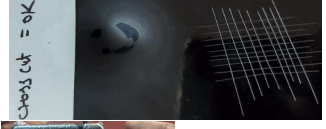


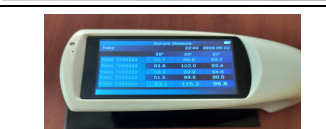
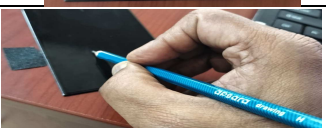
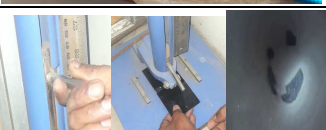






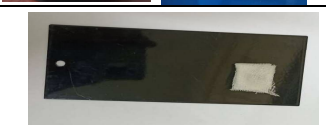

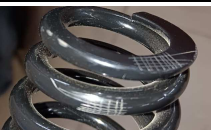



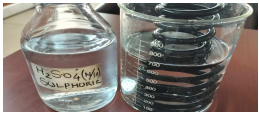




PART NAME	SPRING REAR SHOCKER	DISPOSITION ACCEPTED
MODEL	K1 RSA	
VENDOR / CUSTOMER	M/S-BTL	
LOT.QTY. / SAMPLE LOT	INITIAL SAMPLES (QTY- 5 NOS)	
REPORT DATE	23.10.23 (Coating date -05.10.23 & testing started after 24 hrs curing)	
BAJAJ AUTO, STANDARD	SURFACE TREATMENT AS PER ABS00012	

S.NO.	PARAMETERS	SPECIFICATION	OBSERVATIONS	Tested Part
1	APPEARANCE	SPEC. : NO VISUAL DEFECTS, (scratches, blisters, discoloration , uncoverage, etc.)	Satisfactory From 50 ~ 70 Cm distance (Lux value >1000) OK	<p>4 Surface Finish: The Powder Coated Surface of the Component shall have Smooth Finish and it shall be Free from Scratches, Blisters, Discoloration, Un-coverage or any other Visible Surface Defect when observed under light of intensity 1000 lux and from distance of 30-70 cm.</p> 
2	PAINT ADHESION	Make lattice pattern in the film at 2mm spacing 6 cuts. Apply Permacel tape and pull out tape. 100/100 mm² (no paint peel off) (3B or Better)	Passes	
3	PAINT THICKNESS	powder coating - 50µ - 200µ	90, 98 , 102 µ (master setting done on 120µ foil)	
4	COLOUR / SHADE	as per approved shade panel	Matching with master panel	
5	SPECULAR GLOSS ON PANEL	Multi angle Specular Gloss meter at 20 deg. for Gloss>70 and at 60 deg for gloss < 70. Test as per ASTM D-523 -2014 (spec >72% @ 20° A)	83 unit @20°	
6	PAINT HARDNESS	> H grade pencil (no scratch on test surface)	Passes	
7	IMPACT RESISTANCE ON PANEL	no crack or flaking, height -62 cm & wt. - 2.25 kg@R.T. (0.8 ~ 1 mm thick panel)	Passes (No chipoff during spring to spring impact)	
8	FLEXIBILITY TEST ON PANEL	no crack or flaking - Use 0.5 to 0.8 mm thick panels, bend at 180 deg. on conical mandrel (6.25 to 38.1 mm). Observe at 10X magnification.	Passes (checked at 10x magnification)	
9	HUMIDITY RESISTANCE TEST	95 to 100%RH at 42 to 48 deg C. Use distilled / DM water. 168 HRS. min (no blisters,flaking,wrinkles,rust,excessive change in gloss etc.) Sample to be examined after 1/2 hr.	Doing water fog test (keeping 2 ltr water in drum keeping near oven in close drum, it creates >90% humidity inside the drum, passes 300 hrs , test continue)	
10	WATER IMMERSION TEST	40 ± °C X 48 HRS MIN.(no blisters, flaking, cracks,wrinkles,rustexcessive changes in colour or softening of coating) Examine the sample after 30 min.	Passes	
11	CORROSION RESISTANCE	SALT SPRAY TEST - 700 HRS min. (no corrosive products,blisters- extending 3 mm from the cut on each side) (the X-cut shall be 3mm max.)	500 Hrs OK (test continue)	
12	GASOHOL RESISTANCE TEST	no blisters,cracks or flaking or excessive changes in gloss etc. DIP-2 HRS.)	Passes	
13	OIL RESISTANCE TEST	No staining, dulling, peeling, blistering, softening or discoloration . 50C temp. for 2 hrs. Wipe and examine the sample after 30 min.	Passes (checked at lab oven)	
14	XYLENE RESISTANCE	no excessive flaws,decreased gloss or colour gauze.(rubbing by 08 times)	Passes	
15	XENON ARC WEATHERING TEST	Min 1200 Hrs. No flaking, chalking, peeling etc & Gloss Loss ≤ 20%.	N.A.	N.A

16	HEAT RESISTANCE TEST	* No blistering or cracking after two cycle (250°c x 30 mints then quench in water)	passes 3 cycles , no adhesion failure	
	THERMAL SHOCK RESISTANCE	* No cracking & flaking after 03 cycles (heating at 120°c & immediate transfer in deep cooling <5°c in fridger)	passes 3 cycles , no adhesion failure	
17	BRAKE FLUID RESISTANCE	Immerse it in DOT4 grade Break fluid for 2.5 h at 60° C after that kept at ambient temp. for 1h . (3B or better)	Passes (checked at lab oven)	
18	WATER RUB TEST	No color staining on cloth after 20 rubs (Wet the AATCC Crock meter White cloth with tap water and rub it manualy)	* passes 250 rubs in wet * passes 250 rub in dry (check on parts)	
19	GASOLINE STANNING TEST	No staining shall be observed after 2 hrs of test.	Passes (no marks, check on panel)	
20	TABER ABRASION RESISTANCE	MAX Weight Loss Be 50 mg.	N.A.	N.A
21	QUV TEST	Min 200 Hrs. No change in Gloss and Shade	N.A.	N.A
22	ACID RESISTANCE TEST	No staining, dulling, peeling, blistering, softening or discolouration .	Passes	
23	ALKALI RESISTANCE TEST	No staining, dulling, peeling, blistering, softening or discolouration . (50°c x 12 Hrs)	Passes	

REMARKS:-

CHECKED BY - TARUN KUMAR  APPROVED BY - VISHAL RASTOGI 