

PART NAME - M/CYL BODY FINISHED- RE 012.7

PART NO - B2G0005240

Objective - To increase the awareness about acceptance and non acceptance level of powder coated parts.

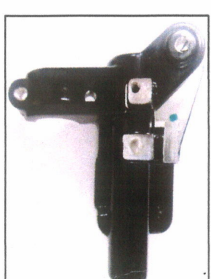
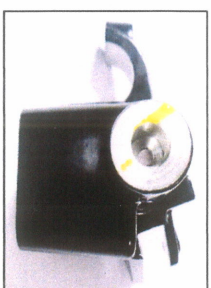
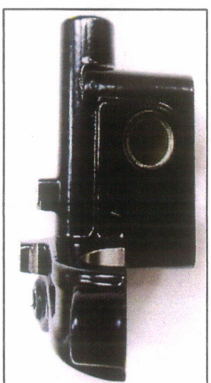
Purpose - To Fix the acceptance criteria for to take judgement and to avoid person to person different opinions.

Powder coating details - Pure polyester powder coated as per ABS00012 Colour- Black Finish- Saini.

Process Details - Pretreatment,Powder,powder coating, Baking

Note- Inspection standard will be revise as on when required.

VISUAL INSPECTION INSPECTION STANDARAD



Check All Defects as shown in Pictures (Highlighted Area's)

S.no.	Defect Phenomenon	Acceptance Criteria			Defective Pictures
		Zone A	Zone B	Zone C	
1	Powder coating Dust	1. Zone A - 03 to 04 dust particle with (0.2 - 0.3) shall be allowed. Note- Bunch of Dust particles not allowed.	2. Zone B - 4 to 5 dust particles with (0.2 to 0.5 dia) shall be allowed. Note- Bunch of Dust particles not allowed.	3. Zone C - 5 to 6 dust particle (0.2 to 0.5 dia) shall be allowed. Note- Bunch of Dust particles not allowed.	
2	Coating Uncover	Uncover not accepted at all.	Uncover not accepted at all.	Uncover not accepted at all.	
3	Bubble	Uncover not accepted at all.	Uncover not accepted at all.	Uncover not accepted at all.	
4	Coating Peel off	Peel off not accepted all over the part	Peel off not accepted all over the part	Peel off not accepted all over the part	
5	Pin Holes (Pre-treatment dot marks)	1. Zone A - 2 to 3 with 0.2 shall be allowed. Note- Bunch of pin holes not allowed.	2. Zone B - 3 to 4 (0.2 dia) shall be allowed. Note- Bunch of pin holes not allowed.	3. Zone C - 5 to 6 (0.5 dia) shall be allowed. Note- Bunch of pin holes not allowed.	
6	Scratch mark	1. Zone A - free Scratch marks.	2. Zone B - small hair line scratch length 5 to 6 mm one allowed but more than 01 & Deep marks not allowed.	3. Zone C - small hair line scratch length 5 to 6 mm 02 allowed but more than 2 & Deep marks not allowed.	
7	Shade Variation	Shade variation to be checked as per Master Sample.			
8	Over Flow	Paint Over flow not allowed at all	Paint Over flow not allowed at all	Paint Over flow not allowed at all	
9	Blisters	Blisters not accepted all over the part	Blisters not accepted all over the part	Blisters not accepted all over the part	Defective part not available
10	Orange Peel	Not Acceptable	Acceptable when not noticable from 2 ft.	Acceptable when not noticable from 2 ft.	
11	Casting Dents	1. Zone A - 01 dent with (LXWXD)5X1X0 5mm shall be allowed.	1. Zone A - 1 to 2 dent with (LXWXD)5X1X0 5mm shall be allowed.	1. Zone A - 1 to 2 dent with (LXWXD)5X1X0 5mm shall be allowed.	
12	Batch code	Excessive DFT should not reduce legitivity of hatch code			

Remarks- Combination of Defects in Zone will not be acceptable.

Prepared By
(Engineer)

Reviewed By
(Section Incharge)

Approved By
(QA HOD)