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THE BASIC CRITERIA FOR INSPECTION OF SURFACES
OF BRASS AND BRONZE CASTINGS SHALL BE AS
FOLLOWS:

(1) ON NONMACHINED SURFACES, INDIVIDUAL
DISCONTINUITIES HAVING ROUNDED POROSITY OF 1/16
INCH DIAMETER OPENING OR SMALLER ARE AC-
CEPTABLE PROVIDED THE COMPONENT HAS SUC-
CESSFULLY PASSED HYDROSTATIC TESTING AND
MINIMUM WALL THICKNESS IS NOT VIOLATED.
WALL THICKNESS IS TO BE EVALUATED TO
MAXIMUM POSSIBLE EXTENT WITHOUT GRIND-
ING, I.E., LOCATION ON CASTING, ETC..

OPENINGS OVER 1/16-INCH MUST BE EXPLORED
BY GRINDING AND MUST NOT VIOLATE MINIMUM
WALL THICKNESS.

(2) ON NONMACHINED SURFACES, CLUSTERS OF
THREE OR MORE DISCONTINUITIES, HAVING ROUNDED
POROSITY, THAT CAN BE INCLUDED WITHIN A
1/2-INCH DIAMETER CIRCLE, SHALL BE EX-
PLORED BY GRINDING AND MUST NOT VIOLATE
MINIMUM WALL THICKNESS. ASSURANCE WILL
BE MADE THAT POROSITY DOES NOT EXTEND
BEYOND THE IMMEDIATE SURFACE.

(3) ON NONMACHINED SURFACES, DISCONTINUITIES
HAVING LINEAR POROSITY MUST BE EXPLORED BY

GRINDING AND MUST NOT VIOLATE MINIMUM WALL THICKNESS. ASSURANCE SHALL BE MADE THAT POROSITY DOES NOT EXTEND BEYOND THE IMMEDIATE SURFACE.

(4) ON NONMACHINED SURFACES, ROUGHNESS OR DEPRESSIONS IN CASTINGS INCLUDING THOSE RESULTING FROM NORMAL HANDLING, OTHER THAN POROSITY, SHALL BE ACCEPTABLE PROVIDED THERE ARE NO SHARP CORNERS, THE DEPRESSION IS ROUNDED (RADIUS AT LEAST EQUAL TO THE DEPTH). AND MINIMUM WALL THICKNESS IS NOT VIOLATED.

(5) ON NONMACHINED SURFACES, GROSS CASTING DEFECTS SUCH AS HOT TEARS, CRACKS, ETC., ARE UNACCEPTABLE.

(6) CRITICAL MACHINED SURFACES SUCH AS SEATING AREAS, SEALING SURFACES AND EXTERNAL SURFACES INCLUDED AS PART OF THE PRESSURE ENVELOPE OF THE COMPONENT SHALL BE FREE OF ANY VISIBLE SURFACE DISCONTINUITIES.

(7) NONCRITICAL MACHINED SURFACES SUCH AS THE AREA BEYOND THE CIRCUMFERENCE OF THE BOLT HOLES IN FLANGES ARE ACCEPTABLE WITH SURFACE POROSITY TYPE DISCONTINUITIES, PROVIDED THAT THESE DEFECTS ARE NOT DETRI-

MENTAL TO THE FUNCTION OF THE COMPONENT.

(8) DISCONTINUITIES WHICH DO NOT HAVE A CRACK-LIKE APPEARANCE (i. e., DO NOT HAVE A BOTTOM RADIUS-TO-DEPTH RATIO LESS THAN ONE) ARE ACCEPTABLE.