

Adhesion Force Procedure-WI 038

Part #: Non specific		Part Name/Product: Non specific		Operation: Adhesion Force Gage Setup and Operation Procedure	
Originated 02/16/99 B. Skiba	Rev: A	Quality Engineer: Laura Richards Revised 8/23/00 by L. Richards		Equipment: Adhesion Force 5 Gage	Page: 1

Step #	Procedure	Part #	Part Description	Qty	To/Location	How/Using	TQC Information	Fig.
010	Set-up		Adhesion Force Gage Station	1	Inspection Area	Manually	✓ Turn on the force gage: Press the power button	1,1A
020	Set-up		Adhesion Force Gage Station	1	Inspection Area	Visually and Manually	✓ Check to see if force gage display screen is reading in Newton. NOTE: There will be a small "N" in the bottom right corner of the display. ✓ NOTE: If force gage is not reading Newton use set-up instructions on back side of force gage and also see Q.C. Engineer or Q.C. Technicians for help if needed.	1A,1B
030	Set-up		Adhesion Force Gage Station	1	Inspection Area	Manually	✓ Set the force gage to display peak values on the display screen by pressing the middle button labeled "PEAK"	1A
040	Set-up		Adhesion Force Gage	1	Inspection Area	Visually and Manually	✓ Make sure the display screen is reading zero, if it doesn't, Press the top button labeled "ZERO"	1A

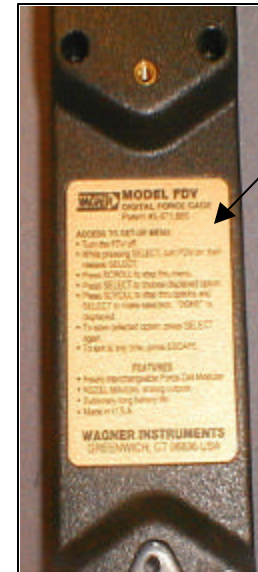


Fig. 1

Adhesion Force Gage Station



Fig. 1A



Set-Up Instructions
On Back Side of
Force Gage

Fig. 1B

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Step #	Procedure	Part #	Part Description	Qty	To/Location	How/Using	TQC Information	Fig.
010	Part Placement	N/A	Gasketed Housing	1	Inspection Area	Manually	✓ Place a gasketed part in the mount/holding fixture and place in Adhesion Force Gage Station as shown.	3,3A
020	Measuring Adhesion	N/A	Gasketed Housing	1	Inspection Area	Manually adhesion probe # T0501-3	✓ Turn the hand-wheel until the probe slides past gasket; the 'Test till Failure' version of the test or until the spec. limit is met. Spec. Information can be obtained from Process Documentation at Gantries, see QA Engineer or QA. Technicians for help if needed. ✓ NOTE: See additional instructions as shown in Fig. 4	4

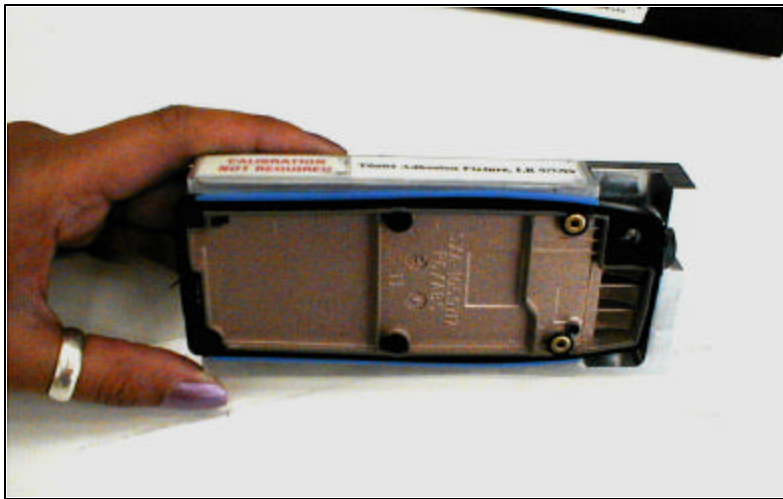


Fig. 3

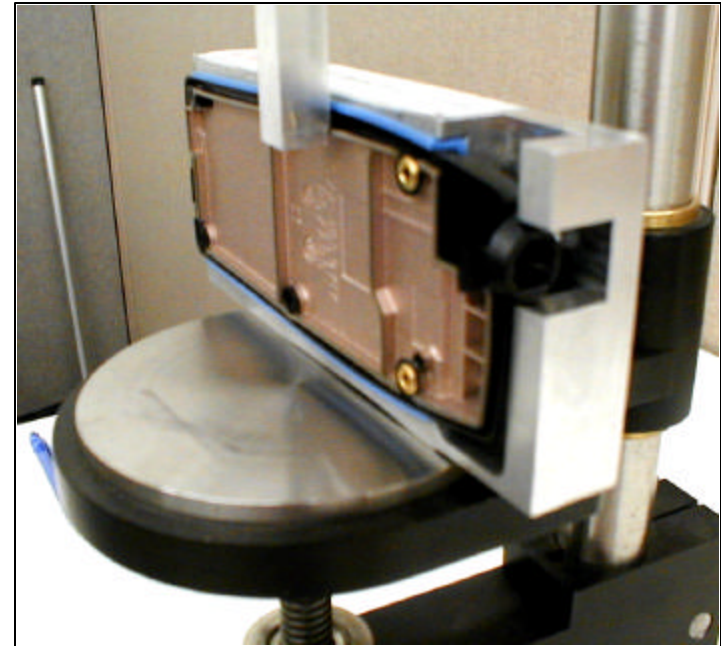


Fig. 3A

Initiator: Frank Bardascino		Dave Boland	<i>Dave Boland</i>
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Measuring Instructions:

1. Place a gasketed part in the Adhesion Force Gage Station and hold firmly into place as shown.
2. Turn the hand-wheel clockwise until the probe makes contact to the gasket from the side as shown in **Fig. 3A**.
3. Keep turning hand-wheel until the probe slides past the gasket; The 'Test till Failure' method or the adhesion spec. limit is met.

NOTE: Spec. Information can be obtained from Process Documentation at Gantries, see Q.C. Engineer or Q.C. Technicians for help if needed

4. Take and record reading off the force gage display screen.
5. Lower the stage/round base by turning the hand-wheel counter clockwise to make room for the next part.
6. Zero the force gage see **Fig. 1A** and repeat steps above 1 through 5 for each additional part.

NOTE:

Do not make any adjustments to where the stage/round base or the force gage is located by loosening the black knobs. They are fine the way they are and if they are loose, you will not get an accurate reading.

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Revision History:

8/23/00, L. Richards Rev – to A

1. Format change from word document to current format.

1/17/01, L. Richards Rev A to B

1. Addition of adhesion probe part number: T0501-3

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