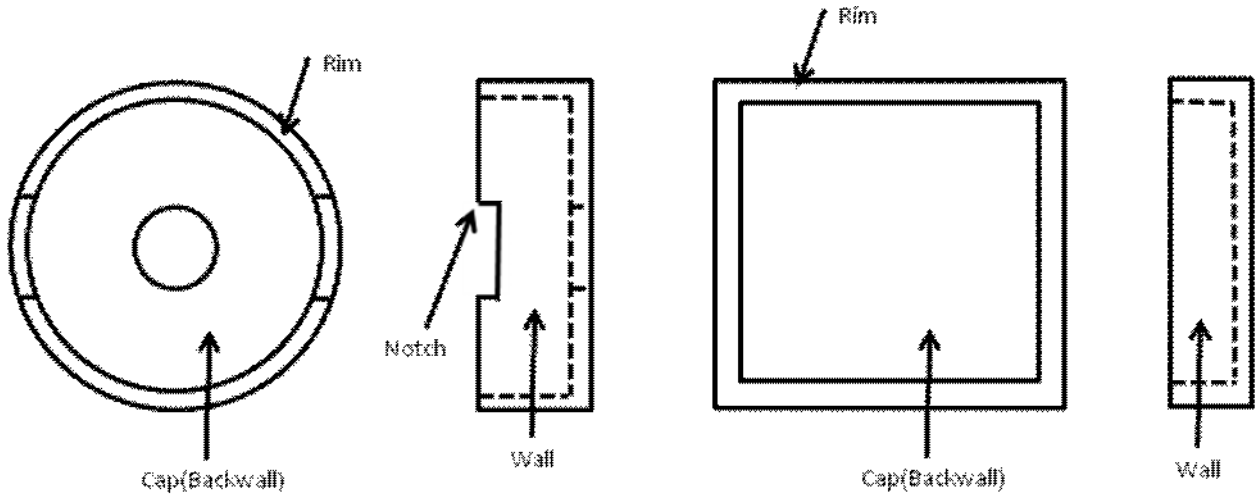
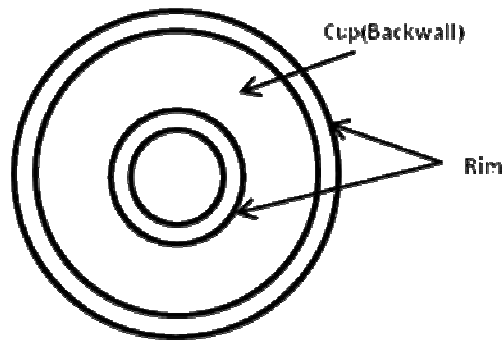


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UPDATE RESPONSIBILITY: Quality Department		



Cup core

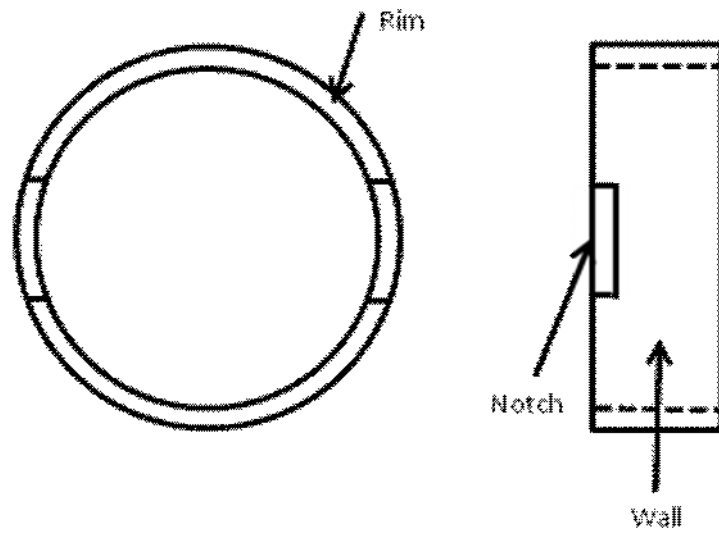
Rectangular Cup core



Cup core

<b>TITLE:</b> CUP CORES and SLEEVES
<b>DEVELOPED BY:</b> John Lynch
<b>UPDATE RESPONSIBILITY:</b> Quality Department

<b>EFFECTIVE:</b> September 24, 2013 <b>Rev. 2</b>
<b>SUPERSEDES:</b> Rev 1



Sleeve

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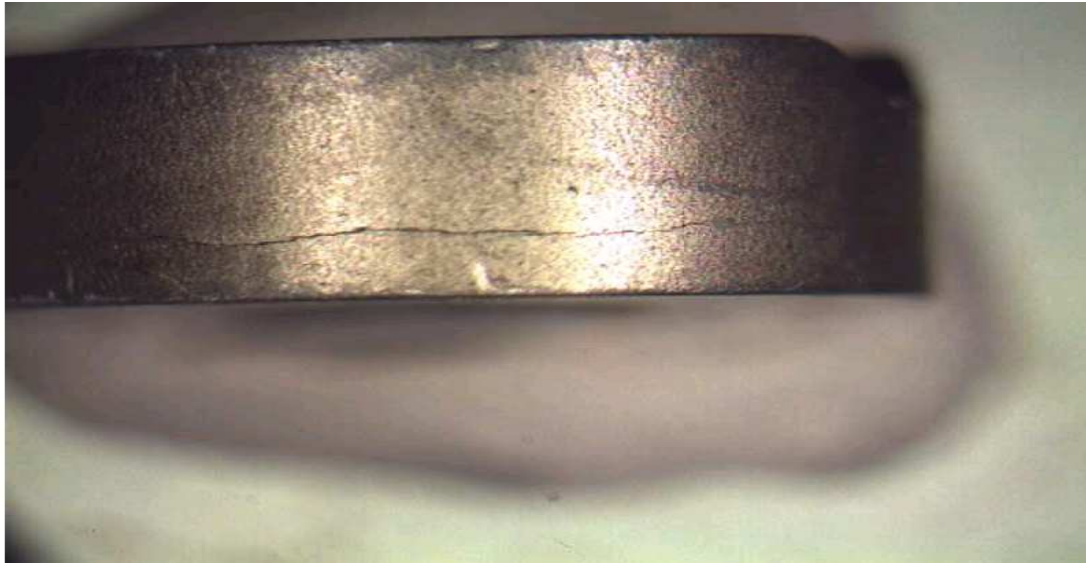


Figure 1

Pull a random sample of parts for visual inspection based on a c=0 sampling plan with an AQL of 0.25. See chart listed in SOP I&T-01. All inspections listed below shall be done at 10X magnification unless otherwise specified.

**1.0 Limits for Irregularities:**

Type	Location	Max. Size Allowed	Max Count Allowed
Chips	Rim including any notches	10% of rim area	No limit on number, total coverage <10%
	Wall & backwall	10% of surface	No limit on number, total coverage <10%
Cracks	Interface between wall & backwall	Unopened cracks in this area are acceptable.	NA
	Backwall	Longer than 1/4 of the distance from the inner diameter(hole) or part center to the inner wall are unacceptable.	2 total

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Type	Location	Max. Size Allowed	Max Count Allowed
	Parallel to the circumference	Cumulative length equal to 33.3% (1/3) of the relative core circumference. Open cracks, or cracks which weaken the part are not allowed. Refer to figure 1 for an example of an unacceptable open crack. See engineering for clarification if needed.	Unlimited up to cumulative length allowance
Particle Separation	Backwall	No limit This is typically found in the center of the backwall 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	30% of rim and backwall surfaces.	No limit on number, total coverage <30% of perimeter
Pits, Bumps	All	Bumps not to interfere with dimensions, pits no larger than 5% of surface area.	3 total
Stains, Discolorations	All	Stains and discolorations which do not affect the performance of the part are acceptable.	No limit on number
Crazing	All surfaces	N/A	N/A
Flash	All surfaces, OD or smaller overall dimension less than .250"	.002" max height over full perimeter, with a max thickness of .002"	N/A
	All surfaces, OD or smaller overall dimension greater than .250"	.003" max height over full perimeter, with a max thickness of .003"	N/A

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<b>Type</b>	<b>Location</b>	<b>Max. Size Allowed</b>	<b>Max Count Allowed</b>
Pullout	All Surfaces with exception of inside of backwall(flo or of cup)	Pullout which extends further than .003 inches into the part is unacceptable.	No limit, 25% of each area.
	Inside of backwall (floor of cup)	Pullout which extends further than .002 inches into the part is unacceptable	No limit

**2.0 Revision History:**

<b>Revision Number</b>	<b>Reason for Change</b>	<b>Revision Date</b>
1	Revised Complete VIC	11/10/11
2	Revised section 1.0	9/24/13