

FCAL1 Process Sheet

T.Embry/P.Loch/L.Shaver

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

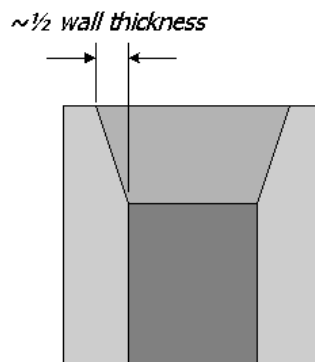
Tooling: Magnifying Loupe

Location: UofA PAS 346 – Laboratory

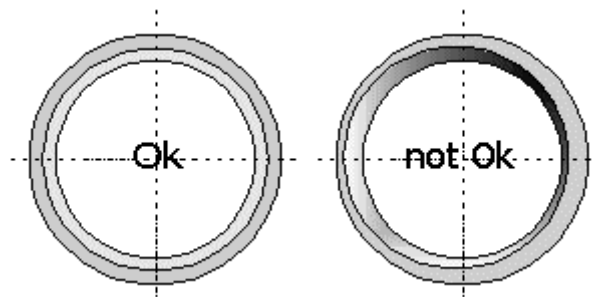
QC Form: FCal1-QC-1.3.3.1.2-3 – De-Burring Inspection

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:



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



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]