



Voorbehandelen
Natlakken
Poedercoaten
Screenen

QUALITY 1:

Application:

Very luxurious consumer articles, medical equipment.

General:

The quality of the treated products is inspected for the points below. Inspections can only be carried out on annealed products.

Covering capacity:

The products' visible sides have to be fully covered. Inspection is carried out when products are collected.

Esthetical inspection:

Inspections take place in an adequately lit workplace (e.g. 500 Lux under a 90° angle).

Inspection distance 0.50 metres

There are no or merely very slight anomalies allowed on the surface which have been caused by;

Mechanical processing;

*Grinding and scouring scratches,
Sawdust splinters.*

Extrusion techniques;

*Extrusion stripes,
Press residue.*

Joining techniques;

*Weld spots,
Seams.*

Application of coating;

*Dust pockets,
Orange structure,
Spray fog,
Pitting.*

This quality can be achieved with wet paint, only in exceptional cases is powder coating suited for this.

Frequency of controls during production:

All.



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Structure:

The visible sides of products should, when using a structure coating, meet the customer-approved model.

Coating thickness: (ISO 2360 (1982))

When carrying out measurements, the rim of the measuring post has to be distanced at least 3 mm from the product's angle or framework.

Universally applicable coating thickness requirements:

Inside application in wet paint: minimum 25 µm;

Inside application in powder form: minimum 40 µm;

Frequency of controls during production:

In a daily production the first sprayed products or the first charge undergoes inspection, subsequently in a continuous production line 5 products or 1 charge an hour and in a batch-type installation 5 products of each new batch.

Smaller products with a sample size of 10% distributed amongst the entire assignment undergo inspection.

Gloss factor: (ISO 2813 (1978))

Measurements are carried out with a reflectometer that bears a 60°-measurement angle.

The gloss factor is expressed in % gloss.

Admissible tolerance:

gloss factor 0 - 30 %	+/- 5 % gloss
gloss factor 31 - 70 %	+/- 7 % gloss
gloss factor 71 -100 %	+/-10 % gloss

Because gloss factor in textured paints *cannot* be measured, it is inspected visually by comparing it with an approved sample.

If the optical plane is not suited for carrying out measurements, the gloss factor is then compared visually with an approved sample.

Frequency of controls during production:

In a daily production the first products undergo inspection, after that one measurement per hour.

The first charge is inspected in smaller assignments; subsequently the rest of the assignment is visually compared with the first charge.



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Adhesion: (ISO 2409 (1992))

Adhesion is thus inspected that no damage is created on the visible side.

A 1mm incision breakpoint is observed for a coating thickness up to 60 microns, and 2mm for a higher coating thickness.

Potential damage to adhesion can be tested by sticking a tape on the coated surface, rub it well and leave as is for 60 seconds, then pull the tape off in one tug. No peeling must take place.

Frequency of controls during production:

In a daily production the first charge undergoes inspection, then 1 product at every 4-hour interval.

In smaller assignments the first product undergoes inspection.

Curing:

The monitoring liquid for testing curing depends on the type of coating and is carried out in compliance with the instructions of the powder or lacquer manufacturer.

The non-visible side undergoes inspection.

Frequency of controls during production:

In a daily production the first charge undergoes inspection, then 1 product at every 4-hour interval.

In smaller assignments one product of each new batch undergoes inspection.

Colour:

Colour has to be consistent and render good covering capacity.

The anomalies can be specified in Delta-E values, in compliance with the specifications provided by the powder or lacquer supplier.

If so desired, the supplier can also supply measurement reports with the delivered raw material.

Visual inspection is carried out during production.

Anomalous requirements:

If anomalous requirements are agreed to with a principal, these requirements have to be observed rather than the abovementioned norms.



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Sample size to be carried out by the principal:

Order size	Sample size	Admissible rejects
1 - 10	all	0
11 - 200	10	1
201 - 300	15	1
301 - 500	20	2
501 - 800	30	3
801 - 1300	40	3
1301 - 3200	55	4
3201 - 8000	75	6