

- APPEARANCE - DYE TEST** : The components to be free from defects of the form identified in Appendix B.
 Determined by dye test/UV inspection in accord with the relevant Operating Instructions.
- D. PROCESSING** : Processing to be carried out in accord with relevant Operating Instructions.
- E. SUPPLIER** : Not applicable ; manufactured in-house.
- F. PACKAGING**
- FOR USE OFF SITE** : Components to be sealed hermetically and in accord with customer requirements
- G. LABELLING**
- FOR USE OFF SITE** : Each container to be labelled to identify component, drawing number, quantity and batch number. Other customer labelling requirements must also be included.
- H. TRACEABILITY**
- FOR USE OFF SITE** : Different batches to be packaged in separate containers or otherwise segregated so that they are clearly identifiable by batch number and quantity.
- I. CERTIFICATION** : In accord with customer requirements.

THE INFORMATION CONTAINED WITHIN THIS PRINT IS THE PROPERTY OF IONOTEC LIMITED AND IS TO BE TREATED CONFIDENTIALLY

WRITTEN		ISSUE & DATE	1	3/12/98						
APPROVED		ECN No.								

APPENDIX A

VISIBLE LIGHT INSPECTION

Determined by white light and in ambient light - all visual inspection to be conducted with the naked eye or, if necessary, wearing spectacles prescribed by an optician for close work.

A1. DETERMINED USING AMBIENT LIGHT

Determined using ambient light, is defined as inspection under room lighting.

REJECT CLASSIFICATIONS

Discolouration*	Large areas of <u>surface</u> discolouration with clearly visible colour or contrast.
White Marks*	White marks on the external base of the electrolyte.
Inclusions*	Large inclusions in the <u>body</u> of the electrolyte which give an area of clearly visible colour.

Electrolyte with an overall bluish hue is acceptable provided that the chemical analysis of the batch, as determined by XRF, conforms to the specification included in M249.

A2. DETERMINED USING WHITE LIGHT

Determined using white light, is defined as inspection in a darkened booth using a 275W radiographic white light box.

REJECT CLASSIFICATIONS

Holes*	Holes visible from both sides of the electrolyte.
Cracks*	Any cracked shape.
Chips*	(a) Large chips in the open end of the electrolyte, extending >1mm down from the open end. (b) Chips which extend <1mm down from the open end which retain dye during dye testing (Appendix B) i.e. there is cracking associated with the chipped edge.
Shadows*	Dark shadows in the base of the electrolyte.
Flaking*	Large areas of flaking on internal and external surfaces.

THE INFORMATION CONTAINED WITHIN THIS PRINT IS THE PROPERTY OF IONOTEC LIMITED AND IS TO BE TREATED CONFIDENTIALLY

WRITTEN		ISSUE & DATE	1	3/12/98					
APPROVED		ECN No.							

APPENDIX B
DYE TEST/UV INSPECTION

DEFECTS RESULTING IN REJECTION⁽¹⁾

Any pinholes on the surface of the shape retaining yellow colour in contrast to the background.

Any cracks retaining yellow colour in contrast to the background

Any yellowish background sufficient to mask surface defects.

⁽¹⁾ Shapes to be examined against a non-fluorescent background.

THE INFORMATION CONTAINED WITHIN THIS PRINT IS THE PROPERTY OF IONOTEC LIMITED AND IS TO BE TREATED CONFIDENTIALLY

WRITTEN		ISSUE & DATE	1	3/12/98						
APPROVED		ECN No.								