
Fortis ZD 2 and 3 pair shielded right angle and vertical module assembly Inspection Criteria

1. SCOPE

This specification defines the acceptable and the not acceptable conditions for the Shielded Fortis modules.

2. INSPECTION CRITERIA

Unless otherwise specified, Figures are shown at approximately 5X to 10X magnification. Parts shall be viewed at 10X magnification for 10 seconds at 405mm to 610 mm [12 in. to 24 in.] from the eyes. Proper lighting should be used to determine acceptance within the specified time and distance.

2.1. Shield Form and Adhesion



Figure 1

● ACCEPTABLE

- Shield is clearly adhered to all modules.
- Shield is formed at right angles on all corners.

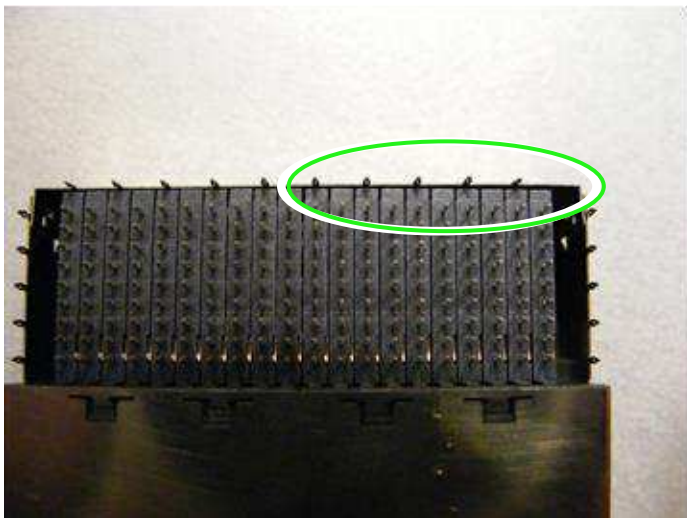


Figure 2

● ACCEPTABLE

- Hairline separation from modules.
- Shield is still clearly adhered to modules when looked under proper magnification.

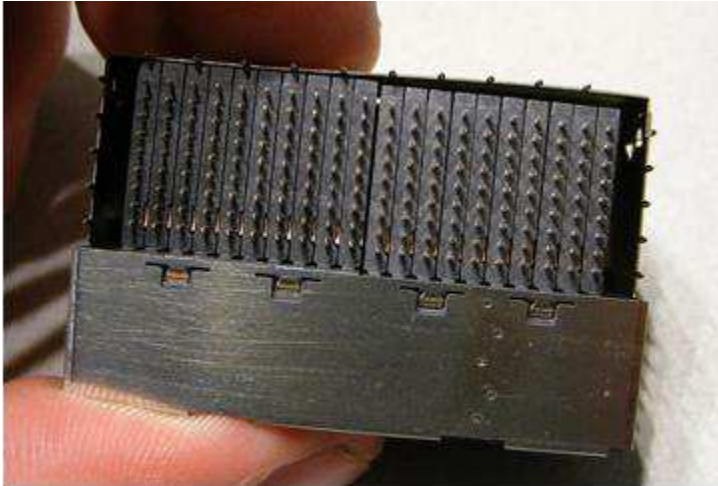


Figure 3

● **NOT ACCEPTABLE**

- Shield partially separated from right side of module.
- Top right corner folded at acute angle.

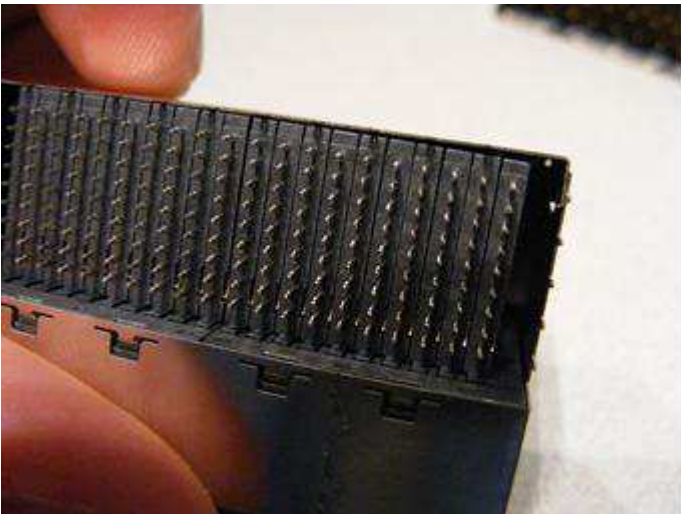


Figure 4

● **NOT ACCEPTABLE**

- Entire right side of shield separated from right module.

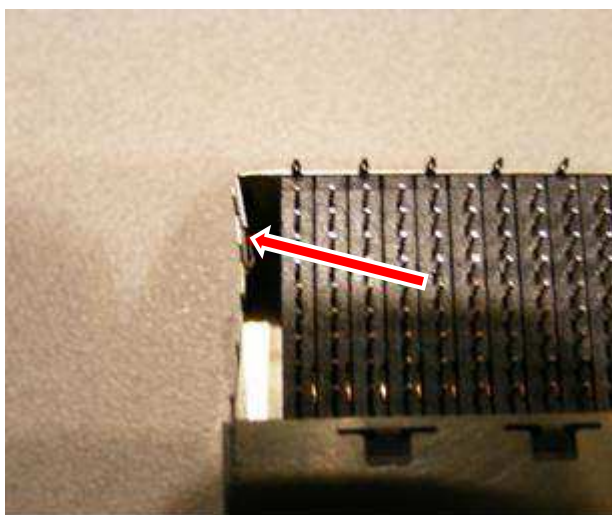


Figure 5

● **NOT ACCEPTABLE**

- Left side of shield plastically deformed out of shape.

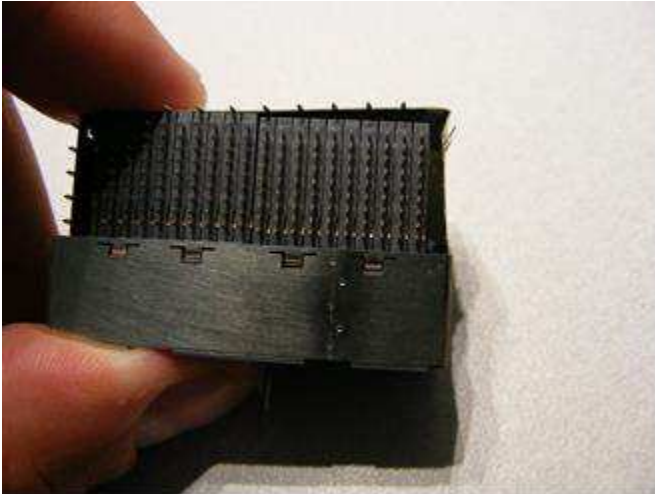


Figure 6

● **NOT ACCEPTABLE**

- Shield separated and/or plastically deformed.



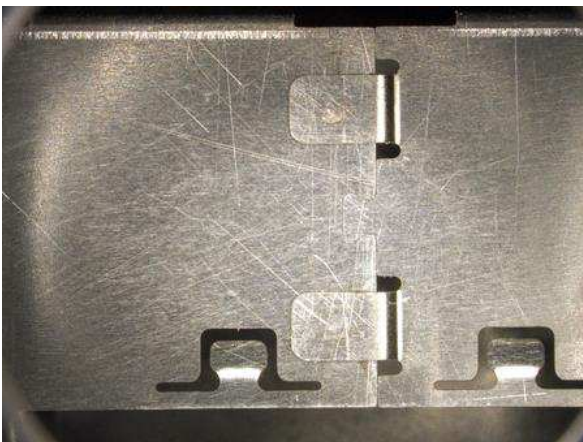
Figure 7

● **NOT ACCEPTABLE**

- Unformed and unlatched tab.

2.2. Weld Joint

2.2.a 2 PAIR RIGHT ANGLE SHIELD



● **ACCEPTABLE**

- Good weld sample
- Dovetails aligned and in plane
- Weld centered
- No discoloration
- Slight indentation

Figure 8

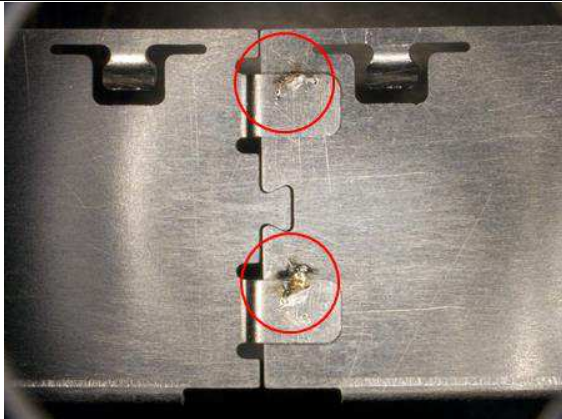


Figure 8

● **NOT ACCEPTABLE**

- Welding location too close to edge, resulting in discoloration and spattering

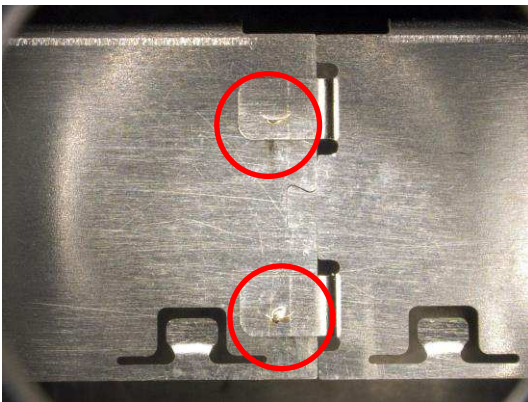


Figure 9

● **NOT ACCEPTABLE**

- Raised burr
 - Insufficient electrode force
 - Dirty electrode

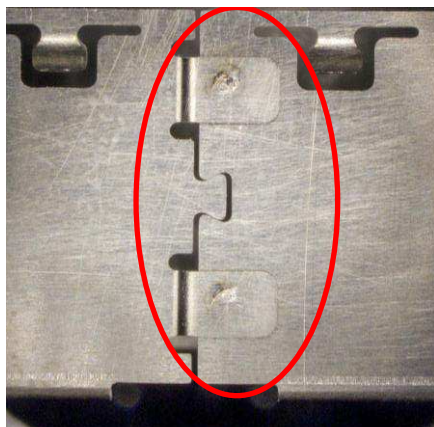


Figure 11

● **NOT ACCEPTABLE**

- Loose dovetail
- Weld discoloration and location

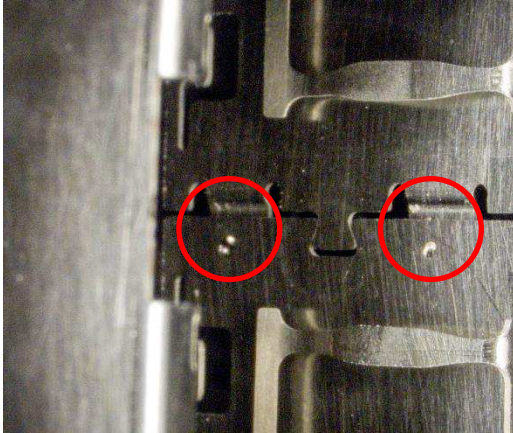


Figure 12

● **NOT ACCEPTABLE**

- Weld burn through on inside surface

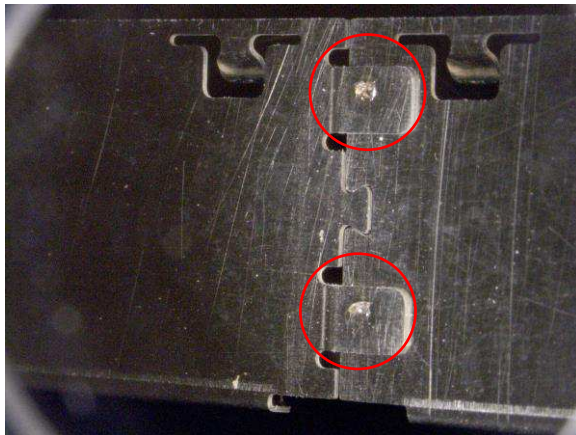
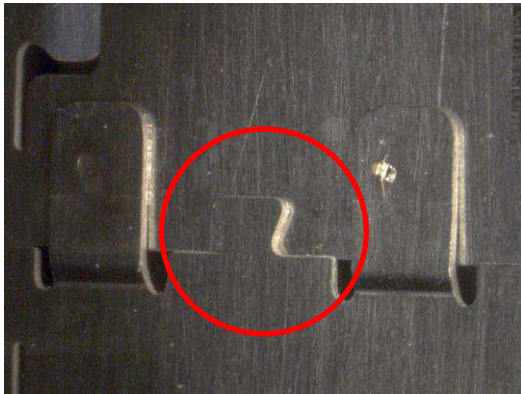


Figure 13

● **NOT ACCEPTABLE**

- Weld location too close to shield seam
- Excessive indentation, discoloration, and raised burr.

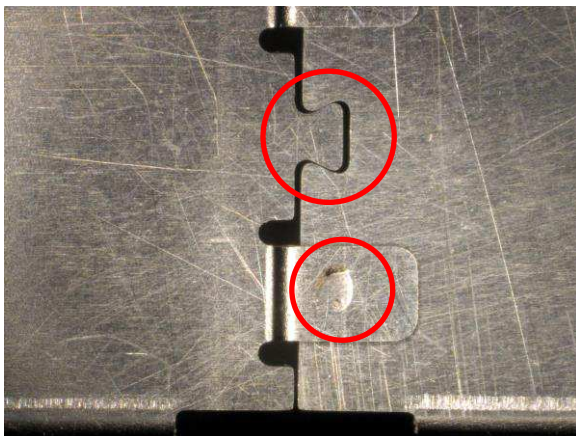
● **NOT ACCEPTABLE**



- Mismatch in shield dovetail surfaces.

Figure 14

● **NOT ACCEPTABLE**



- Loose dovetail
- Raised burr

Figure 15

2.2.b 3 PAIR RIGHT ANGLE SHIELD

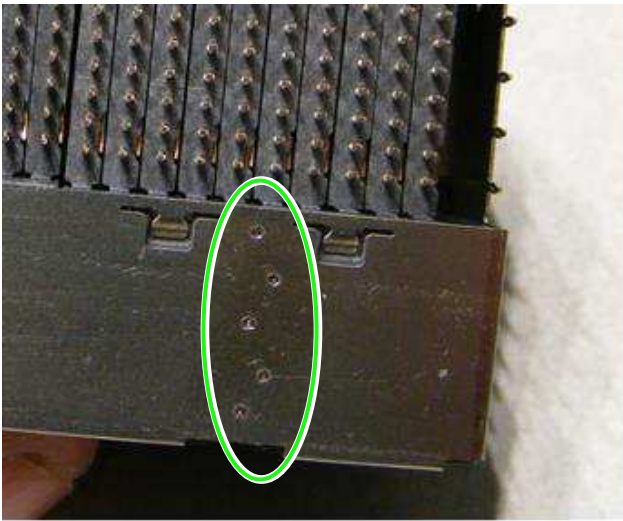


Figure 16

● **ACCEPTABLE**

- All five weld marks present and clean.
- No excessive bending around weld joint.

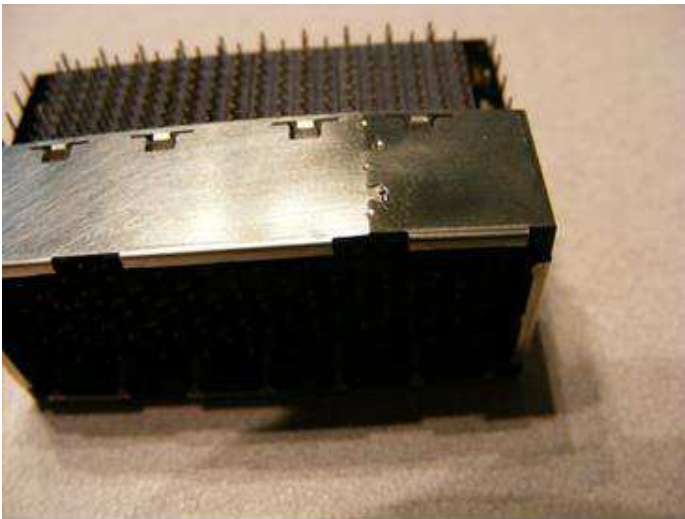
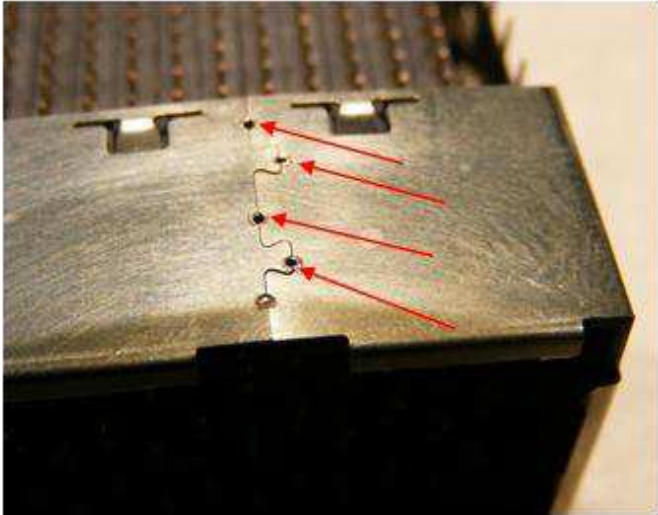


Figure 17

● **NOT ACCEPTABLE**

- Weld joint bent upwards.



● **NOT ACCEPTABLE**

- Weld joints blown through.

Figure 18

2.3. Pins (Individual and Array)

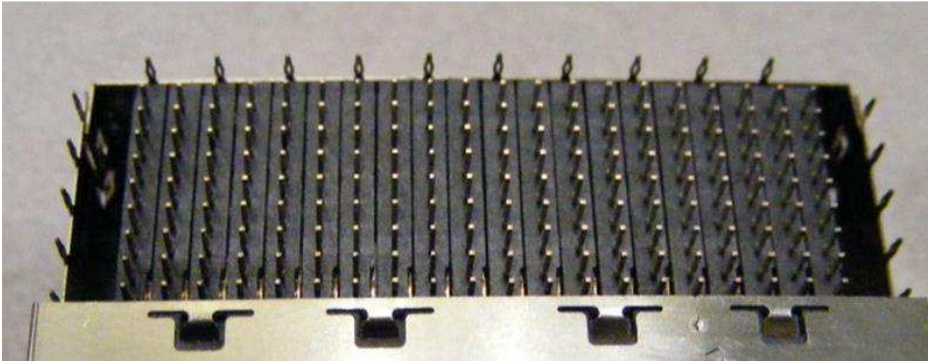


Figure 19

● **ACCEPTABLE**

- Pin pattern consistent
- All pins present
- No pins bent



Figure 20

● **NOT ACCEPTABLE**

- Row of pins in modules bent.
- Individual pins on shield bent.

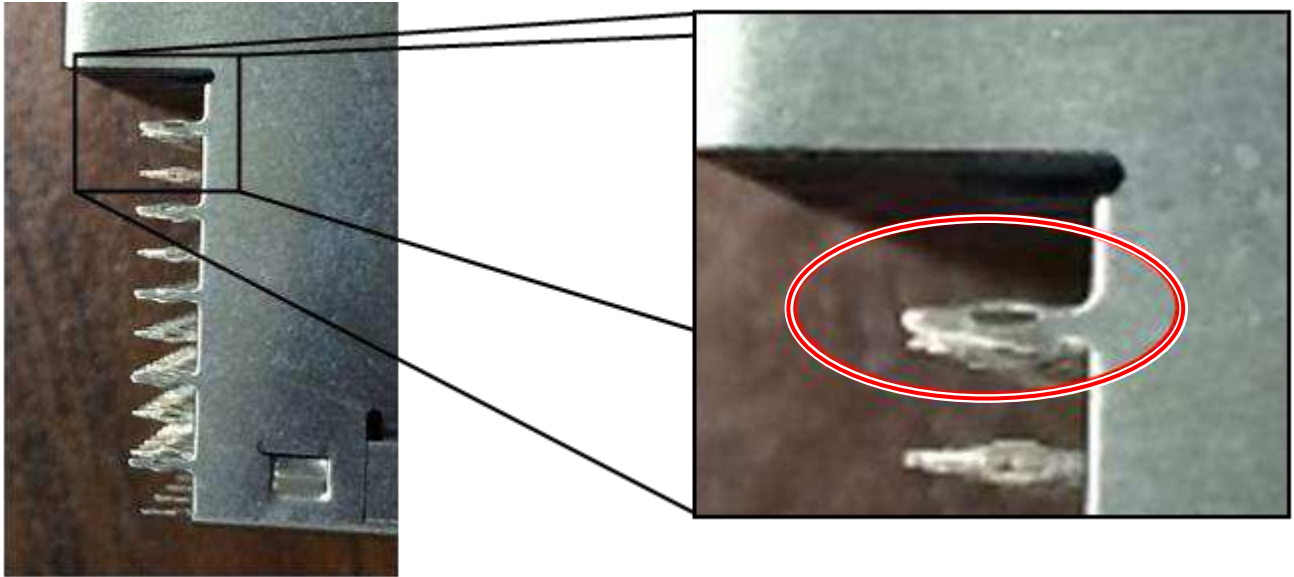


Figure 21

● **NOT ACCEPTABLE**

- Eye of needle offset from center of shielded pin.

2.4. Packaging – Right angle assemblies

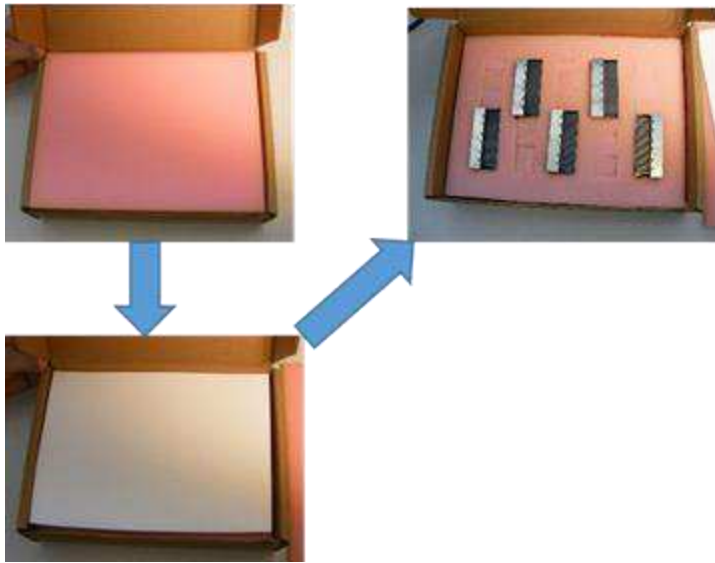


Figure 22

● **ACCEPTABLE**

- Layering of packaging materials in correct order (from top to bottom): 1. Foam 2. Cardboard support 3. Nested parts 4. Foam.
- Parts shown are a 30 column part – pattern and spacing of packaging is required of 30, 40, 50 column parts.

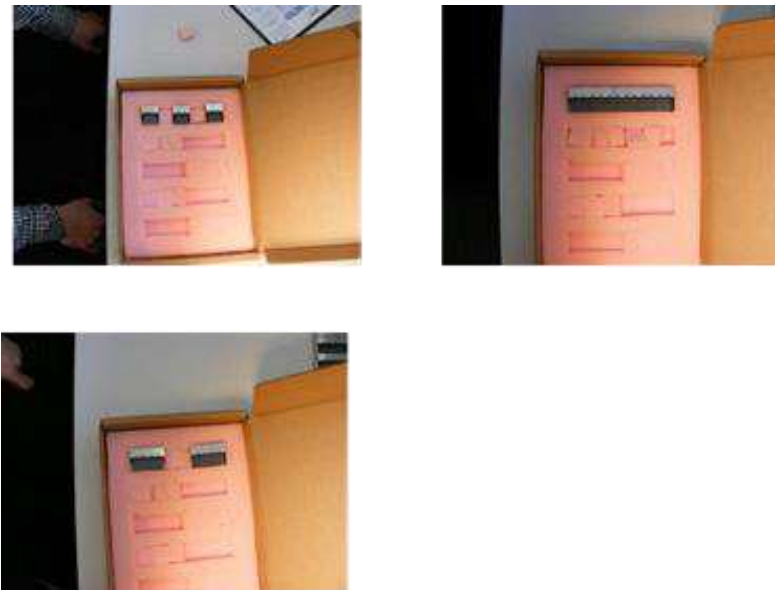


Figure 23

● **ACCEPTABLE**

- Parts shown are (clockwise from top left) 10 column part, 60 column part, 20 column part. Pattern and spacing is typical and required.

Packaging – Vertical assemblies

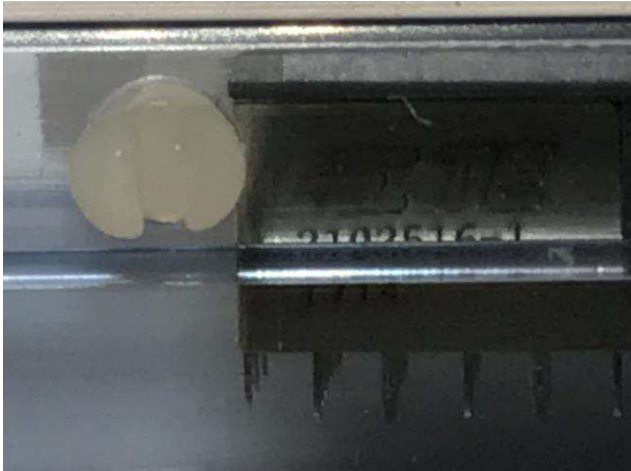


Figure 24

● ACCEPTABLE

- Correct loading position of vertical assembly part EONs Relative to Pin



Figure 25

● NOT ACCEPTABLE

- Incorrect loading position of vertical assembly part EONs Relative to Pin



Figure 26

● **ACCEPTABLE**

- Cut Bubble Sleeve to 25" Length and Load Tube Inside Sleeve – One Tube Per Sleeve



Figure 27

● **ACCEPTABLE**

- Load Bubble Sleeve Into Box One Per Layer – 6 Layers Per Box

2.5. Presence of Module Shielding



NOTE

This section (2.5.A) only valid for part numbers 2102247-1 through 2102247-6.

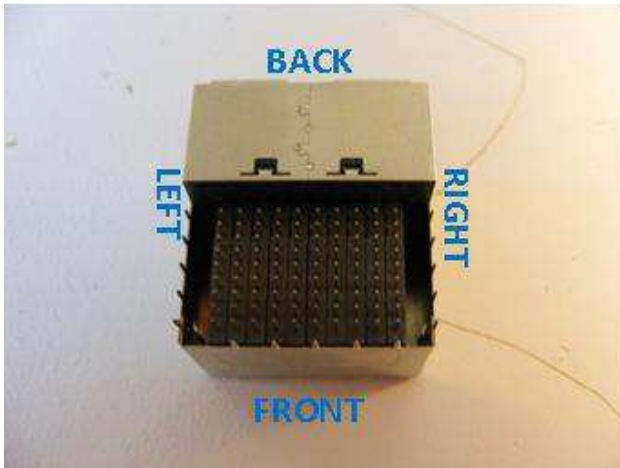


Figure 28

REFERENCE

All of the photos in this section that refer to a left or right side of the part refer to the layout as shown in Figure 16.

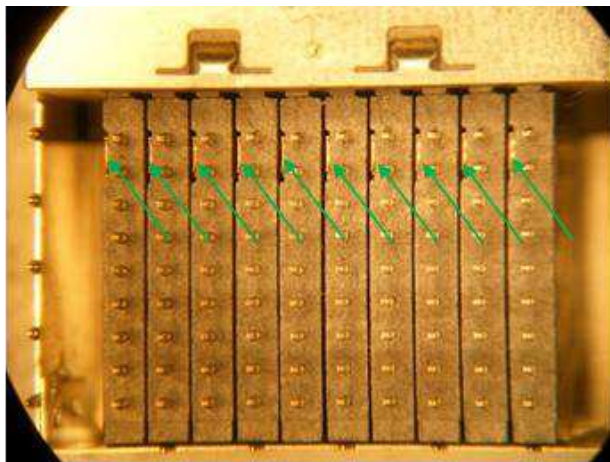


Figure 29

● ACCEPTABLE

- All shields present on each module as evidence by tab on back left of individual modules.

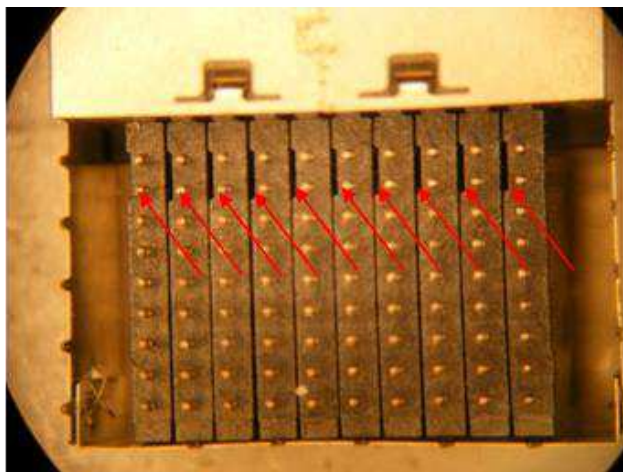


Figure 30

● NOT ACCEPTABLE

- Shield missing.

**NOTE**

This section (2.5.B) only valid for part numbers 2102320-1 through 2102320-6.

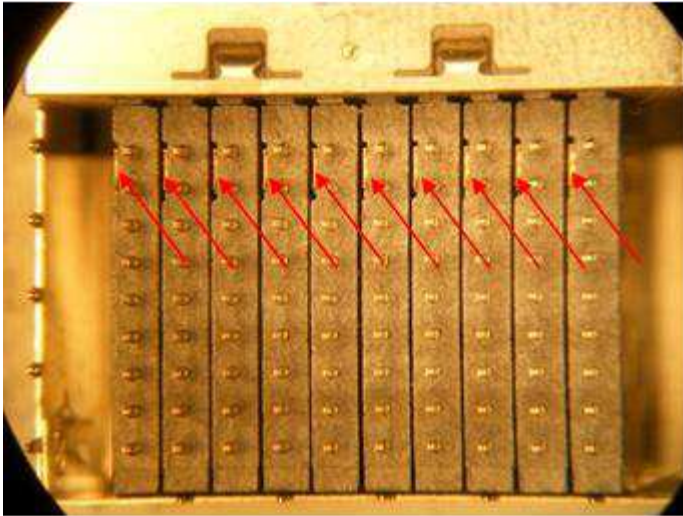


Figure 31

● NOT ACCEPTABLE

- Shields present on modules.

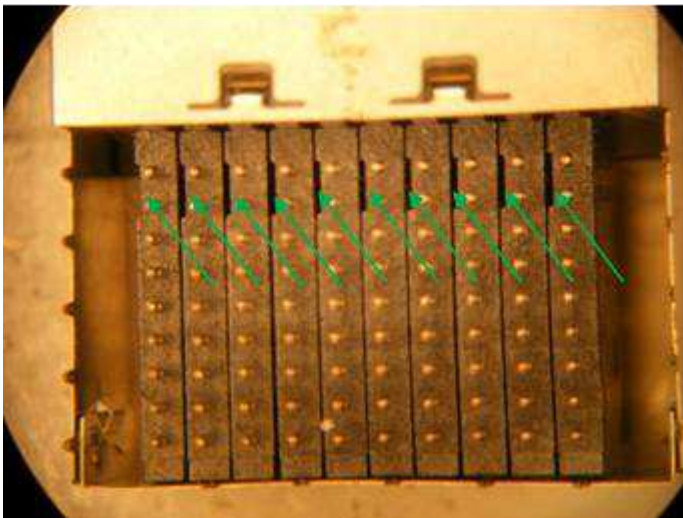


Figure 32

● ACCEPTABLE

- No shields present.