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**Ultrasonic Welding, LC & SC Adapters**

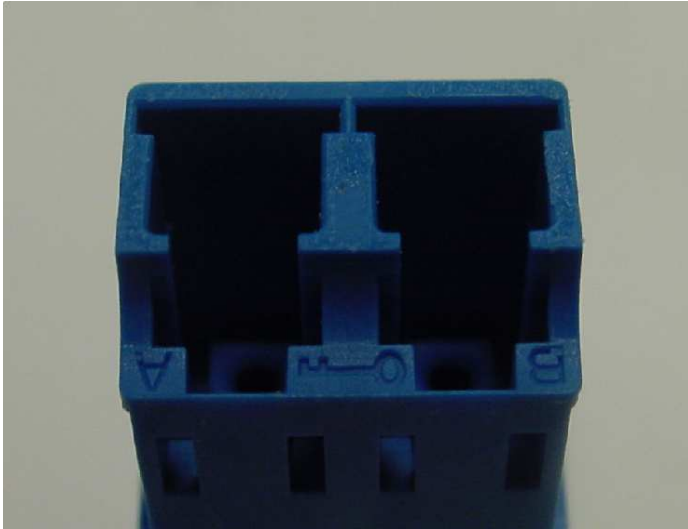
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**1. SCOPE**

This specification covers the acceptable and not acceptable conditions for the Ultrasonic Welding operation of the LC & SC adapters.

**2. INSPECTION CRITERIA**

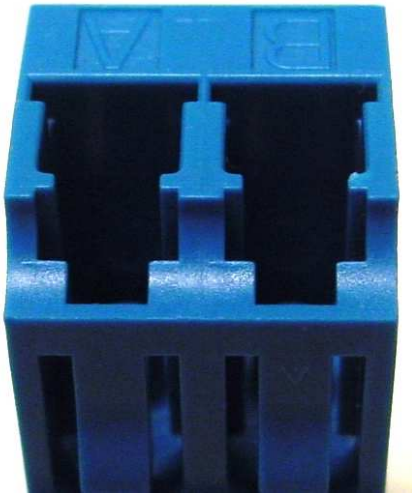
Unless otherwise specified, figures are shown under Magnification. The welded adapters will be inspected without magnification.



**ACCEPTABLE**  
Tool Marks LC Secure  
Figure 1



**Acceptable**  
Tool Marks SC  
Figure 2



**Acceptable**  
Tool Marks LC, LC Cutout  
Figure 3



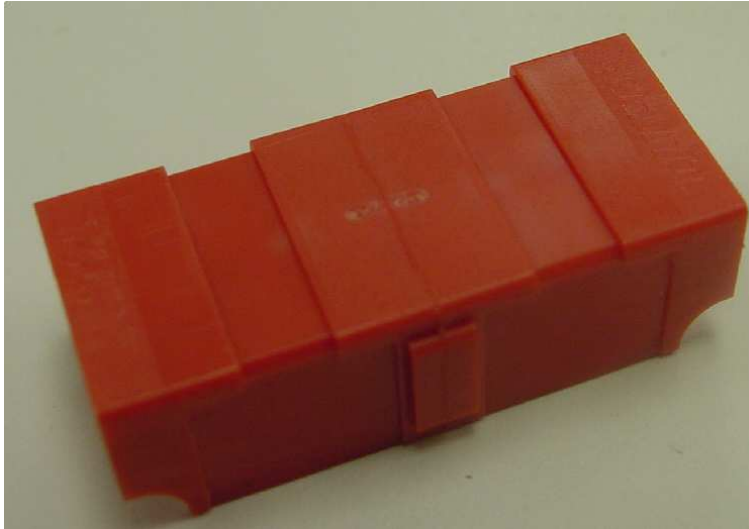
**Not ACCEPTABLE**  
Heavy Tool Marks and Flash  
LC Secure  
Figure 4



**NOT ACCEPTABLE**  
Heavy Tool Marks and Flash SC  
Figure 5



**NOT ACCEPTABLE**  
Heavy Tool Marks and Flash  
LC, LC Cutout  
Figure 6



**ACCEPTABLE**

Flash Around the Weld Line  
LC Secure  
Figure 7

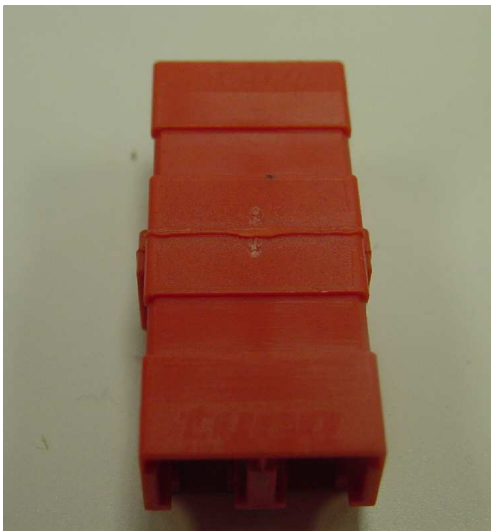


**ACCEPTABLE**

Flash Around the Weld Line SC  
Figure 8



**ACCEPTABLE**  
Flash Around the Weld Line  
LC, LC Cutout  
Figure 9



**Not ACCEPTABLE**  
Heavy Flash Around the Weld Line  
LC Secure  
Figure 10



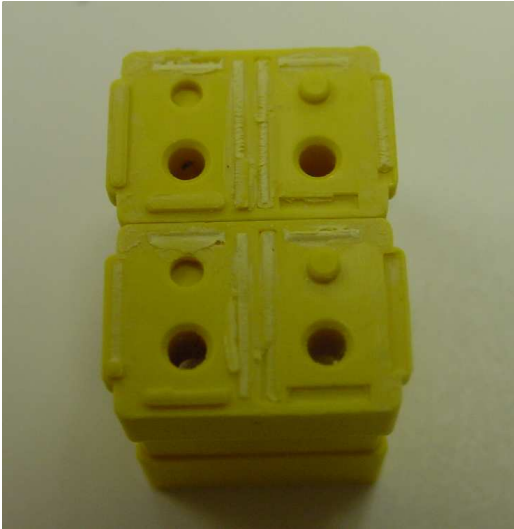
**Not ACCEPTABLE**

Heavy Flash Around the Weld Line SC  
Figure 11



**Not ACCEPTABLE**

Heavy Flash Around the Weld Line  
LC, LC Cutout  
Figure 12

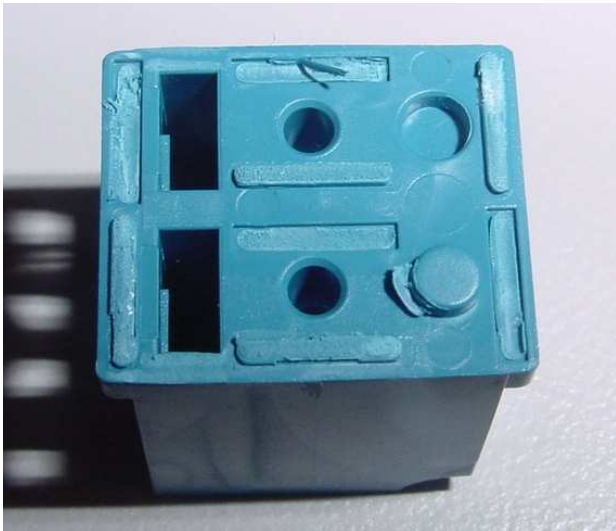


**ACCEPTABLE**  
Weld at Break Test  
LC Secure  
Figure 13



**ACCEPTABLE**  
Weld at Break Test, SC  
Figure 14

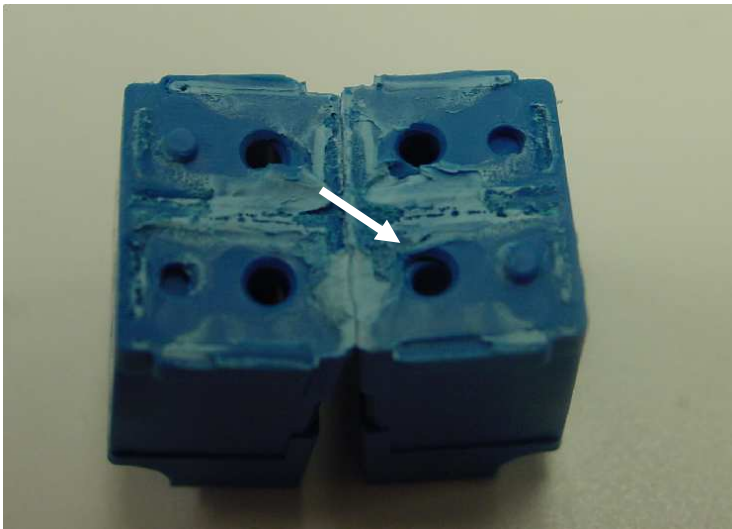




**ACCEPTABLE**

Weld at Break Test,  
LC, LC Cutout

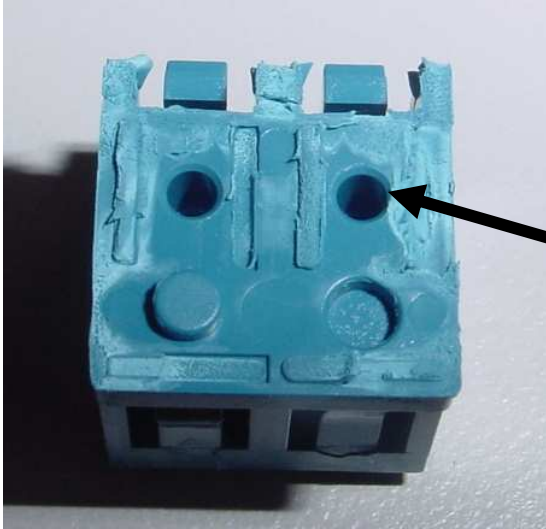
Figure 15



**Not ACCEPTABLE**

Weld At Break Test  
Flash at Alignment Sleeve Cavity  
LC Secure

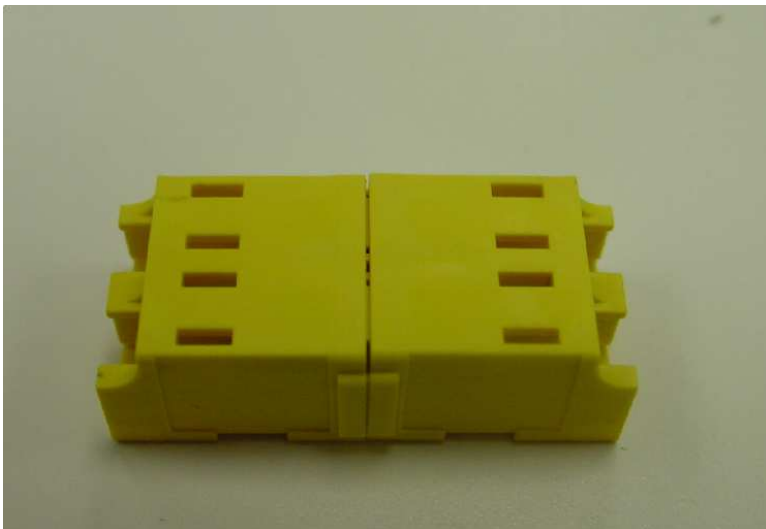
Figure 16



**Not ACCEPTABLE**

Weld At Break Test  
Flash at Alignment Sleeve Cavity  
LC, LC Cutout

Figure 17



**Not ACCEPTABLE**

Gap Between Housings  
LC Secure  
Figure 18



**Not ACCEPTABLE**  
Gap Between Housings SC  
Figure 19



**Not ACCEPTABLE**  
Gap Between Housings  
LC, LC Cutout  
Figure 20



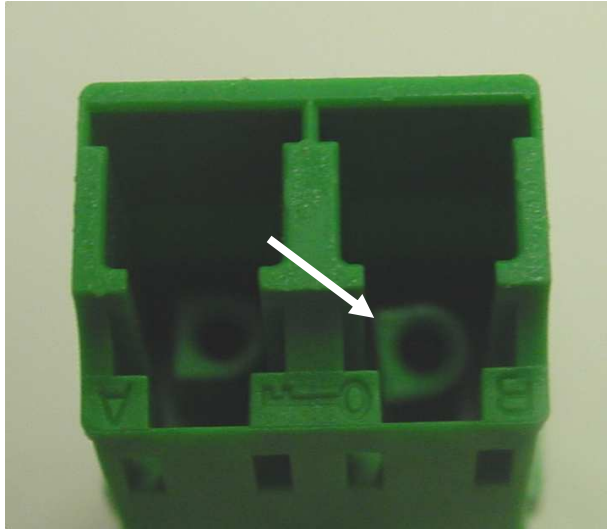
**Not ACCEPTABLE**

Housings Reversed  
Figure 21



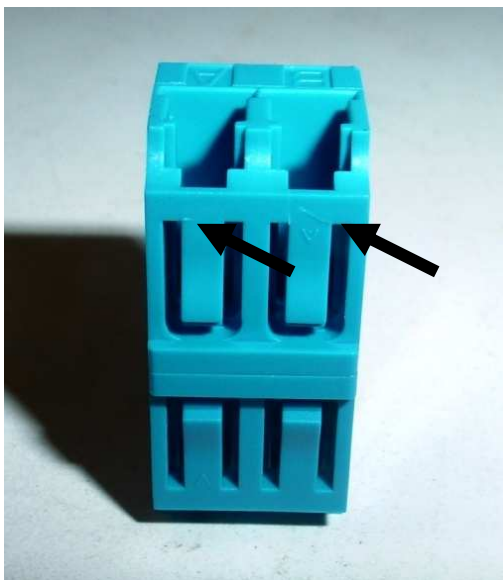
**Not ACCEPTABLE**

Weld Fractures LC Secure  
Figure 22



**Not ACCEPTABLE**

Broken Stack  
Figure 23



**Not ACCEPTABLE**

Broken Latch  
Figure 24