flange (Figure 2)	No limit On tack bobbins this is typically found in the center of the backwall(flange) on the bottom of the part due to an inherent lower density in this area. Looks like a separation of particles.	N/A
Ragged Edges	All surfaces	1/5 distance between center post and outer edge of flange(See Figure 1)	1/4 circumference
Pits, Bumps	All	.020" in diameter and do not interfere with part size.	3 total
Stains, Discolorations	All	Stains and discolorations which do not affect the performance of the part are acceptable.	Unlimited
Crazing	All surfaces	No limit.	N/A
Flash	All surfaces	Flash is allowed unless the part is burnished. If the part is burnished, no flash is allowed. Flash can never interfere with part size.	N/A

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Type	Location	Max. Size Allowed	Max Count Allowed
Pullout	All Surfaces	For tack bobbins which are less than 1/2 of an inch in diameter, pullout which extends further than .002 inches into the part is unacceptable. For tack bobbins which are greater than or equal to 1/2 inch in diameter, pullout which extends further than .004 inches into the part is unacceptable.	1/2 area of any surface

## 2 Associated Documents:

### 2.1 Fair-Rite Products: *Visual Inspection – Definitions & General Criteria*

## 3 Revisions:

Revision Number	Reason for Change	Revision Date
1	Revised the complete VIC	3/21/11

## References:

International Electrotechnical Commission (IEC) International Standard 60424-1: *Ferrite Cores – Guide on the Limits of Surface Irregularities Part 1: General specification* (First Edition 1999-05)