




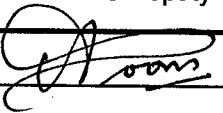
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**RADIOGRAPHIC INSPECTION OF
QUARTZ CRYSTAL UNITS
ESA/SCC Basic Specification No. 2093501**



**space components
coordination group**

Issue/Rev.	Date	Approved by	
		SCCG Chairman	ESA Director General or his Deputy
Issue 1	September 1994		



SCC

ESA/SCC Basic Specification
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DOCUMENTATION CHANGE NOTICE

Rev. Letter	Rev. Date	Reference	CHANGE Item	Approved DCR No.

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**1. SCOPE**

This specification, to be read in conjunction with ESA/SCC Basic Specification No. 20900, Radiographic Inspection, contains additional specific requirements for Quartz Crystal Units, which shall be applied, where relevant, to each device.

2. GENERAL REQUIREMENTS**2.1 APPLICABILITY**

The following criteria may not be varied or modified after commencement of any inspection stage. Any ambiguity or proposed minor deviation shall be referred to the Qualifying Space Agency for resolution and approval.

2.2 PROCEDURE

All items shall be examined in such a manner that a minimum of handling and movement of the components is involved.

2 X-ray views shall be taken of each crystal unit (as shown in Figure I).

2.3 MOUNTING FIXTURES

Suitable fixtures may be used to assist in the inspection process provided they do not of themselves cause damage to the device.

3. DETAILED REQUIREMENTS**3.1 GENERAL**

The radiographic examination of quartz crystal units shall include, but not be limited to, inspection for foreign or loose particles, identification of element mount, alignment of crystal element, clearance of conductive elements and case and the case seal.

A component shall be rejected if it exhibits one or more of the defects listed in the following paragraphs.

3.2 QUARTZ CRYSTAL UNITS**3.2.1 Mount-Type**

The element mount shall be recorded in the radiography report, indicating either a 2-, 3- or 4-ribbon mount for support of the element.

3.2.2 Extraneous Material

Loose or adherent material larger than 0.05mm in its longest dimension.

3.2.3 Clearances

Clearances between internal components (ribbons, conductive elements, crystal elements, posts, etc.) such that the case material and all internal elements are separated by 0.3mm or less.

**3.2.4 Alignment**

Crystal element not aligned to within 10° of the normal horizontal plane of the base of the crystal-mounting pads.

Internal ribbons non-uniform in length and construction and not within 10° of the vertical.

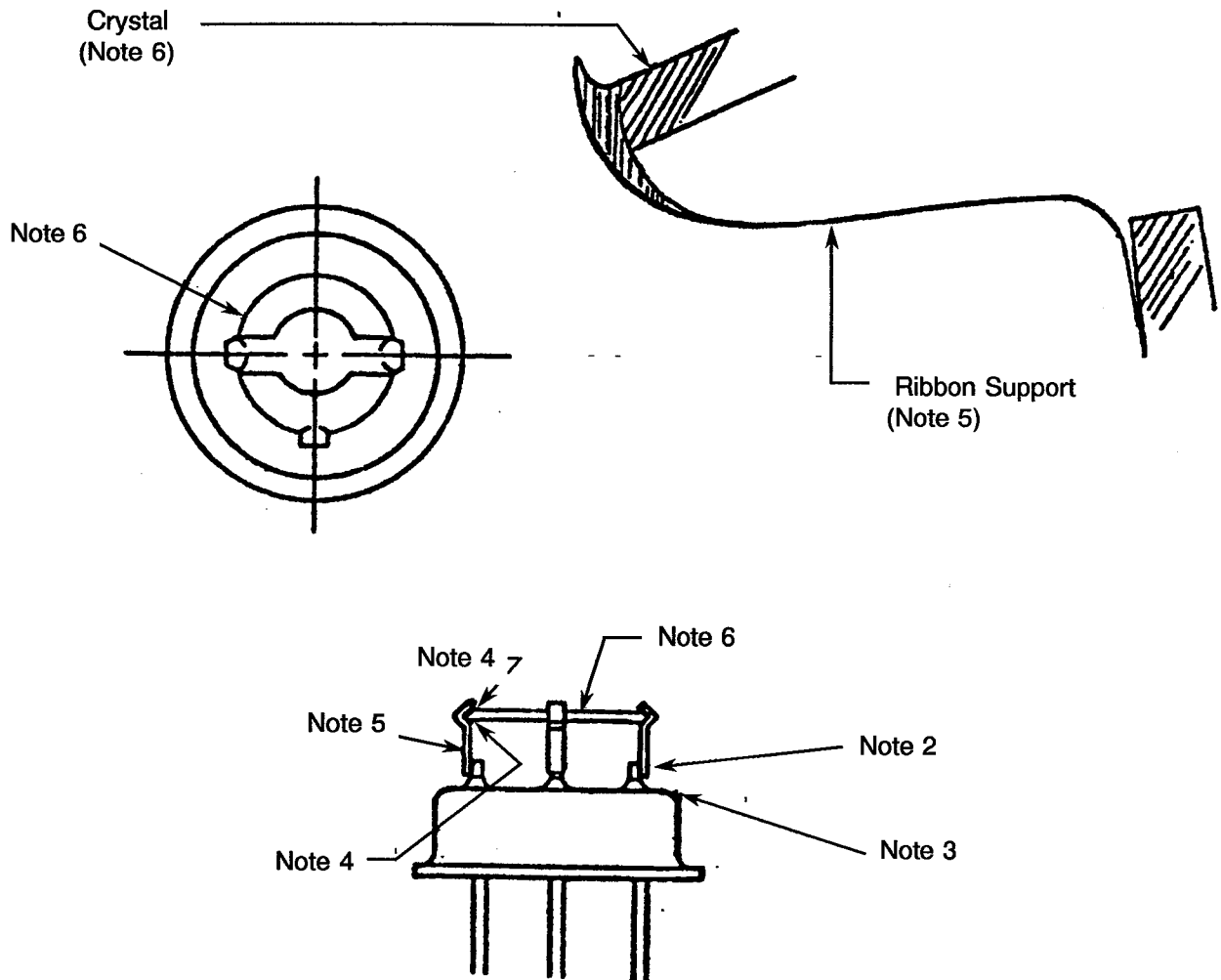
3.2.5 Lid Seal

Voids resulting in more than 50% reduction in seal width (no through voids).

Total void area reducing total seal area by more than 30%.



FIGURE I - TYPICAL



NOTES

1. Not drawn to scale; outline is typical of a DK (TO-5) or (TO-8) header.
2. Weld attachment.
3. Mounting base.
4. Bonding cement is placed here at each support.
5. Ribbon-type support; the ribbon will be shaped in accordance with the diameter of the quartz and the position of the pads on the mounting base.
6. Quartz element.