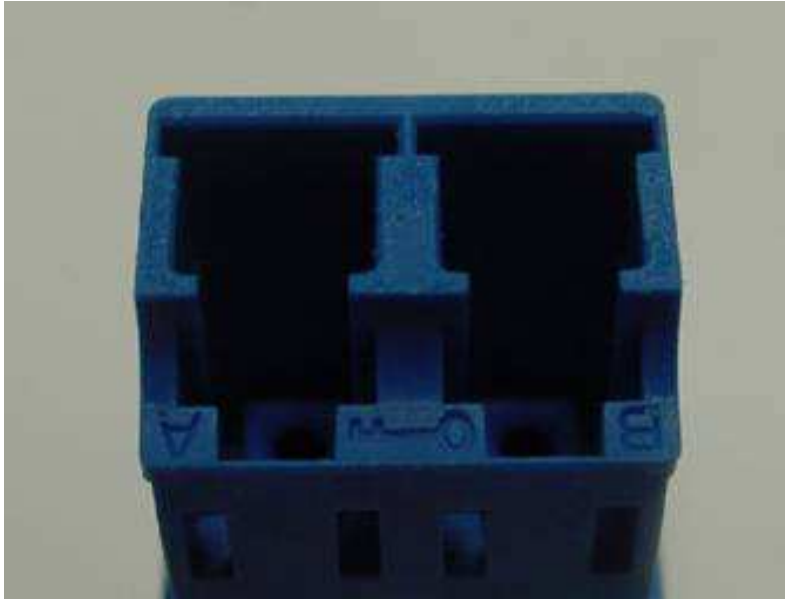

Ultrasonic Welding, LC & SC Adapters

1. SCOPE

This specification covers the acceptable and not acceptable conditions for the Ultrasonic Welding operation of the LC & SC adapters.

2. INSPECTION CRITERIA

Unless otherwise specified, figures are shown under Magnification. The welded adapters will be inspected without magnification.



ACCEPTABLE
Tool Marks LC Secure
Figure 1



ACCEPTABLE
Tool Marks SC
Figure 2



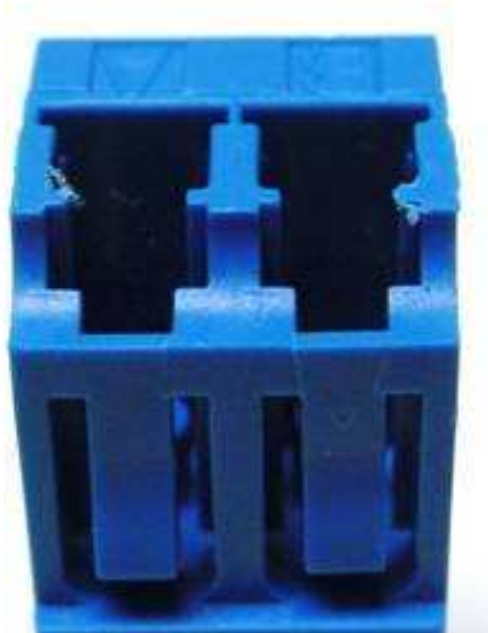
ACCEPTABLE
Tool Marks LC, LC Cutout
Figure 3



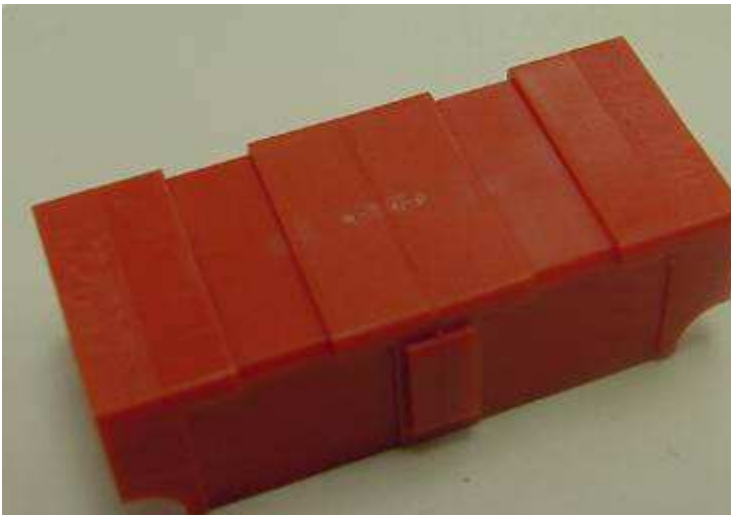
NOT ACCEPTABLE
Heavy Tool Marks and Flash
LC Secure
Figure 4



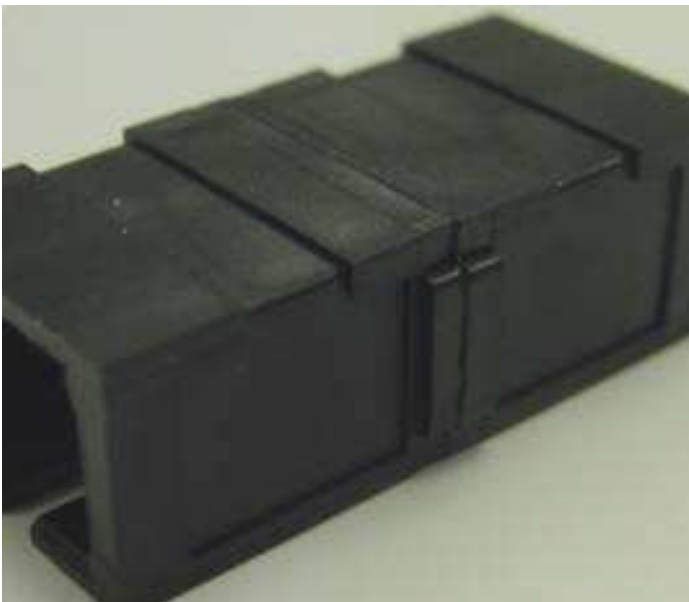
NOT ACCEPTABLE
Heavy Tool Marks and Flash SC
Figure 5



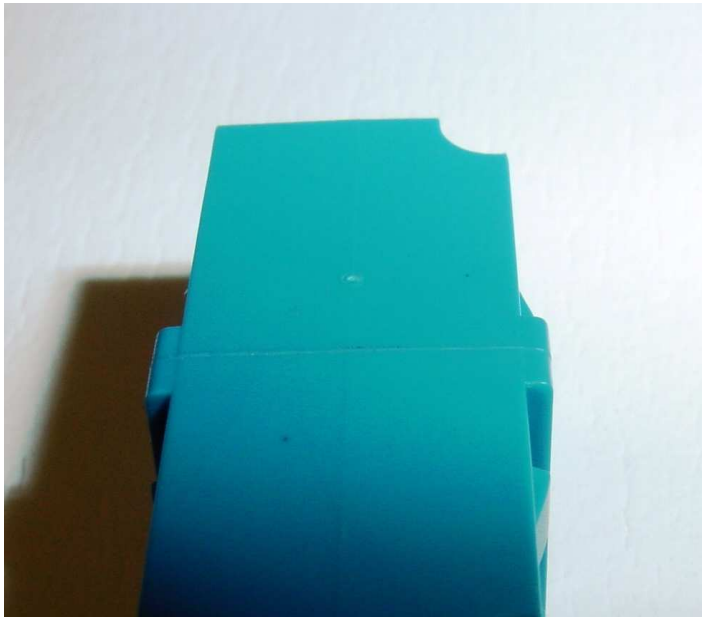
NOT ACCEPTABLE
Heavy Tool Marks and Flash
LC, LC Cutout
Figure 6



ACCEPTABLE
Flash Around the Weld Line
LC Secure
Figure 7



ACCEPTABLE
Flash Around the Weld Line SC
Figure 8



ACCEPTABLE
Flash Around the Weld Line
LC, LC Cutout
Figure 9



NOT ACCEPTABLE
Heavy Flash Around the Weld Line
LC Secure
Figure 10



NOT ACCEPTABLE
Heavy Flash Around the Weld Line SC
Figure 11



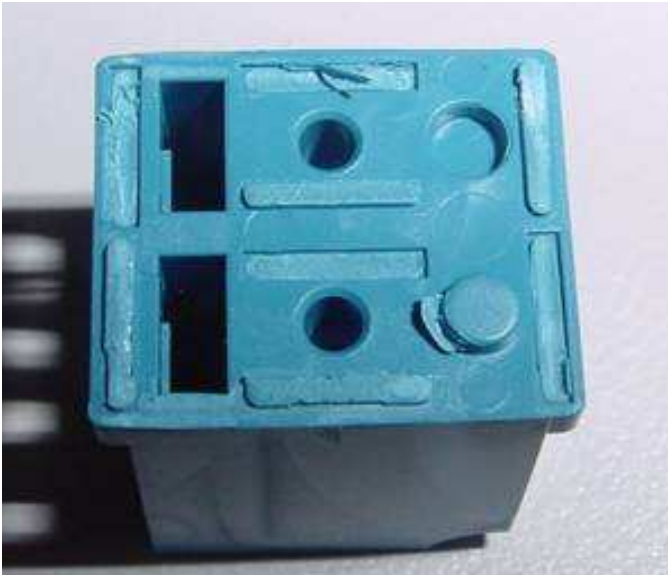
NOT ACCEPTABLE
Heavy Flash Around the Weld Line
LC, LC Cutout
Figure 12



ACCEPTABLE
Weld at Break Test
LC Secure
Figure 13



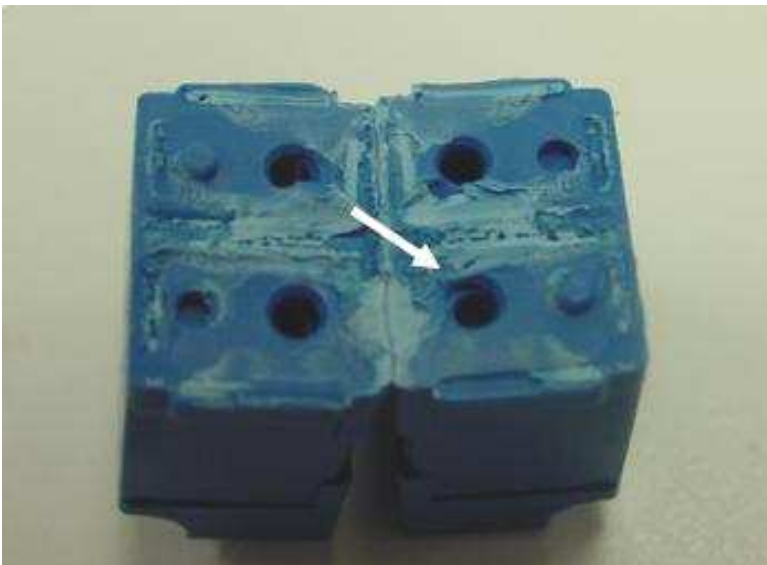
ACCEPTABLE
Weld at Break Test, SC
Figure 14



ACCEPTABLE

Weld at Break Test,
LC, LC Cutout

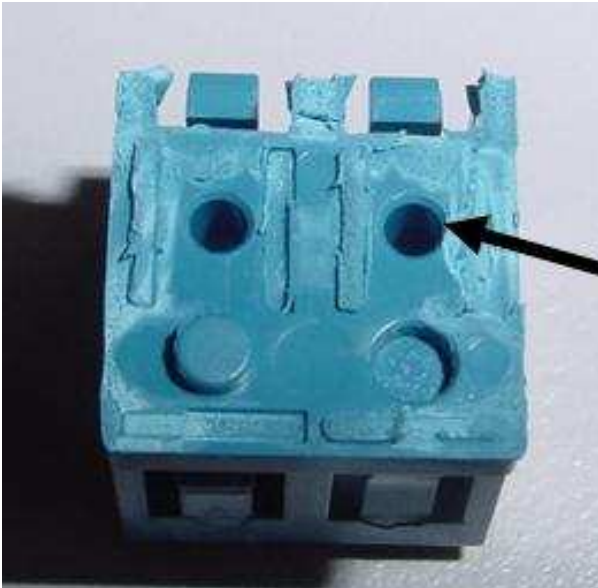
Figure 15



NOT ACCEPTABLE

Weld At Break Test
Flash at Alignment Sleeve Cavity
LC Secure

Figure 16



NOT ACCEPTABLE

Weld At Break Test
Flash at Alignment Sleeve Cavity
LC, LC Cutout

Figure 17



NOT ACCEPTABLE

Gap Between Housings
LC Secure
Figure 18



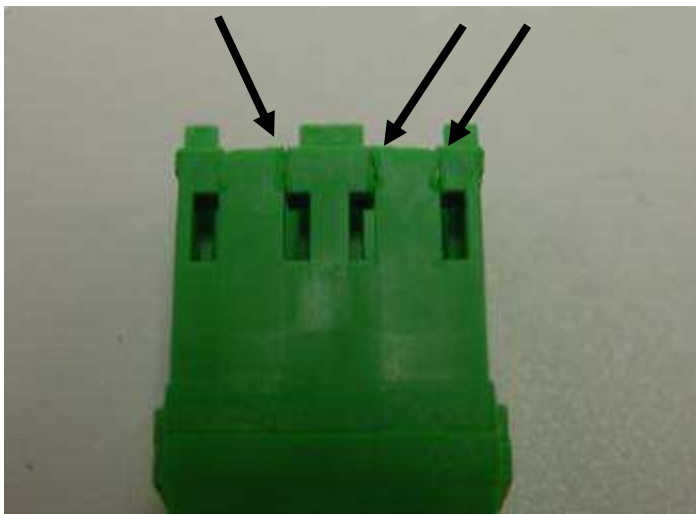
NOT ACCEPTABLE
Gap Between Housings SC
Figure 19



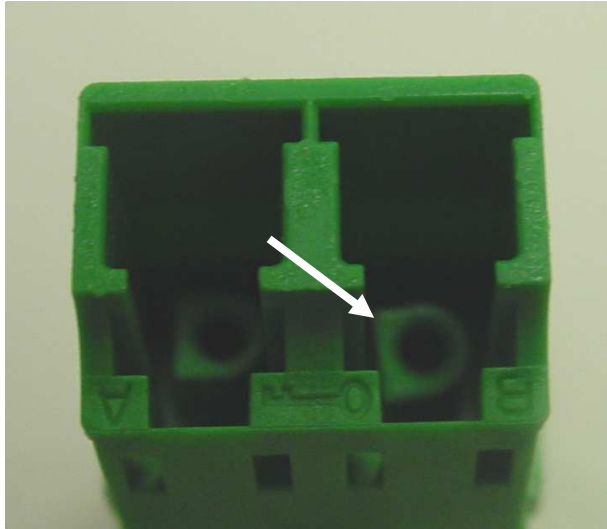
NOT ACCEPTABLE
Gap Between Housings
LC, LC Cutout
Figure 20



NOT ACCEPTABLE
Housings Reversed
Figure 21

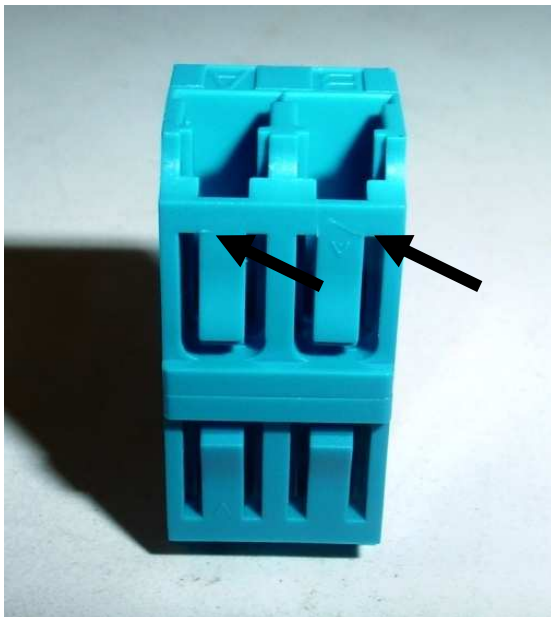


NOT ACCEPTABLE
Weld Fractures LC Secure
Figure 22



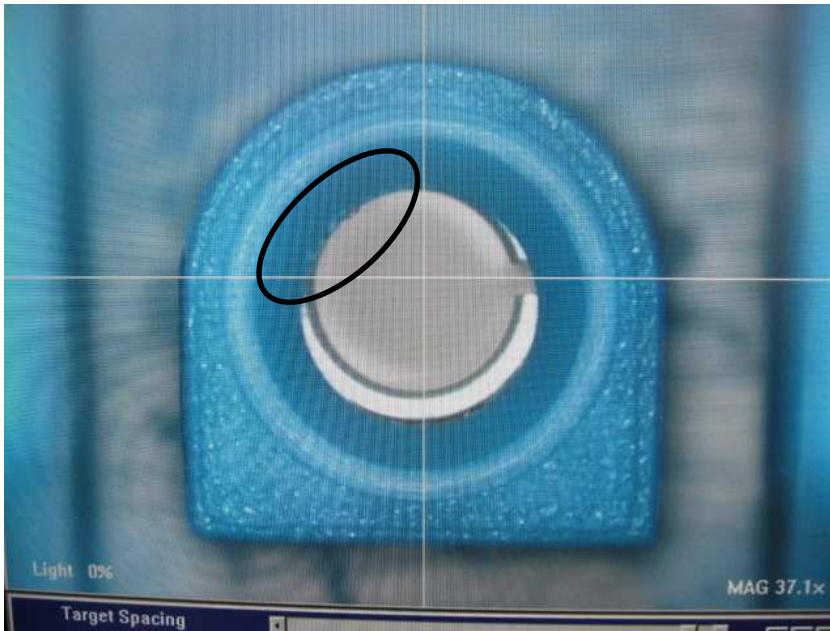
NOT ACCEPTABLE

Broken Stack
Figure 23

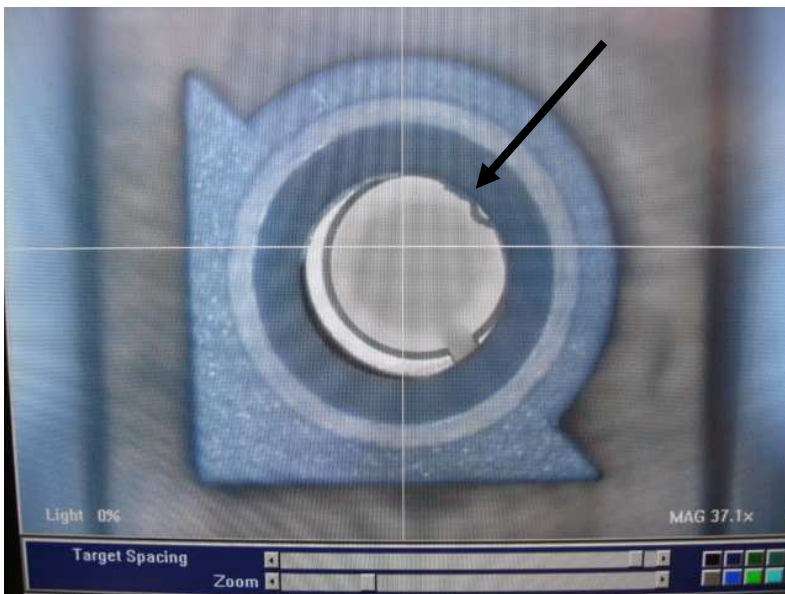


NOT ACCEPTABLE

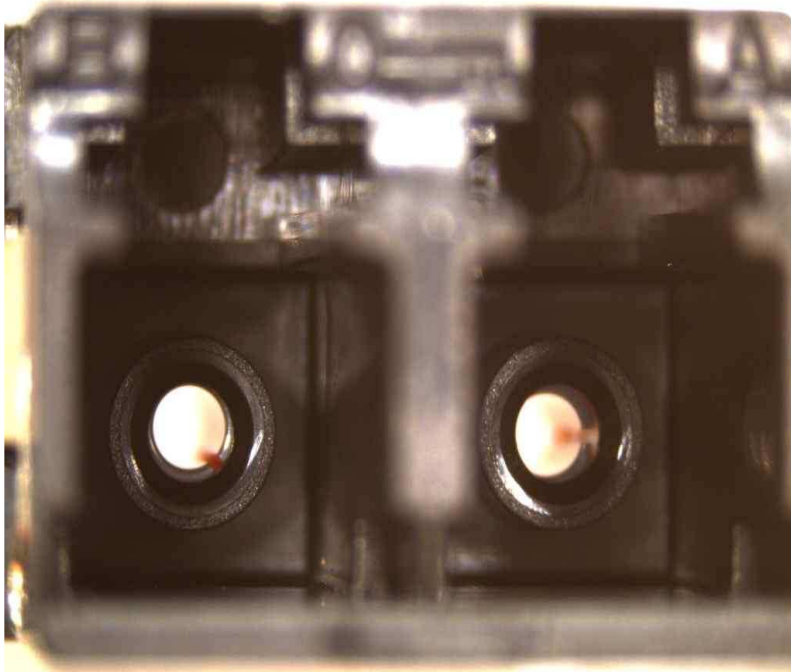
Broken Latch
Figure 24



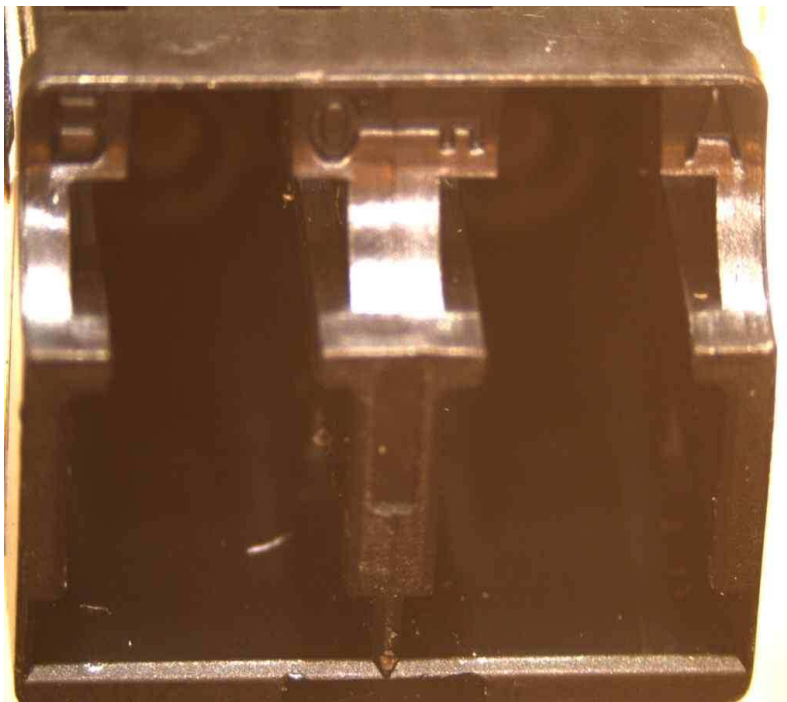
ACCEPTABLE
Flash
Figure 25



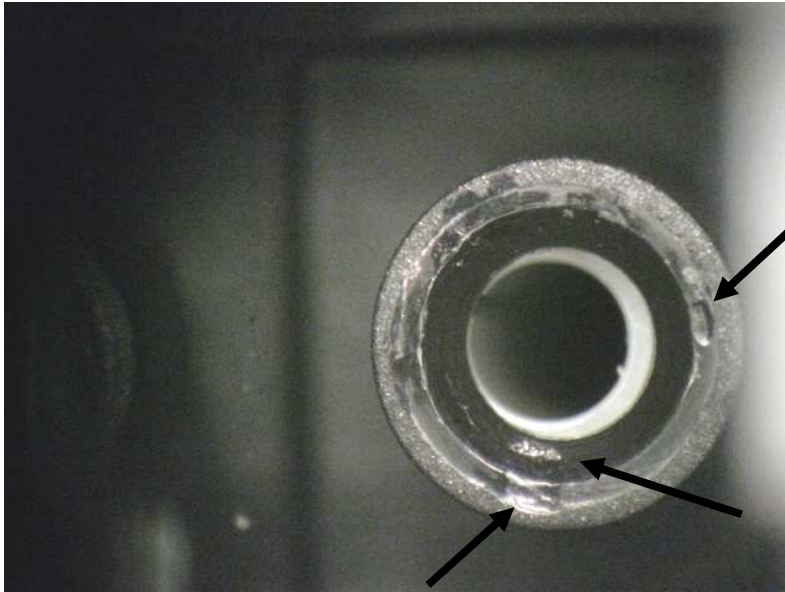
NOT ACCEPTABLE
Flash
Figure 26



ACCEPTABLE
Debris
Figure 27

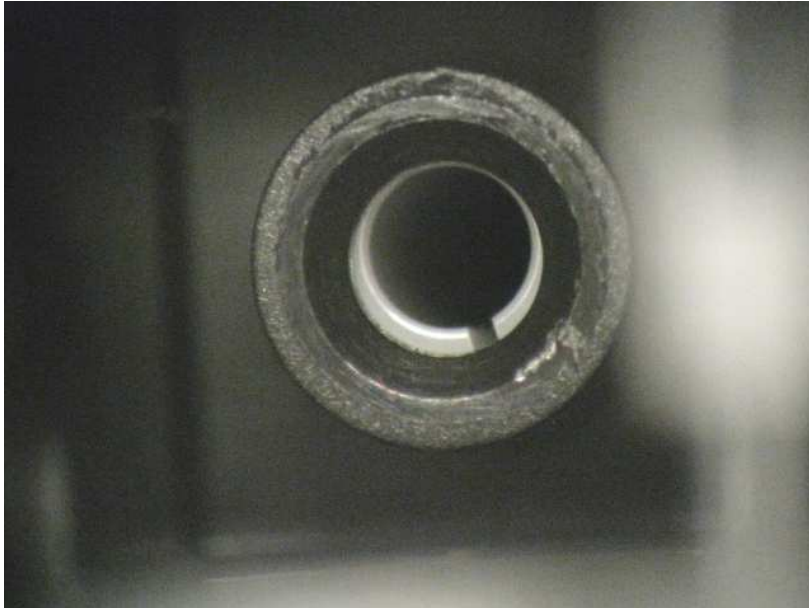


NOT ACCEPTABLE
Debris
Figure 28



NOT ACCEPTABLE

Tool marks on ferrule lead-in of stack, large tool marks on rim of stack
Figure 29



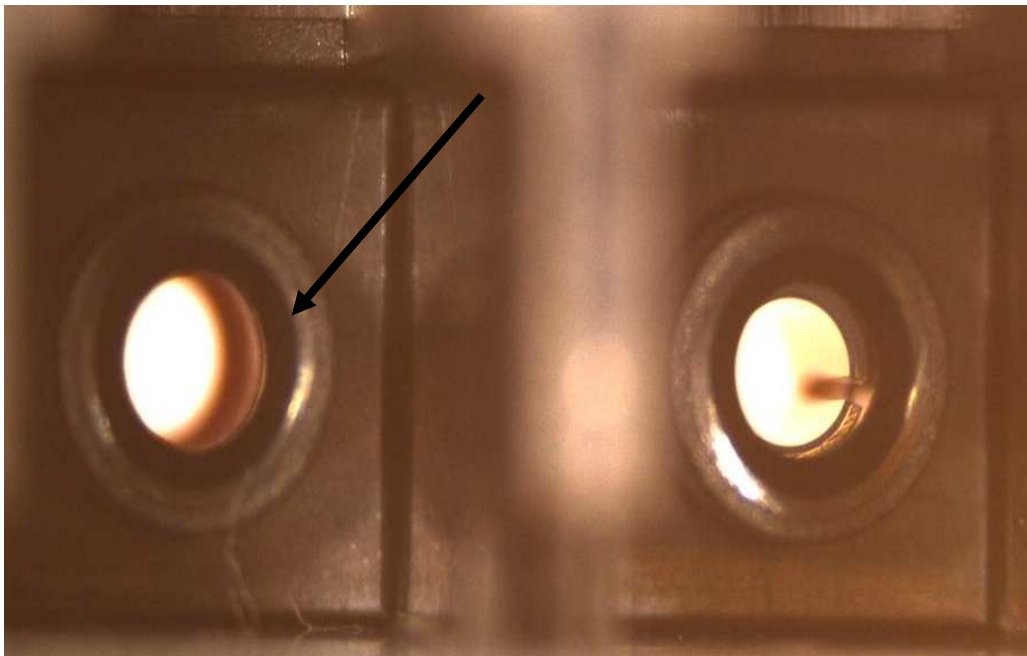
ACCEPTABLE

Tool marks on stack
Figure 30



NOT ACCEPTABLE

Broken Sleeve
Figure 31



NOT ACCEPTABLE

Missing Sleeve
Figure 32