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	Document Identifier:	General Workmanship Requirements	-
	Date:	Latest Revision Date	-
	Project:	Customer, Unique ID, Part Number	
	Document Status:	Draft, Redline, Released, Obsolete	2
~ 0 ^e	Document Link:	Location on Server (if used)	_
Abstract: This document describes generation	al manufacturir	ng and interpretation requirements.	-

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1. SCOPE

This document describes general requirements and methods of interpreting engineering requirements specified in specifications and/or drawings. 2. THEORY

The space available on product drawings sometimes limits the opportunity for a clear description of engineering requirements. Details that the engineer would like to include on the drawing are sometimes left off with the assumption that the User will understand what is meant



REQUIREMENTS 4.

Order of Precedence 4.1

In the event of conflicting requirements the following order of precedence governs: The Customer's requirements always



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4.2 Significant Digits Calculations may be performed applicable drawing; however,	l with a greater number of signi by the applicable	ficant digits than shown on the must be drawing. For instance	

4.3 Determining Conformance; Absolute Method Rounding Method (ASTM E 29)

Unless otherwise specified by the CCB, the 'rounding method' is used for determining compliance of test data to product specifications according to

Rounding is performed as follows:	
•	
	0.
•	
•	
•	

Example — 0.0<u>21</u>"±0.001"

0.0211" to 0.0214" *must* be rounded down to 0.021" for **2** significant digit specifications; 0.0215" to 0.0219" *must* be rounded for **2** significant digit specifications; (unless the last retained digit from the rounding method is even, e.g., 0.0225" is rounded while 0.02<u>2</u>6" is rounded ")

Example - 0.0215"±0.0015" 0.0211" to 0.0219" must be applied as observed - no rounding is possible if If the equipment is capable of reading paying particular

attention to whether the retained digit is

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Example — 550±50

499.1 to 499.4 *must* be rounded 499.5 to 499.9 *must* be rounded 600.1 to 600.5 *must* be rounded 600.6 to 600.9 *must* be rounded

ridwide 4.3.1 Decision Rule for Considering Measurement Uncertainty in Determining **Conformance to Specifications**

ASME B 89.7.3.1 specifically addresses the issue of applying measurement uncertainty in industrial settings. A decision rule is

For workpieces, the permissible variation is commonly called the tolerance; for instruments it is often given by the specification limits or a maximum permissible error (MPE). The permitted variation of a product's characteristic is known as the "specification zone".

Figure 1 defines the Company's decision rule with stringent acceptance, simple rejection, and a transition zone where the product is likely to be

The outcome of a measurement

result in the transition zone is dependent upon the rule stated below for Figure 1. For example, stringent acceptance implies both a decrease in the acceptance zone width and an increase in confidence that a measurement result in this zone is associated with an in-specification product. Similarly, stringent rejection results in a

	Lower	R		Upper Upper	
	Specification		Specification Zone	<i>g_{In}</i> Specific Limit	cation
Eigung 1	Rejection Zone	Transition Zone	Stringent Acceptance Zone	Transition Simple Zone Rejection	► n Zone
accepted if	-Stringent acceptance,	simple rejection	on and a transition zone us	ing symmetric two-sided g	uard-banding. Products are
Decision	Rule for Measur	ements w	ithin the 10:1 Tran	sition Zone in Figu	ire 1:
The calib	oration tolerance	for a meas	surement device car	n be used to	
				the instr	ument's calibration
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book for every mix.

4.5.1.1 **Application of Drawing Specification** Unless otherwise specified, potting and encapsulation materials whose shelf-life has expired must not

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The expiration date is somet expiration date after the conta properly stored and then a 3 m potting or encapsulation mate	times modified by an annotati niner is opened, e.g., 6 month s nonth shelf-life after opening th erial,	on that applies an additional shelf-life while un-opened and e container. Prior to using any
4.6 Dimensional Require	ments and Allowances	
4.6.1 Surface Flaws		S
Surface flaws include		
	Acceptance of parts having	surface flaws shall
4.6.2 Free State Variation	1	
II material flexibility or norma	i stresses can be expected to cal	ise parts to be out of tolerance,
appropriate inspection procedur	es	
463 Blind Holes		
The drill point shall not	•	
I I		
4.6.4 Gaging Hole Diameters		
The diameter of a hole is with	n required limits when	
		the hole is out-
of-round	Bell-mouthed holes a	re acceptable if
4.6.5 Hole Quality	n out and shall present a	
Hole edges shall be free from	in cut and shall present a	
These requirements are subject	to	
4.6.6 Removing Burrs and Sha	rp Edges	
All burrs and sharp edges shall	be removed to the extent that ma	aterial fragments are not visible
and sharpness cannot		If it is necessary to break sharp
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drawing is that they shall be shall be	I	Discontinuities on the flat surface
4.6.10 Thread Form All threads shall be free from		AN'
applicable drawing. Where no	Thread form shall comply with thread form is specified, the	the requirements specified by the reads shall comply with
A slight groove may appear all Besly tool and is acceptable if	as Besly "X-Press" may be use ong the thread crest as a result	t of the metal flowing action of a
4.6.11 Thread Gaging	indiantan may be used	nt thread dimensions
When "GO" gages are used, the	e product shall allow the "GO" however, the thread	gage to enter or to be entered
When "NOT GO" plug or ring For threads having thr	gages are used, the product is ee or fewer turns, the drag sha	or before ll occur on or before
4.6.12 Surface Roughness	jalt	
When the surface roughness performed roughness specified is 32 micro	specified is less than 32 mic using inches or greater.	when the surface
4.7 Requirements for Cle Parts and Assemblies	eaning, Protection and Id	entification of Raw Material,
All parts and assemblies shall	be adequately protected from	

These requirements shall apply to all manufacturing operations from receipt of raw material to completion of a finished product and

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to product held in any storage area and product prepared for shipment. Protective measures used during processing, fabricating and packaging must not only guard against obvious damage and deterioration but also against



4.7.2 Cleanup of Parts and Assemblies

All finished parts and subassemblies shall be adequately cleaned before final assembly. Final assembly and necessary subassembly shall be performed in an environment appropriate to the type of product. All parts and assemblies shall be





General Requirements

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Accuracy:	194
CCB	Configuration Control Board
Goal Posts	
GR&R	Gage Reproducibility and Repeatability
IAW:	In accordance with
Independent	
Test Results:	
MRB:	Material Review Board
Precision	
REA:	Responsible Engineering Authority
Repeatability	
Conditions:	
D (111)	
Repeatability:	
Conditioner	
Conditions:	
Reproducibility:	Donulation standard doviation is known
<u> </u>	Population standard deviation is estimated
5.	i opulation standard deviation is estimated
Trueness:	
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