

Visibility to the customer should be considered as a key inspection criterion.

Defects which are invisible at an angle of $\pm 30^\circ$ are acceptable.

	Zone A	Zone B	Zone C	Missing or mechanically damaged funct.parts
Abrasions	Independently soft abrasion of any size – without sensible depth Are accepted max 2 abrasion < 50 x 20 mm soft if not crossing each other in different direction (nor printed text nor pressed logo affected)	Soft abrasion of any size if not crossed each other with different direction	any allowed if not affected printed information or label Damage to bare metal is allowed if does not occur signs of corrosion - rust or colored spots Damage done on a purpose like knife cut or repetative scratches made by abrasive object is not allowed	Not allowed. These will result in complete component replacement
Scratches	Independently soft scratch without sensible depth of any size; Are accepted max 2 scratches < 50 mm, distance min 50mm Scratch with sensible depth max 1 scratch < 10 mm (nor printed text nor pressed logo affected) Logo: soft hair scratch on <5mm	Independently soft scratch without sensible depth of any size Are accepted max 2 abrasions < 50 mm, any distance Deep scratch max 1 scratch < 10 mm is accepted		
Multiple Scratches (series of scratches of a same direction and relative size)	max 1 series without sensible depth < 50 mm (nor printed text nor pressed logo affected)	Accepted defect max 1 series without sensible depth per surface of any size		
Dents, sinks	Defects < 1 mm is not considered as defect Defects max 5 < 3 mm in diameter (without sharp edges) no printed text or pressed logo affected	Defects < 1 mm is not considered as Defect; Are accepted: defects max 3 < 5 mm in diameter; Are accepted defects max 5 < 4 mm in diameter without sharp edges	< 2 mm in depth without sharp edges is not considered as a defect	
Corrosion / Rust	Not Allowed		Not Allowed	
Dark spots / Light spots	Defects < 15 mm in diameter is not considered as defect – max 10 , Are accepted: defects max 2 < 50 mm; Defects max 4 < 20mm, Defect max 1<100mm and must not be in contrast with surface, (does not apply on cleanable dark spots) (nor printed text nor pressed logo affected)	Soft dark spots are allowed (does not apply on cleanable dark spots)		
Re-spraying defects overpainted dust, craters, pinholes etc.	Defects < 2 mm in diameter are not considered as defect Are accepted defects max 3 < 4mm Distance 20 mm, No sharp edges (no printed text nor pressed logo affected)	Defects < 3 mm in diameter are not considered as defect; Are accepted defects max 5 < 5mm, Distance 20 mm, No sharp edges	Allowed	
Re-spraying defects spray maps, orange skin etc.	Acceptable defect max 1 < 100 x 20 mm (constant structured surface finish is not considered as defect)	Acceptable Defect max 2 of any size per surface		
Dirt	Not allowed except loose airborne dust particles			
Remark	If you are not sure if unit is PASS or FAIL according to aforementioned criterias, consider unit as PASS.			

Produkt	Instrukcja powiązana	Autor	Sprawdził/Zatwierdził	Data
SKY	N/A	Paweł Koperda Inżynier Jakości	Paweł Dera Inżynier produktu	18.02.2022