



MTS-Test Workmanship Standards


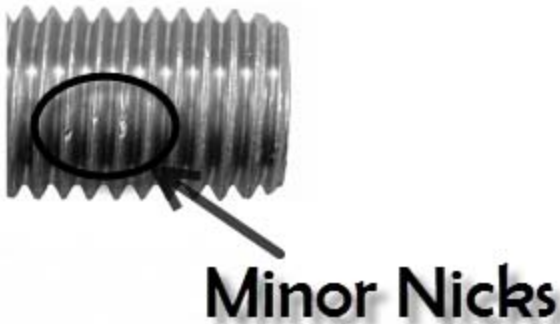
Workmanship Standards Number: 02-04

Rev: A

- 1.1 Name: Machining – Threads, Internal and External
- 1.2 Workmanship Standards Category: Metal Fabricated Materials
- 1.3 Purpose/Description (why/when/how): To supplement the part print to help define in illustrations what is difficult or not possible to define on a print. This is applicable to machined threads regardless if they are cut, mill, milled, or rolled.

Illustration:

The following illustrations depict “Acceptable” and “Unacceptable” workmanship results.

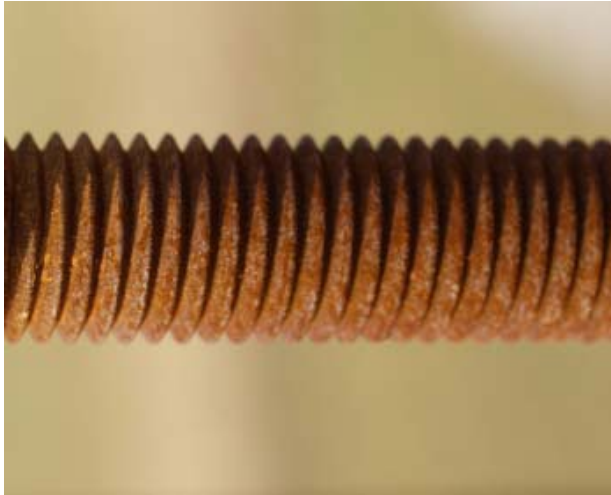
Acceptable Workmanship	Acceptable Notes
	<p>All threads should be fully formed or cut and should be of the correct thread size, class and form per the print. Threads shall be free of tears, cracks, loose burrs and contamination.</p>
	<p>Minor nicks, dents, or scrapes on threads are ok and are not reason for reject unless they do not gage acceptable with the correct thread gages.</p>
Unacceptable Workmanship	Unacceptable Notes



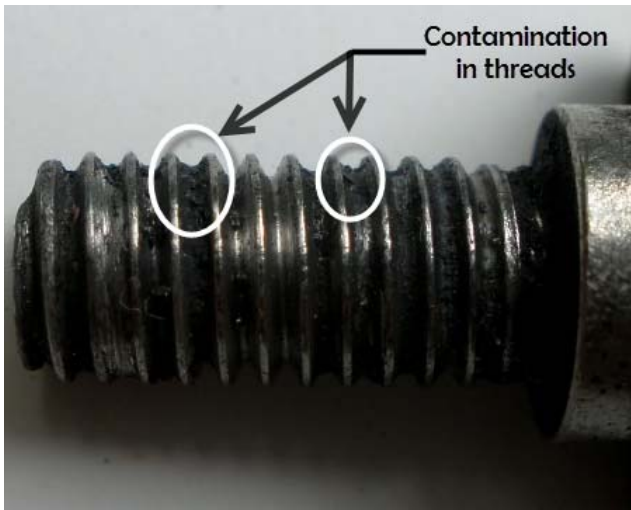
MTS-Test Workmanship Standards

Workmanship Standards Number: 02-04

Rev: A



Threads shall be adequately protected to prevent corrosion. Corroded, rusted, or excessively oxidized threads are unacceptable and can lead to decreased fastener strength, incorrect torque values and overall unacceptable quality appearance.



Dirt, grease, chips, and contamination in threads are unacceptable and can lead to poor assembly, contamination of the hydraulic system or improper torque values.



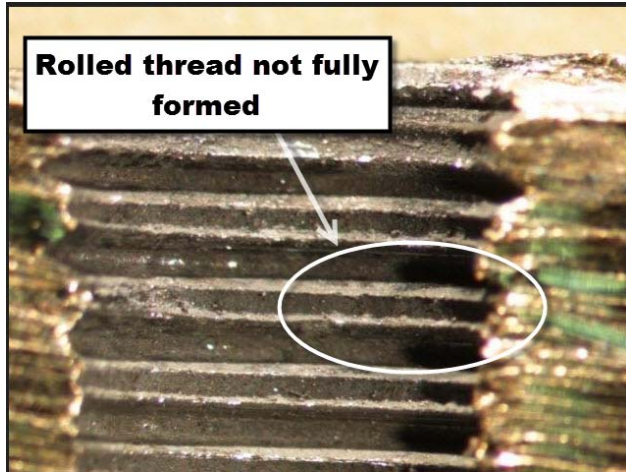
Threads that are cross-threaded are unacceptable. They can prevent future thread engagement and can lead to decreased fastener strength, incorrect torque values and overall unacceptable quality appearance.



MTS-Test Workmanship Standards

Workmanship Standards Number: 02-04

Rev: A



Rolled threads that are not properly formed are unacceptable. This can lead to larger than specified minor diameter, lower thread strength, and could lead to miss-threading the fastener.

2 REVISION HISTORY & APPROVAL

REVISION HISTORY			
Rev	Description of Change	Author	Effective Date
A	Initiated	Jim Fischer	3/11/13

APPROVAL OF CURRENT REVISION		
Name / Function	Signature	Date
Stephen Jordheim / Workmanship Standards Process Owner	(approval on file)	
Alan Rivers / Workmanship Standards Co-Pilot	(approval on file)	