

TITLE: DISCS	EFFECTIVE: March 21, 2011 Rev. 1
DEVELOPED BY: FRANKLIN DEMUTH	SUPERSEDES: 0
UPDATE RESPONSIBILITY: QUALITY DEPARTMENT	

**0.0 Discs – Generic**

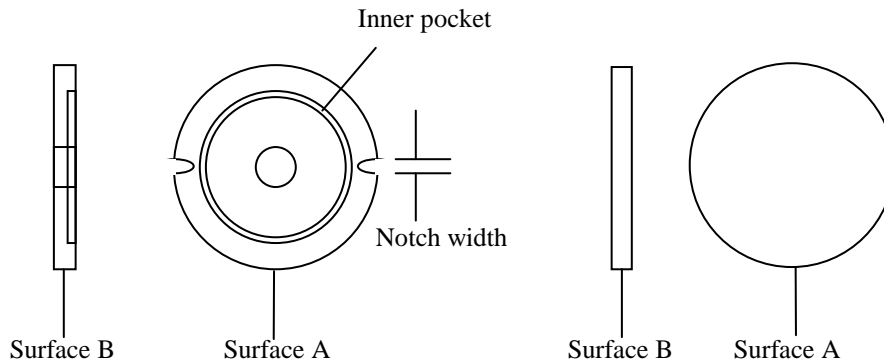


Figure 1

Figure 2

**1.0 Chips**

Core Size	Surface	Max. Size Allowed	Max Qty
Figure 1 Nominal OD of less than 1.00in. (25.4mm)	A	Chips on Surface A which are longer or wider than 1/3 of the distance between the outer diameter and the inner pocket are unacceptable. If a chip in the notch covers more than half the width of the notch, then the part is unacceptable.	3 each surface, 5 total
Figure 1 Nominal OD of less than 1.00in. (25.4mm)	B	Chips on Surface B which are longer than 1/3 of the height of the part (C dimension) or 2mm whichever is greater are unacceptable.	3 each surface, 5 total
Figure 1 Nominal OD of greater than or equal to 1.00in. (25.4mm)	A	Chips on Surface A which are longer or wider than 1/4 of the distance between the outer diameter and the inner pocket are unacceptable. If a chip in the notch covers more than half the width of the notch, then the part is unacceptable.	3 each surface, 5 total

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Core Size	Surface	Max. Size Allowed	Max Qty
Figure 1 Nominal OD of greater than or equal to 1.00in. (25.4mm)	B	Chips on Surface B which are longer than 1/3 of the height of the part (C dimension) or 2mm whichever is greater are unacceptable.	3 each surface, 5 total
Figure 2 With and without ID	A	Chips on Surface A which are longer or wider than 1/10 of outer diameter to a max of 7mm are unacceptable	3 each surface, 5 total
Figure 2 With and without ID	B	Chips on Surface B which are longer than 1/3 of the height of the part (C dimension) or 2mm whichever is greater are unacceptable.	3 each surface, 5 total

## 2.0 Cracks:

- 2.1 Parallel to the circumference with cumulative length equal to 1/3 of the relative core circumference. Radiating cracks less than 1/10 of outer diameter, maximum of 1 allowed. No open cracks allowed.

## 3.0 Ragged Edges:

- 3.1 Ragged edges which are a series of small chips usually along an edge having a width less than 1mm (0.039in) allowed around entire edge.

## 4.0 Pits:

- 4.1 See chip spec.

## 5.0 Stains and Discolourations:

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

## 6.0 Pullout:

- 6.1 No more than 1/4 of the area of any surface can be affected by pullout and must be less than .005" deep. Ground discs shall have no pullout.

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**7.0 Revision History:**

Revision Number	Reason for Change	Revision Date
1	Added Figure 2 and updated entire document	3/21/11