





E L C O M A

QUALITY LABORA

KHR-89/SB-786

Fous,

Hierby retour.

7.3.86 Jo).

12<sup>h</sup>.

INTEROFFICE

From : A.G. Sieben

Quali

To : See copylist

Enclosed please find the following:

<u>documents</u>	<u>12NC: 8222 037 +</u>	<u>name</u>
Drawing + Q.D.S.	1996	centring plate g2
(incl. Insp.	1981	centring plate g5
certificate)	1991	centring plate g1
	1997	centring plate g4
	1998	centring plate g2-2
	1999	centring plate g2-1

The documents are dated 85.02.15.

Alle documents have been brought in line with the agreements, reached during the visit of Messrs. Dürr/Schuster of Saxonia-Franke GmbH.

Moreover, a definition of "a lot" has been added to the inspection certificates.

The Purchasing Dept. is now requested to obtain the formal appointment for the quality assurance system for these products (centring plates).

Proposals for a similar system for the deflection plates deliveries can be expected within some weeks.

Regards,

A.G. Sieben

Copy to Messrs.: Koppelmans  
Vinders (3x)  
Geurts  
Kicken  
Zeppenfeld

E L C O M A

QUALITY LABORATORY PHILIPS HEERLEN

KHR-89/SB-786

1

1985.02.20

ONTVANGEN

Ontv. 20 FEB. 1985

A. G. SIEBEN

*Werkmap,  
2 Haafjes*

INTEROFFICE MEMO

From : A.G. Sieben

Quality Lab. Instrument C.R.T.'s

To : See copylist

Enclosed please find the following:

<u>documents</u>	<u>12NC: 8222 037 +</u>	<u>name</u>
Drawing + Q.D.S.	1996	centring plate g2
(incl. Insp.	1981	centring plate g5
certificate)	1991	centring plate g1
	1997	centring plate g4
	1998	centring plate g2-2
	1999	centring plate g2-1

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Copy to Messrs.: Koppelmans  
Vinders (3x)  
Geurts  
Kicken  
Zeppenfeld

## 1. VISUAL

- A. Inspection points.
- |              | <u>A.Q.L.</u> | <u>LEVEL</u> |
|--------------|---------------|--------------|
| 1. Degreased | 1,0 %         | S 4          |
| 2. Burr      | 1 0 %         | S 4          |
| 3. Flatness  | 1,0 %         | S 4          |
- B. Equipment.
- For A1: Unaided eye.
  - For A2: Unaided eye.
  - For A3: Knife-edge rule.
- C. Methods and Standards
- For A1: Parts may not feel greasy.
  - For A2 Burr not permitted Special attention should be paid to the centre hole.

## 2. DIMENSIONAL

- A. Inspection points.
- |                              | <u>A.Q.L.</u> | <u>LEVEL</u> |
|------------------------------|---------------|--------------|
| 1. Flatness                  | -             |              |
| 2. Pitch centring holes      | 1,0 %         | S 4          |
| 3. Squareness lug            | 6,5 %         | S 4          |
| 4. Concentricity centre hole | -             |              |
- B. Equipment
- For A1: Any; accuracy  $\pm$  5 micron  
 For A2: Special measuring apparatus  
 For A3: Jena  
 For A4: To be defined
- C. Method and standards
- See sheet 3 + 4

← EIS!

## GENERAL

The packing shall be such that after normal transport the quality of the components still meets the requirements.  
 Each lot shall be accompanied by an inspection certificate (sheet 3 + 4).

		Q.D.S CENTRING PLATE G2		8222 037 19960			
NAME	OFFERMANS	SUPERS.	4	110	002	010	A4
KH	CHECK	DAT.	85-02-15	Property of N.V. PHILIPS GLOEILAMPENFABRIEKEN EINDHOVEN - THE NETHERLANDS			







## 1. VISUAL

- A. Inspection points.
- |              | <u>A.Q.L.</u> | <u>LEVEL</u> |
|--------------|---------------|--------------|
| 1. Degreased | 1,0 %         | S 4          |
| 2 Burr       | 1,0 %         | S 4          |
| 3. Flatness  | 1,0 %         | S 4          |
- B. Equipment.
- For A1: Unaided eye.
  - For A2: Unaided eye.
  - For A3: Knife - edge rule.
- C. Methods and Standards
- For A1: Parts may not feel greasy.
  - For A2: Burr not permitted Special attention should be paid to the centre hole.

## 2. DIMENSIONAL

- A. Inspection points.
- |                         | <u>A.Q.L.</u> | <u>LEVEL</u> |
|-------------------------|---------------|--------------|
| 1. Flatness             | -             |              |
| 2. Pitch centring holes | 1,0 %         | S 4          |
- B. Equipment
- For A1: Any; accuracy  $\pm 5$  micron  
For A2: Special measuring apparatus
- C. Method and standards
- See sheet 3

## GENERAL

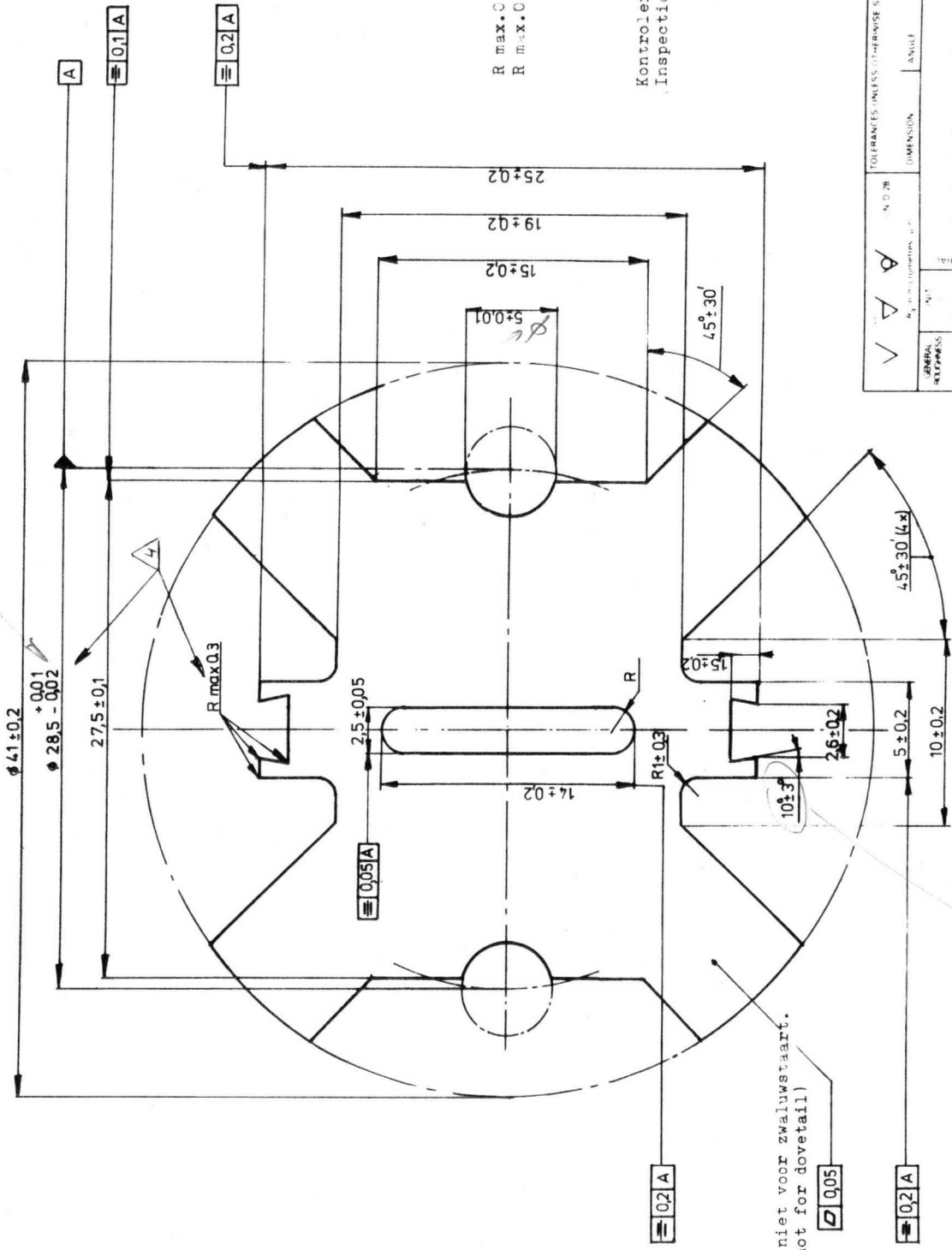
The packing shall be such that after normal transport the quality of the components still meets the requirements.  
Each lot shall be accompanied by an inspection certificate (sheet 3).

		Q.D.S CENTRING PLATE G5		8222 037 19810		
NAME	OFFERMANS	SUPERS.	3	110	002	010
KH	CHECK	DAT.	85-02-14	Property of N.V. PHILIPS GLOEILAMPENFABRIEKEN EINDHOVEN - THE NETHERLANDS		
						A4



Tot niet eenduidig z.v.g.

Tot niet eenduidig z.v.g. ±1



R max. 0,5 tenzij anders aangegeven.  
R max. 0,5 unless stated otherwise.

Kontrolleren volgens QDS, blad 110-00.  
Inspection according to QDS sheet 110-00.

geldt niet voor zwaaiwstaart.  
(not for dovetail)

GENERAL REFERENCE	UN	UN D 90	TOLERANCES UNLESS OTHERWISE STATED	UN D 90	QUANT
MATERIAL	Cr Ni St band 18/12	U2M-286	DIMENSION	ANGLE	
FINISH	0,75±0,02				
CLASS NO	Ontbreand (Degreased)				
	Intvet (Degreased)				
	8222 037 1981				
	82-11-02				
	82-11-09				
	83-09-05				
	83-10-24				

## 1. VISUAL

- A. Inspection points.
- |              | <u>A.Q.L.</u> | <u>LEVEL</u> |
|--------------|---------------|--------------|
| 1. Degreased | 1,0 %         | S 4          |
| 2. Burr      | 1,0 %         | S 4          |
| 3. Flatness  | 1,0 %         | S 4          |
- B. Equipment.
- For A1: Unaided eye.
  - For A2: Unaided eye.
  - For A3: Knife - edge rule.
- C. Methods and Standards
- For A1: Parts may not feel greasy.
  - For A2: Burr not permitted. Special attention should be paid to the centre hole.

## 2. DIMENSIONAL

- A. Inspection points.
- |                              | <u>A.Q.L.</u> | <u>LEVEL</u> |
|------------------------------|---------------|--------------|
| 1. Flatness                  | -             |              |
| 2. Pitch centring holes      | 1,0 %         | S 4          |
| 3. Concentricity centre-hole | ----          |              |
- B. Equipment
- For A1: Any; accuracy  $\pm$  5 micron  
 For A2: Special measuring apparatus  
 For A3: Jena
- C. Method and standards
- See sheet 3

## GENERAL

The packing shall be such that after normal transport the quality of the components still meets the requirements.  
 Each lot shall be accompanied by an inspection certificate (sheet 3).

		Q.D.S. CENTRING PLATE G1		8222 037 19910			
NAME	OFFERMANS	SUPERS.	3	110	002	010	A4
KH	CHECK	DAT.	85-02-14	Property of N.V. PHILIPS GLOEILAMPENFABRIEKEN EINDHOVEN - THE NETHERLANDS			





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M.I.S.D.  
 Electronic components and  
 materials Division

PHILIPS

INSPECTION CERTIFICATE

LOT: \_\_\_\_\_  
 LOTSIZE: \_\_\_\_\_

Inspection : ATTR.: A.Q.L. = 1 % / S4 Visual  
 VAR. : n = 5 at start } of the batch  
 n = 5 at end }

Parameter : FLATNESS [ / ] 0,05

Sample size n:	S		E		HRL		S		E		HRL		S		E		HRL		S		E		HRL	
No. of defects																								
START/END																								
> 80																								
[ /um]																								
60																								
40																								
20																								
0																								
Yr. Mo. Day																								

Inspection : ATTR.: A.Q.L. = 1 % / S4  
 VAR. : n = 5 at start } of the batch  
 n = 5 at end }

Parameter : PITCH CENTRING HOLES

Sample size n:	S		E		HRL		S		E		HRL		S		E		HRL		S		E		HRL	
No. of defects																								
START/END																								
[ /um]																								
+ 20																								
0																								
- 20																								
Yr. Mo. Day																								

Inspection : ATTR.: ----  
 VAR. : n = 2 at start } of the batch  
 n = 2 at end }

Parameter : CONCENTRICITY Centre hole  $\phi$  0,02

Sample size n:	S		E		HRL		S		E		HRL		S		E		HRL		S		E		HRL	
No. of defects																								
START/END																								
>40																								
[ /um]																								
30																								
20																								
10																								
0																								
Yr. Mo. Day																								

d = defects	n	d	n	d	n	d	n	d	n	d	n	d	n	d	n	d	n	d
n = sample																		
Degreased																		
Burr																		
Lot release																		
Sign.:																		
Yr. Mo. Day																		
Remark																		

One lot comes from a homogeneous production series.  
 Lot-definition changes when e.g., significant tools are interchanged or overhauled.

89222	(ONTWERP)	85-02-15
Q.D.S.	CENTRING PLATE ( G1 )	8222 037 19910
Inspection certificate		
Gebr. o. a. in:		
NAME offermans	SUPERS	3
KH	CHECK	DAT 85-02-15
Property of N. V. PHILIPS' GLOEILAMPENFABRIEKEN EINDHOVEN THE NETHERLANDS		



## 1. VISUAL

- | A. | <u>Inspection points.</u> | <u>A.Q.L.</u> | <u>LEVEL</u> |
|----|---------------------------|---------------|--------------|
|    | 1. Degreased              | 1,0 %         | S 4          |
|    | 2. Burr                   | 1,0 %         | S 4          |
|    | 3. Flatness               | 1,0 %         | S 4          |
- B. Equipment.
1. For A1: Unaided eye.
  2. For A2: Unaided eye.
  3. For A3: Knife - edge rule.
- C. Methods and Standards
1. For A1: Parts may not feel greasy.
  2. For A2: Burr not permitted Special attention should be paid to the centre-hole.

## 2. DIMENSIONAL

- | A. | <u>Inspection points.</u>    | <u>A.Q.L.</u> | <u>LEVEL</u> |
|----|------------------------------|---------------|--------------|
|    | 1. Flatness                  | -             |              |
|    | 2. Pitch centring holes      | 1,0 %         | S 4          |
|    | 3. Concentricity centre-hole | -             |              |
- B. Equipment
- For A1: Any; accuracy  $\pm$  5 micron  
 For A2: Special measuring apparatus  
 For A3: Jena ?
- C. Method and standards
- See sheet 3

## GENERAL

The packing shall be such that after normal transport the quality of the components still meets the requirements.  
 Each lot shall be accompanied by an inspection certificate (sheet 3)

	Q.D.S. CENTRING PLATE G4	8222 037 19970	
NAME	OFFERMANS	SUPERS.	3
KH	CHECK	DAT.	85-02-15
		Property of	N.V. PHILIPS GLOEILAMPENFABRIEKEN EINDHOVEN - THE NETHERLANDS
		110 — 002	010
		A4	

