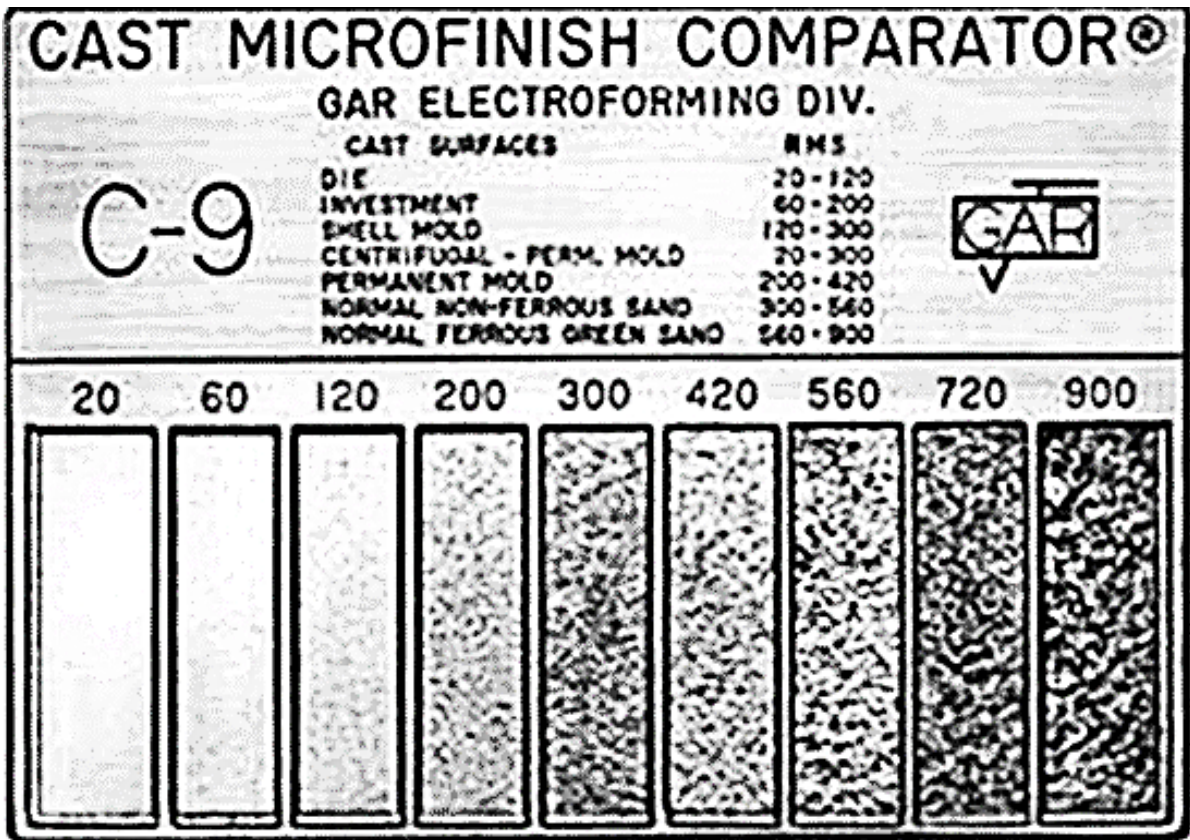


Ball Clamp Inclusion guide

The purpose of this procedure is to give guidance on acceptability criteria and critical areas of the ball clamp that must be defect free of inclusions. The overall workmanship of the Ball clamp needs to have a consistent casting surface per the applicable casting process per a Cast Microfinish Comparator C-9. Abnormalities otherwise known as cast inclusions are concerning when on product integrity especially when it comes to the critical surface **highlighted in red this area can not have any inclusions greater than what the range for that process it was made from on the Cast Microfinish Comparator.**

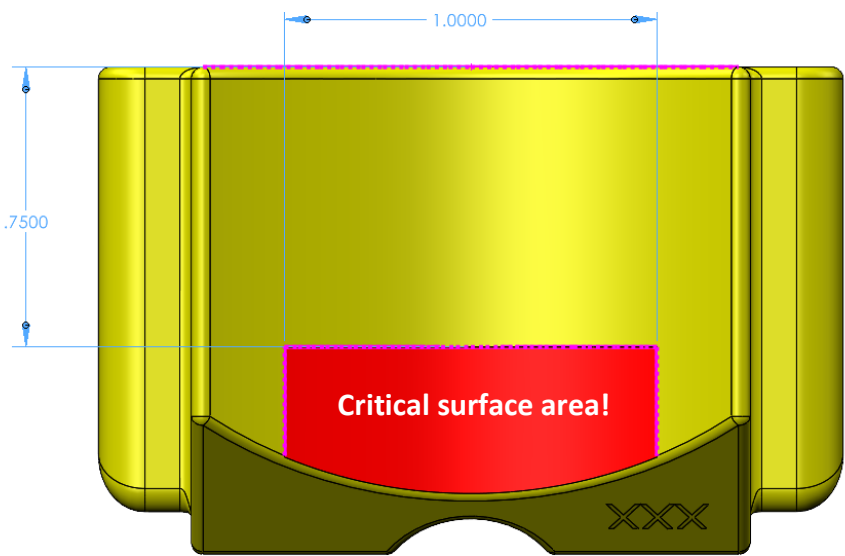
Example:

- Investment Casting 60-200 Microfinish.
- Shell Mold 120 -300 Microfinish
- Normal Non-Ferrous Sand 300- 560 Microfinish.



Below in red is the critical surface from a safety standpoint. This area should be treated as critical and be free from defects. The overall surface finish of the part and defects in other areas can be handled differently depending on amount/severity of discontinuities. When in doubt, it is better to red tag questionable product quality to put aside.

A quick reference from the top @ .75 or aka ¾" of an inch that particular area is where the hitch ball makes contact to keep the hitch ball from pull out.



Example of nonconforming ball clamp