










VISUAL APPEARANCE STANDARD

PART NAME	Front fork assembly	PART PHOTO (INSPECTION AREA)			SUPPLIER NAME : SUPPLIER CODE :	M/s Anant Enterprises 100001	ETL	
VISUAL INSPECTION STANDARD NO.	Appearance Std.				APPROVED BY		OPERATIONAL HEAD	
DATE					VERIFIED BY		DIVISION HEAD	
DURATION OF DEVIATION	PLS FILL IF DEVIATION REQUIRED	A SIDE UPPER BRACKET	B SIDE UPPER BRACKET	A SIDE HANDLE HOLDER	PREPARED BY		DEPARTMENT HEAD	
PART NO.	F2PD02007B/ F2PD02107B/ F2PD02907B & F2FQ00507B			B SIDE HANDLE			TEAM LEADER	
MODEL	XF1C1 (HH)							
PART TYPE	Upper Bracket & Handle Holder							

Reference Standards :	Photo of defect
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Sr. No.	Type of defect as per SES STD	Inspection Area / View	Defect Size / Criteria as per SES STD	Density / Group Size (No of defect unit) Allowed	Distance Between Groups of Defect	Accepted Criteria	Evaluation Method	ETL Remark	Photo of defect
1	Concave Defects Le Basis material Scratch (Casting Scratch / Dent)	A Side	upto Size Ø0.15mm	No Limit	No Limit	•	Allowed		
			Size Ø0.2mm to Ø0.4 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.5mm to Ø0.7 mm	Must be a single defect unit	More than 30 mm	•			
		B Side	upto Size Ø0.2 mm	No Limit	No Limit	•			
			Size Ø0.2 mm to Ø0.6 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.5 mm to Ø1.0 mm	Must be a single defect unit	More than 30 mm	•			
2	Concave Defects Le Bruise after painting (Dent & Damage after Painting)	A Side	upto Size Ø0.1mm	No Limit	No Limit	•	Allowed		
			Size Ø0.2mm to Ø0.4 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.2mm to Ø0.5 mm	Must be a single defect unit	More than 30 mm	•			
		B Side	upto Size Ø0.2 mm	No Limit	No Limit	•			
			Size Ø0.2 mm to Ø0.5 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.5 mm to Ø2.0 mm	Must be a single defect unit	More than 30 mm	•			
3	Concave Defects Le Pin Hole/ Eye hole	A Side	upto Size Ø0.1mm	No Limit	No Limit	•	Allowed		
			Size Ø0.2mm to Ø0.4 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.5mm to Ø0.8 mm	Must be a single defect unit	More than 30 mm	•			
		B Side	upto Size Ø0.2 mm	No Limit	No Limit	•			
			Size Ø0.2 mm to Ø0.5 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.5 mm to Ø2.0 mm	Must be a single defect unit	More than 30 mm	•			
4	Concave Defects Le Shot Peel / shrinkage	A Side	upto Size Ø0.1mm	No Limit	No Limit	•	Allowed		
			Size Ø0.1mm to Ø0.4 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.5mm to Ø0.8 mm	Must be a single defect unit	More than 30 mm	•			
		B Side	upto Size Ø0.2 mm	No Limit	No Limit	•			
			Size Ø0.2 mm to Ø0.6 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.5 mm to Ø2.0 mm	Must be a single defect unit	More than 30 mm	•			
5	Same color/ Convex : Dust Particle (Foreign matter contamination) Same color with P/C	A Side	upto Size Ø0.1mm	No Limit	No Limit	•	Allowed		
			Size Ø0.2mm to Ø0.4 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.3mm to Ø0.6 mm	Must be a single defect unit	More than 30 mm	•			
		B Side	upto Size Ø0.2 mm	No Limit	No Limit	•			
			Size Ø0.2 mm to Ø0.6 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.5 mm to Ø1.0 mm	Must be a single defect unit	More than 30 mm	•			
6	Different color Convex : Dust Particle (Foreign matter contamination) & Bubbles	A Side	upto Size Ø0.2mm	No Limit	No Limit	•	Allowed		
			Size Ø0.2mm to Ø0.4 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.3 mm to Ø0.5 mm	Must be a single defect unit	More than 30 mm	•			
		B Side	upto Size Ø0.2 mm	No Limit	No Limit	•			
			Size Ø0.2 mm to Ø0.6 mm	Less than 5 Units in dia. 20 mm Range Less than 3 units in dia. 10 mm Range	More than 30 mm	•			
			Size Ø0.5 mm to Ø1.0 mm	Must be a single defect unit	More than 30 mm	•			
7	Hair convex & concave Defect Le Basis material Scratch (Casting line mark).	A side	Length upto 3 mm & Width up to 0.3mm	Must be a single defect unit	More than 30 mm	—	Allowed		
		B side	Length upto 7 mm & Width up to 0.5 mm	Must be a single defect unit	More than 30 mm	—			
8	Hair convex & concave Defect Le Hair Line Dust/ Flow lines /Abrasion on surface .	A side	Length upto 5 mm & Width up to 0.2 mm	Must be a single defect unit	More than 30 mm	—	Allowed		
		B side	Length upto 7 mm & Width up to 0.3 mm	Must be a single defect unit	More than 30 mm	—			
9	Flow Painting stay on the part edge	A side	Length upto 1 mm & Width up to 0.4 mm	Must be a single defect unit	—	—	Allowed		
		B side	Length upto 2 mm & Width up to 0.4 mm	Must be a single defect unit	More than 30 mm	—			
10	Gloss	A side	Must be evenly Good	—	—	—	Allowed		

		B side	Must Be Even	--	--			
11	Orange peel	A side	Must not be easily Visible	--	--	Allowed		
		B side	Must not be Obvious	--	--			
12	Color	A side	Must Be No Difference	--	--	Allowed		
		B side	Must Be No obvious Difference	--	--			
13	Inspection shall be conducted visually under appropriate environment - Minimum illuminance :- More than 700 lux							
14	Inspection shall be conducted visually - Distance : Approx. 500 mm from target object							
15		No Painting/ Powder Coating Allowed on this marked zone.						

SES Requirement :- Reference by : SES D 2214 – Buffing for aluminum alloy components - Buffing Operation

16	Parting line on casting	A & B side	No parting line on accessible area where Buffing are possible					
17	Waviness mark after Buffing e.g. Straight Line on surface, Round line mismatch	A side	No Remarkable (Noticeable) waviness Mark on accessible area where Buffing are possible					
		B side	No Remarkable (Noticeable) waviness Mark on accessible area where Buffing are possible					
18	Deep Buffing Mark after Buffing	A side	No Remarkable (Noticeable) Deep Buffing Mark on accessible area where Buffing are possible					
		B side	No Remarkable (Noticeable) Deep Buffing Mark on accessible area where Buffing are possible					
19	Drag Mark after buffing	A side	No Remarkable (Noticeable) Drag mark on accessible area where Buffing are possible					
		B side	No Remarkable (Noticeable) Drag mark on accessible area where Buffing are possible					
20	Casting Rough surface	A side	No Remarkable (Noticeable) Rough surface on accessible area where Buffing are possible					
		B side	No Remarkable (Noticeable) Rough surface on accessible area where Buffing are possible					
21	Catching Mark on caster surface	A & B side	No Remarkable (Noticeable) Catching Mark on caster on accessible area					
21	Catching Mark on caster surface	A & B side	No Remarkable (Noticeable) Catching Mark on caster on accessible area					