

IN-HOUSE PROCEDURE # _____

PROCEDURE FOR VERIFYING RETAINERS

Item:

Retainer

Purpose:

This method provides instructions for checking the critical dimensions and planeness of retainer rings.

Inspection Equipment Required:

1. Ruler or caliper readable to at least 1/16 inch or 1 mm.
2. Feeler gauge 0.002 in. (0.05 mm)
3. Straightedge at least as large as the retainer diameter

Tolerance:

Equipment shall meet the dimensional tolerances specified in the applicable test method.

Procedure:

1. Measure the total height of the retainer ring.
2. Measure the thickness of the outside ring.
3. Measure the base thickness of the retainer.
4. Measure the inside diameter of the retainer.
5. Examine the bearing surface of the retainer ring for gouges, grooves, protusions and indentations. None shall be greater than the allowed tolerances.