



*Emsig/US Button inspects our button products to a standard of Mil Spec 105D.  
(see below chart)*

*Finished buttons are inspected on moving conveyer belts. Human operators visually inspect 100% of the button and remove any buttons not meeting the standard.*

*Any and all defects are recoded and directed back thru the plant to all departments responsible for the defect, and to the plant manager. The problem is reviewed with the department supervisor to determine route cause. An action plan to correct problem is implemented.*

*Each department in the process also has quality standards that are followed and monitored.*

*We also track every lot we produce and record in a data file, starting quantity, finished quantity and scrap.*

*Lean manufacturing quarterly Audits also incorporate quality and standards have been established which monitor each department.*

## **MIL SPEC 105D**

### **Lot Size: 20 gross – 243 gross**

Test Sample Size : 300 pieces

Non Functional Allowed : 0

Cosmetic Defects Allowed: 5 or Less

### **Lot Size: 244 gross – 1,042 gross**

Sample Size: 500 pieces

Non Functional Allowed : 0

Cosmetic Defects Allowed: 7 or Less

### **Lot Size: 1,043 gross – 3,500 gross**

Sample Size: 800 pieces

Non Functional Allowed : 0

Cosmetic Defects Allowed: 10 or Less