

MOOG

MACHINING SUPPLIER WORKMANSHIP STANDARDS

Issue: 1-APRIL- 2007

INTRODUCTION

Supported by valued suppliers, Moog has developed a reputation for quality, performance and delivery that has helped it to become a leading supplier of highly sophisticated control systems. Quality workmanship will help Moog products to meet or exceed customer expectations, and assure our mutual success in the marketplace.

This document supplements engineering drawings and purchase order requirements for machined parts. In the event of conflict, engineering drawings and purchase order requirements shall take precedence.

TRACEABILITY

Each lot of material issued by Moog is designated by a traceability (work order, receiver or purchase order) number. In order to preserve required traceability, make sure that:

- Individual lots of material are not mixed
- Items produced from different lots of Moog-supplied material are organized into separate lots
- Items produced can be traced to the specific lot of Moog-supplied material used

HANDLING & PACKAGING

Parts should be handled and packaged as required to preserve lot identity, and prevent damage.

Completed parts should be cleaned and, if required, protected using an appropriate corrosion preventive prior to packaging. Packaging should prevent damage due to contact of parts with one another during shipment.

GUIDELINES FOR MACHINING

Guidelines for the following are presented on the following sections.

- 1. - [Electrical Discharge Machining](#)
- 2. - [Machined Hole Surfaces](#)
- 3. - [Threaded Bores/Holes](#)
- 4. - [Intersecting Passages](#)
- 5. - [Bores](#) (Lead, Intersections, Surfaces)
- 6. - [Burr](#)s

1. ELECTRICAL-DISCHARGE MACHINING (EDM)

EDM surfaces should be free of particles (spherical globules, splatter) eroded from base material, and carbon-like layered deposits. Removal should be performed using an appropriate process (liquid honing, wet blasting, for example) having minimal affect on close tolerance features. Resulting contaminants el b

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2. MACHINED HOLE SURFACES

Surfaces of machined holes should be free of stripped and potentially loose metal particles.

Uniform surface

ACCEPTABLE

*Rough surface but no
potentially loose particles*

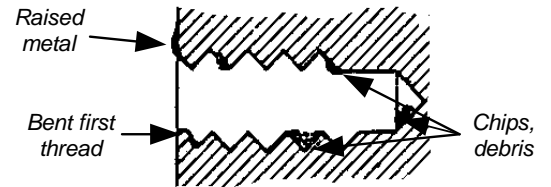
*Potentially loose friction
welded particles*

UNACCEPTABLE

3. THREADED BORES/HOLES

Threaded bores/holes should be free of chips, burrs and major discontinuities. Chips and dislodged burrs may degrade or entirely disable systems, while major discontinuities may damage mating parts or complicate assembly.

A - As designed thread
coe



UNACCEPTABLE Conditions in Threaded Holes

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6. BURRS

Edges should comply with drawing edge break requirements and be free of burrs. When dislodged, burrs may cause product failures, adversely affect subsequent machining and dimensional inspections, and damage other parts. While ultimate acceptance criteria depends upon factors including product application, burrs that are visible at 5-10X magnification or may be

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