

Acceptance Check for Feed thrus.

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General Procedures: All feed thrus are checked in the construction preparation area. No special handling is needed during this part of the procedure. The check is an overall yes/no on the feed thru with the ability to fix problems encountered during checking. The same procedure applies to both the aluminum and the plastic parts.

Training Procedure: New personnel will be shown the posters describing the procedure and asked to carry out the steps under supervision. All work occurs in the prep room and no written documentation of training is maintained.

Caution: None

Safety Issues: If the glue port needs to be reamed, this is done with a hand-held power tool. Care should be exercised in using this tool. Safety glasses are required for reaming.

Q&A Tests: This procedure is a Q&A test to determine if feed thrus are acceptable. It also allows us to repair some deficiencies in donuts and reject bad donuts.

Data Recorded: If the number of rejected components exceeds 25/4000, data are recorded.

Checking Aluminum Feed-Thrus

Check the outer diameter of the feed-thru. It should be between 0.4355 and 0.4375 inches.

If it is out of range, reject the part.



0.4355 to 0.4375 inches

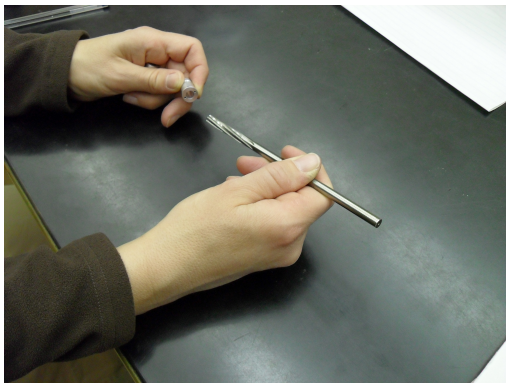
Checking Aluminum Feed-Thrus

Check the inside hole with the go-no-go gauge. If the green end goes in, it is ok.

If the green end does not go in, then ream
Out the hole with the hand reamer.

If the fit with the green felt loose, check
The size of the hole with the red no-go
Gauge. It should not fit.

If the no-go fits, reject the part



Checking Aluminum Feed-Thrus

Check the size of the glue ports.



The needle should slide in and out easily. If it does, the ports are ok.

If it does not fit, the ports need to be reamed out. If the reamer does not fit, the ports need to be drilled out.



Parts are bagged in lots of 100 and then sent into the clean room for ultrasound cleaning.

The following activities take place in the clean room and are carried out under standard clean room procedure.

100 feed thrus at a time can be cleaned in the ultrasound unit. Once the unit is up to temperature, the feed thrus are put in and cleaned for 30 minutes.

Feed thrus are removed, rinsed in tap water, then in distilled water.

Feed thrus are air dried using filtered air.

Feed thrus are packed in clean clear bags with a desiccant packet and then stored in the clean room until ready to use.