

TITLE: SURFACE MOUNT BEADS	EFFECTIVE: July 30, 2013 Rev. 2
DEVELOPED BY: John Lynch	SUPERSEDES: Rev 1
UPDATE RESPONSIBILITY: QUALITY DEPARTMENT	

0.0 Surface Mount Beads - Generic

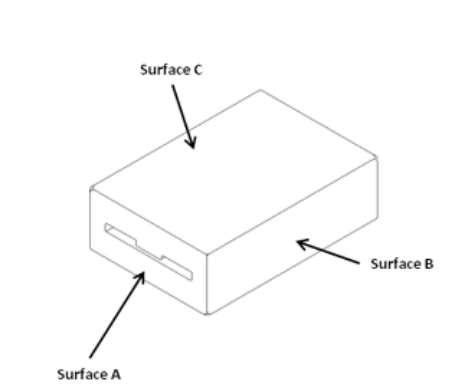


Figure:1

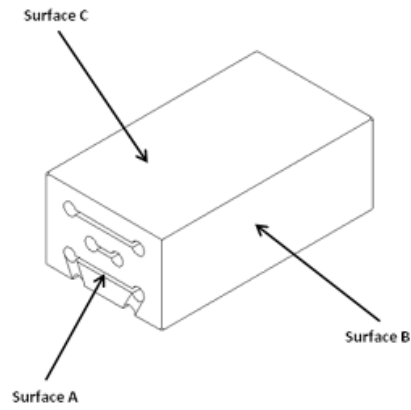


Figure 2

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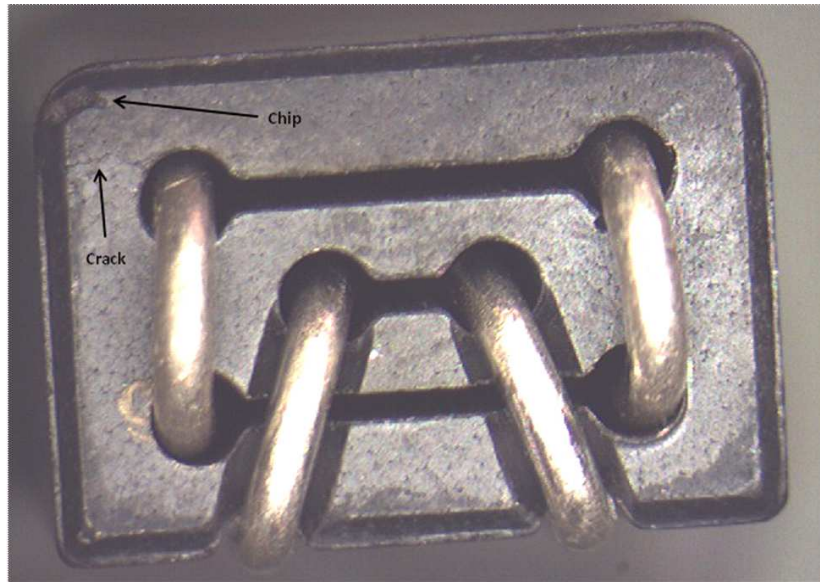


Figure 3

1.0 Surface Mount Beads – Generic

0 1.1 Limits for Irregularities:

Type	Location	Max. Size Allowed	Max Count Allowed
Chips	A	25% (1/4) of the smaller of length and width of surface or 1mm max	3 on each surface, 5 total
	B & C	25% (1/4) of the smaller of length and width	
Bumps	All surfaces	Small to moderate bumps that do not interfere with dimensions are allowed	Unlimited
Pits	All surfaces	1mm max	3 on each surface, 5 total
Cracks(apply only to figure 2 type designs, all others no cracks allowed)	A	2mm, must be unopened(see figure 3). Open cracks, cracks which weaken the part, or worsen after thermal shock(SOP ELC-27)are not allowed. See engineering for clarification if needed.	1
	B & C	2mm adjacent edge to surface A, anywhere else on surface is unacceptable	
Crazing	All surfaces	No limit	N/A
Sticking	All Surfaces	No limit	N/A

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Limits for Irregularities:

Defect Type	Location	Max. Size Allowed	Max Count Allowed
Pullout	All surfaces	0.003in (0.076mm) deep	Cumulative area of Pullout must be less than 30% (1/4) of the relevant surface area.
Ragged Edges	All edges	Width as defined in Defect Definitions	Entire Edge surfaces
Sharp Edges	All edges	N/A	Sharp edges not allowed on burnished cores
Stains and discolorations	All edges	N/A	Stains and discolorations which do not affect the performance of the part are acceptable.

2.0 Associated Documents:

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

Revision History:

Revision Number	Reason for Change	Revision Date
1	Revised Section 4.1	12/5/2001
2	Revised Complete VIC	7/30/13