


Created by:	Ed Carrara written 6-17	 <b>Surtech Industries</b> <small>PROVIDES THE FINISHING TOUCH</small>	Long Line, Short Line and Batch Standards	Page 1 of 1 Created: June 16, 2017
Reviewed by:	Terry Spisak reviewed 6-17			
Approved by:	Ed Carrara approved 6-17			
<b>Cosmetic Inspection &amp; Packaging Criteria for All Substrates Aluminum and Steel</b>				
<b>INSPECTION METHOD</b>		<b>SURFACE CLASS AND INSPECTION LOCATION</b>		
<b>Part Photograph</b>	<b>How to use spacer</b>	<b>Stampings</b>	<b>Weldments</b>	<b>Tubular</b>
Part Type Per Project	Inspection parameters are against a 3" circle template.	<b>Typical</b>	<b>Typical</b>	<b>Typical</b>
Surface of all powder coated parts identified by class A, B, or C	Distance	24 inches from the surface of the part being viewed		
	Time	10 second inspection		
	Light	Normal light, White Fluorescent or natural light		
	Viewing Angle	Approx. 45 degrees		
<b>Cosmetic Inspection Options</b>		Note: if after a 10 sec review / inspection no defect is found the part is deemed acceptable		
		<b>"A" Level Inspection</b>	<b>"B" Level Inspection</b>	<b>"C" Level Inspection</b>
<b>CRITERIAS OF ACCEPTANCE/REJECTION</b>		CUSTOMER SELECT <input type="checkbox"/>	CUSTOMER SELECT <input type="checkbox"/>	CUSTOMER SELECT <input type="checkbox"/>
<b>Coating Chip</b>		<b>Not permitted</b>	<b>Acceptable if:</b>	<b>Acceptable</b>
Chip - Area of coating that has been knocked of or chipped off.		None	Inside surface is to be machined in further processing	Chips will not be touched up
<b>Dirt and Positives</b>		<b>Acceptable if:</b>	<b>Acceptable if:</b>	<b>Acceptable</b>
Dirt - Foreign material in the finish Voids - in the coating		Maximum 6 of .03" dia. Viewing distance is 24" for 10 sec	Maximum 10 of .03" dia. Viewing distance is 24" for 10 sec.	Dirt and small inclusions are permitted. Parts will not be rejected
<b>Hook Mark</b>		<b>Not permitted</b>	<b>Acceptable if:</b>	<b>Acceptable</b>
Hook Mark		None	Inside surface is to be machined in further processing	Hook marks will NOT be touched up
<b>Light Coverage or missing coating</b>		<b>Not permitted</b>	<b>Acceptable if:</b>	<b>Acceptable</b>
Light / Insufficient Coverage - Bleed through of previous color or base coat		No touch up permitted, full and even coverage	Touch up permitted on inside surfaces and surfaces that will be machined later	Touch up permitted on all surfaces
<b>Overspray Condition</b>		<b>Not permitted</b>	<b>Acceptable if:</b>	<b>Acceptable</b>
Overspray - Unintentional settling of paint particles on a part		None	Overspray is on an inside surface that will be machined later	Full coverage no base metal showing. Mil marks will not be removed
<b>Sag, Run, Heavy Powder Build</b>		<b>Not permitted</b>	<b>Acceptable if:</b>	<b>Acceptable</b>
Sag / Run - Heavy build up of a surface finish material		None	Edge build is permitted	Any
<b>Scratches / Scuffing</b>		<b>Acceptable if:</b>	<b>Acceptable if:</b>	<b>Acceptable</b>
Scratch - A fine mark less than .30" in width on the surface material.		.30 scratch and not exposing the base metal	.30 scratch and not exposing the base metal	Scuffs and scratches permitted
<b>Contamination</b>		<b>Not permitted</b>	<b>Acceptable if:</b>	<b>Acceptable</b>
Crater defect, water mark, outgassing, color cross contamination		None	Contamination is on an inside surface that will be enclosed	Minor contamination is permitted
<b>Mil Thickness and Gloss Reading</b>		<b>Acceptable if:</b>	<b>Acceptable if:</b>	<b>Acceptable</b>
Mil Thickness to be 2-4 mils nominal over the entire surface of the part Gloss readings min 80		2-6 mils @80 gloss min. Unless otherwise stated	2-6 mils @80 gloss min. Unless otherwise stated	Full coverage
<b>Packaging Options</b>		<b>"A" Level Packaging</b>	<b>"B" Level Packaging</b>	<b>"C" Level Packaging</b>
		CUSTOMER SELECT <input type="checkbox"/>	CUSTOMER SELECT <input type="checkbox"/>	CUSTOMER SELECT <input type="checkbox"/>
<b>Wrapping Material Used</b>		<b>Level A</b>	<b>Level B</b>	<b>Level C</b>
Type of material used		Low adhesive poly film Foam / Bubble Wrap	Paper / Foam	Paper Only
<b>Boxing</b>		<b>Level A</b>	<b>Level B</b>	<b>Level C</b>
Type of outer containment of the product		New unused box	Return in original shipper box, if usable and in good condition	No Box
<b>Skid</b>		<b>Level A</b>	<b>Level B</b>	<b>Level C</b>
Type and Condition of Skid		New skid, no overhang of product	Used Skid, some overhang permitted	Return on supplied skid form customer
<b>Stretch Wrap</b>		<b>Level A</b>	<b>Level B</b>	<b>Level C</b>
Shrink warp		Yes	Yes	Yes
		<b>Level A</b>	<b>Level B</b>	<b>Level C</b>
Banding to secure material to skid		Yes	Yes	Yes