

Subject: Surface quality classification of painted profiles

	Surface quality class 4	Surface quality class 5
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 for non-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 for non-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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