



GCS

FINISH SPECIFICATION
L-3 GCS LASER ETCH
1000-0015-01 REV A
AUG 26, 2013

FINISH SPECIFICATION: L-3 GCS LASER ETCH

1.0 SCOPE

This specification details the approved process for L3-GCS Laser Etch.

2.0 PROCESS:

In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3.0 PROCESS REQUIREMENTS:

The following are process requirements:

- 3.1 Use 3D CAD files for marking creation. All marking tolerances are +/- .001.
- 3.2 Markings should be crisp and clean, no double images.
- 3.3 Resulting marking color should fill the Letter or Feature
- 3.4 Color should be even one color, no shading, pixilation or cracks.
- 3.5 Each number or letter is complete, and legible, i.e., none of the lines forming a character are missing or broken.
- 3.6 Polarity and orientation markings are present and legible.
- 3.7 Lines forming the character are sharply defined and uniform in width.
- 3.8 Marking forming the characters is uniform, i.e., there are no thick or thin spots.
- 3.9 The open areas within characters are not filled (applies to numbers 0, 6, 8, 9 and A, B, D, O, P, Q, R).
- 3.10 Marking is confined to the lines of the character.
- 3.11 The depth of the marking does not adversely affect the function of the part.

4.0 QUALITY REQUIREMENTS:

All finished parts are to be in accordance with the L-3 GCS Finished Material Workmanship Standards (L-3 GCS Part Number 1000-0100-01).



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5.0 ACCEPTABLE DEVIATIONS:

The following are acceptable deviations:

- 5.1 Marking may be built up outside the line of a character providing the character is legible.
- 5.2 Missing marking is not more than 10% of the character.
- 5.3 Lines of a number or letter may be broken (or thin over a portion of the character).

6.0 UNACCEPTABLE DEVIATIONS:

The following are unacceptable deviations and criteria for rejection:

- 6.1 Missing or illegible characters in the markings.
- 6.2 Multiple images.
- 6.3 Open areas of characters are filled and are not legible, or are likely to be confused with another number or letter.
- 6.4 Lines forming a character are missing, broken or smeared to the extent that the character is not legible or is likely to be confused with another character.
- 6.5 The depth of the marking adversely affects the function of the part.