

Subject: Surface quality classification of painted profiles

| | Surface quality class 4 | Surface quality class 5 |
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| Surface requirements | <p>No obtrusive faults or colour deviation are permitted when viewing the profile's visible surface from the inspection distance.</p> <p>No requirements, not used for visible surfaces.</p> | <p>No obtrusive faults or colour deviation are permitted when viewing the profile's visible surface from the inspection distance.</p> <p>No requirements, not used for visible surfaces.</p> |
| Debris | <p>Small individual pieces: maximum three pieces per metre.</p> <p>Any debris larger than 1.5 mm is cause for scrapping.</p> | <p>Small individual pieces: maximum six pieces per metre.</p> <p>Any debris larger than 1.5 mm is cause for scrapping.</p> |
| Orange peel effect | Permissible as a light appearance defect. | Permissible as a light appearance defect. |
| Common applications | Decorative moulding, furniture, lighting, system profiles, building systems, windows, doors, ladders, electrical components, etc. | Building systems, fence profiles, etc. |
| Quality assurance | <p>GSB quality control (film thickness, gloss, paint adhesion).</p> <p>Visual inspection.</p> | <p>GSB quality control (film thickness, gloss, paint adhesion).</p> <p>Visual inspection.</p> |
| Inspection distance | <p>1–3 m</p> <p>During packaging, the inspection distance is approximately one metre at the end of the profile, extending to approximately three metres towards the middle of the profile.</p> | 3 m |
| Inspection time | 5 s | 3 s |
| Packaging | Apply protection between layers or follow separate packaging instructions. | Apply protection between layers or follow separate packaging instructions. |

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| Author Quality department | Date 4/2017 | Updated by Quality department | Date 9/2017 | Approved by PVe | Version 2.0 |
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