

TITLE: POT CORES	EFFECTIVE: 02/27/2008 Rev. 0
DEVELOPED BY: DAVID EBEL	SUPERSEDES: NONE
UPDATE RESPONSIBILITY: QUALITY ASSURANCE TECHNICIAN	

0 Pot Cores – General

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

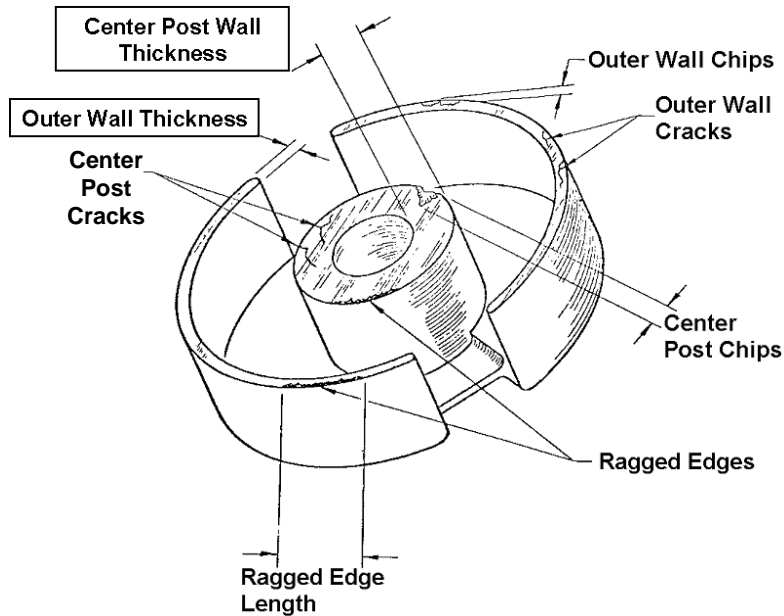


Figure 1

1 Total count limit for chips on any Pot Core is six (6) maximum, with no more than four (4) on any one (1) surface unless otherwise noted.

2 Limits for Mating Surface Irregularities – figure 1

Type	Location	Maximum Size Allowed	Max Qty
Chips	Outer Wall	Maximum size of a mating surface chip cannot be greater than 50% (½) the Outer Wall Thickness.	2
	Center Post* (ungapped)		
Cracks	Outer Wall	Cumulative length less than 50% (½) of Outer Wall thickness	--
	Center Post* (ungapped, with Hole)	Cumulative length less than 100% of Center Post Wall thickness. Single crack length less than 50% (½)	--
	Center Post* (ungapped, No Hole)	Cumulative length less than 25% (¼) of Center Post diameter.	--
Ragged Edges	Mating Surface Edges and ungapped Center Post*	Cumulative length less than 25% (¼) of the length of the relevant circumference.	--

* See section 3 – *Limits for Coil Space and Non-Mating Surface Center Post Irregularities* for gapped Center Post and Non-Mating Surface Center Post irregularities.

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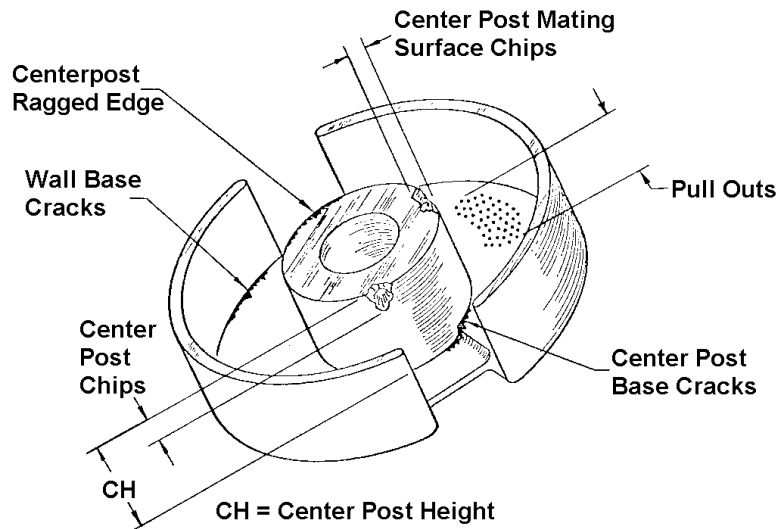


Figure 2

3 Limits for Coil Space and Non-Mating Surface Center Post Irregularities – figure 2

Type	Location	Maximum Size Allowed	Max Qty
Chips	Center Post, Non-Mating Surface	25% (1/4) of Center Post Height (CH)	3
	Center Post* (gapped, with hole)	Maximum size of a top surface chip cannot be greater than 50% (1/2) the Center Post wall thickness.	2
	Center Post* (gapped, no hole)	Maximum size of a top surface chip cannot be greater than 25% (1/4) the Center Post diameter.	
Cracks	Center Post Base	Cumulative length less than 25% (1/4) of the Center Post circumference - must be unopened.	--
	Outer Wall Base	Cumulative length less than 12% (1/8) of the Center Post circumference - must be unopened.	--
Ragged Edges	Center Post* (gapped)	100% of Center Post inner or outer Circumference	--
Pullout	Bottom of Coil Space	Less than 0.003in (0.076mm) deep	Less than 25% (1/4) of the bottom area
Sticking		Less than 0.001in (0.025mm) deep	100% of bottom area

* See section 2 - Allowable Mating Surface Irregularities for ungapped Center Post and Center Post Mating Surface criteria

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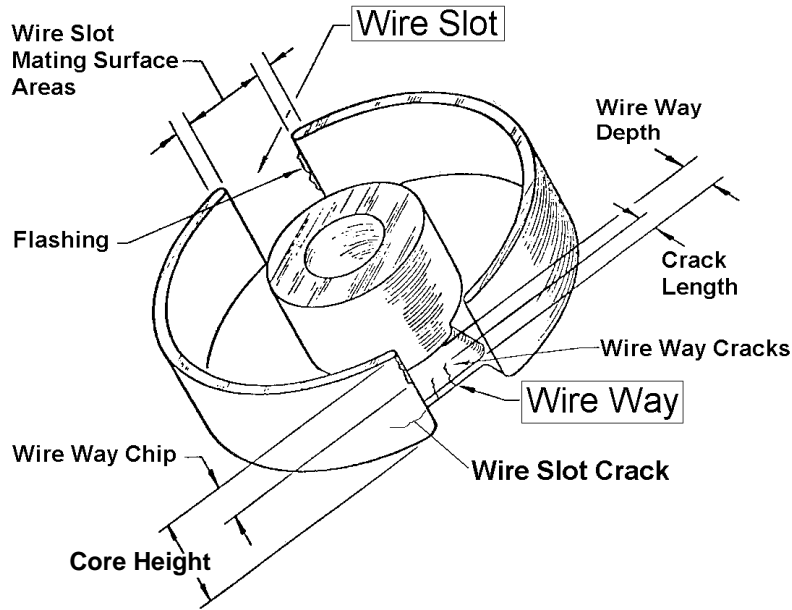


Figure 3

4 Limits for Wire Slot and Wire Way Area Irregularities– figure 3

Type	Location	Maximum Size Allowed	Max Qty	Notes
Chips	Wire Way	50% (½) of Core Height	2	Rule applies to chips beginning at the mating surface and down or beginning at the back surface up
	Wire Slot Mating Surface Areas	Width and length may be 100% of Outer Wall Thickness in size	4	
Cracks	Wire Way	Cumulative length less than 50% (½) of the Wire Way Depth	--	Applies to each Wire Way. Cracks must not be open
	Wire Slot	Less than 100% of the Outer Wall Thickness	4 per slot edge	
Flash	Wire Slot	0	0	Flash not allowed in Wire Slot area.

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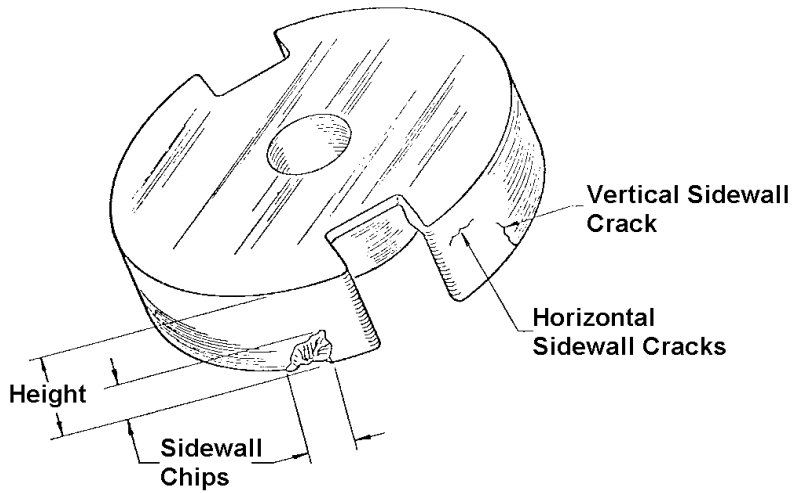


Figure 4

5 Limits for Exterior Wall Surface Irregularities – figure 4

Type	Location	Maximum Size Allowed	Max Qty
Chips	Sidewall	Less than 50% ($\frac{1}{2}$) of Core Height	4
Cracks	Sidewall (Horizontal)	None allowed	0
	Sidewall (Vertical)	Less than 25% ($\frac{1}{4}$) of Core Height	2

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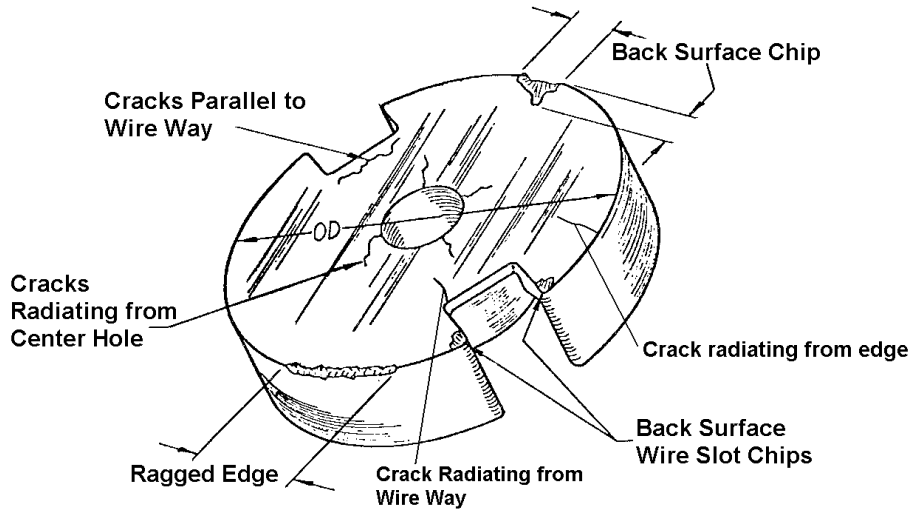


Figure 5

6 Limits for Back Surface Irregularities – figure 5

Type	Location	Maximum Size Allowed	Max Qty	Notes
Chips	Back Surface	Less than 50% ($\frac{1}{2}$) of the Core Height	4	
	Back Surface Wire Slot	100% Outer Wall thickness	4	
Cracks	Parallel to Wire Way	100% Length of Wire Slot	2	Surface Cracks only: open or through cracks, visible on both sides, not allowed
	Radiating from Center Hole	Cumulative length less than 10% ($\frac{1}{10}$) of core OD	--	
	Radiating from Edge	25% ($\frac{1}{4}$) of core OD	1	
	Radiating from Wire Way	Cumulative length in each Wire Way less than 50% ($\frac{1}{2}$) of the Wire Way Depth	--	Must not be open
Ragged Edges	Outer or inner Edge	20% ($\frac{1}{5}$) of the relative circumference	1	

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7 Associated Documents:

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

8 Revision History

Revision Number	Reason for Change	Revision Date

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)

International Electrotechnical Commission (IEC) International Standard 60424-2: *Ferrite Cores – Guide on the Limits of Surface Irregularities Part 2: RM-cores* (First Edition 1997-10)

Magnetic Materials Producers Association (MMPA) MMPA Standard PC 110: *Standard Specifications for Ferrite Pot Cores* (Revised January, 1984)

FAIR-RITE PRODUCTS CORP. VISUAL INSPECTION CRITERIA

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Approvals:

Manufacturing: Henry Jacob 2/27/08

Process Engineering: Bob 2/27/08

Applications: Francis 2/27-08

Quality: Rich Ehlmann

Vendor _____

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