**Process Spec:** 1.3.3.1.1.2-3 - Tube De-Burring Inspection

**Components:** Copper Tube [4.2.7.1.2.1]

**Material:** Nitril Gloves

**Tooling:** Magnifying Loupe

**Location:** UofA PAS 346 - Laboratory

**QC Form:** FCal1-QC-1.3.3.1.2-3 - De-Burring Inspection

**Process:**

1. Gloves should be worn whenever tubes are handled.
2. Check both de-burred tube ends for width of the cut (optical inspection using the loupe). The width of the cut should not exceed $\frac{1}{2}$ of the tube wall thickness:

   ![Diagram](image)

3. Check both de-burred tube ends for planarity of cut surface (chatter). Use the loupe to find uneven spots.
4. Check both tube ends for completeness and center of cut

   ![Diagram](image)

5. Check both tube ends for burr/copper flakes.
**Process Spec:**  1.3.3.1.1.2-3 – Tube De-Burring Inspection (cont'd)

**Process (continued):**

6. Record all observations on Tube De-Burring Inspection Report. Tubes not passing must be placed into Reject bin if not correctable, or returned to 1.3.3.1.1.2-2 (Tube De-Burring) for redo.

**Remarks:**

**Global Process:**  1.3.3.1.1.2 – Tube Processing

**Previous:**  1.3.3.1.1.2-2 – Tube De-Burring

**Follow-Up:**  1.3.3.1.1.2-4 – Tube Cleaning [all accepted tubes]