

Quality management - description of levels

Date: 22-11-2012	Q1	Q2	Q3
Int: OC	<i>GG - Highest quality</i>	<i>GG - General/Industrial product</i>	<i>GG - Lowest quality</i>
DESCRIPTION	Must not contain flaws	May contain flaws	Flaws will occur
Surfaces			
<i>Hairline scratches</i>	Max. 1 scratch <= 50 mm	Max. 2 scratches <= 50 mm, distance > 400 mm	Max. 3 scratches <= 70 mm
<i>Light scratches, feelable with a fingernail</i>	None	Max. 2 scratches <= 3 mm	Max. 3 scratches <= 5 mm
<i>Blistering and point defects</i>	None	Max. 2 <= 0.5 mm / 0.3 m ²	Max 4 <= 0.5 mm / 0.3 m ²
Edges			
<i>Profile type</i>	BFS, BC, MFS, MC	BFS, BC, MFS, MC, GK	GK
<i>Small points</i>	Ground edge without points	Very small points accepted	Small points accepted
<i>Grinding</i>	Evenly ground everywhere without cutter marks	Small cutter marks may occur	Ground so the item can be tempered
<i>Profile</i>	Profile is positioned <u>100%</u> in the centre of the material	Profile is centred on the material	
<i>Finish</i>	Polished edges must be completely polished	Polished edges may be slightly matt	
		(GK) Ground edge without sharp edges	
Silk screen printing			
<i>Roller tracks on the edge</i>	Must not be visible	May appear	May appear
<i>Print on surface</i>	No colour imperfections	Small imperfections may occur	Small imperfections may occur
<i>Pinholes</i>	Must not occur	May be visible < 1 m distance	May be visible > 1 m distance
<i>Shadows</i>	Not allowed	Small shadows may occur	Small shadows may occur
Tempering			
<i>Tempering standard</i>	EN 12150	EN 12150	EN 12150
<i>Oiled surfaces, stripes, flecks</i>	Must not occur	May occur to a small extent	May occur to a small extent
Quality control	Strict	Normal	Reduced