Foreword (cont.)

1.7 Verification of Dimensions

The actual measurements provided in this document (i.e., specific part mounting and solder fillet dimensions and determination of percentages) are not required except for referee purposes. All dimensions in this standard are expressed in SI (System International) units (with Imperial English equivalent dimensions provided in brackets).

1.8 Magnification Aids and Lighting

For visual inspection, some individual specifications may call for magnification aids for examining printed board assemblies.

The tolerance for magnification aids is ± 15% of the selected magnification power. Magnification aids, if used for inspection need to be appropriate with the item being inspected. Lighting needs to be adequate for the magnification aids used. Unless magnification requirements are otherwise specified by contractual documentation, the magnifications in Table 1.2 and Table 1-3 are determined by the item being inspected.

Referee conditions are used to verify product rejected at the inspection magnification power. For assemblies with mixed land widths, the greater magnification may be used for the entire assembly.

Table 1-2   Inspection Magnification (Land Width)

Land Widths or Land Diameters[1]	Magnification Power	
	Inspection Range	Maximum Referee
>1.0 mm [0.0394 in]	1.5X to 3X	4X
>0.5 to ≤1.0 mm [0.0197 to 0.0394 in]	3X to 7.5X	10X
≥0.25 to ≤0.5 mm [0.00984 to 0.0197 in]	7.5X to 10X	20X
<0.25 mm [0.00984 in]	20X	40X

Note 1: A portion of a conductive pattern used for the connection and/or attachment of components.

Table 1-3   Magnification Aid Applications - Other

Cleanliness (cleaning processes)	Magnification not required, see Note 1
Cleanliness (no-clean processes per 10.4.4)	Note 1
Coating/Encapsulation	Notes 1, 2
Other (Component and wire damage, etc.)	Note 1

Note 1: Visual inspection may require the use of magnification, e.g., when fine pitch or high density assemblies are present, magnification may be needed to determine if contamination affects form, fit or function.
Note 2: If magnification is used it is limited to 4X maximum.

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