

HED[®] Specification

Title: Supplier Paint Aesthetic Specification

Number: PS225001

Approved By: Tom Szewczyk

1.0 Purpose

- 1.1 To outline the minimum aesthetic criteria for supplier painted products.

2.0 Scope

- 2.1 All powder coated aluminum enclosures endplates, or brackets
2.2 Does not apply to internal module applications and non-exposed surfaces

3.0 Quality Level of Defect/By Area

- 3.1 Dirt
- Allowed as long as paint adhesion is not affected.
- 3.2 Craters
- Allowed if not through to substrate or bare surface.
- 3.3 Sags and Runs
- Very slight sag that is difficult to notice is allowed, only on face surfaces and not on gasket mating surfaces.
- 3.4 Substrate Scratches (Scratches to substrate only. Paint/Coating over substrate scratches.)
- Allowed if not visible when viewed for 3 seconds at a nominal distance of 24 inches.
 - Allowed as long as paint adhesion and function of the part is not affected.
- 3.5 Overspray/Dry spray
- Allowed
- 3.6 Paint Coverage (Thickness)
- Full coverage required on all exterior surfaces.
- 3.7 Paint Build-up on Tapped Holes (from plugs)
- Allowed up to a maximum height of .007" from dry spray.
- 3.8 Orange Peel
- Light orange peel is allowed (Orange peel is allowed as long as it does not affect functioning of gasket mating surfaces).
- 3.9 Solvent Popping
- Allowed if light pinhole-type solvent pops which are visible only when viewed at an angle. No clusters, only small random pops not visible when viewed for 3 seconds at a nominal distance of 24 inches.
 - Allowed if not through to substrate or bare surface.
- 3.10 Scratches to Painted/Coated Surface (No substrate scratches or defects)
- Allowed if not through to substrate or bare surface and if not visible when viewed for 3 seconds at a nominal distance of 24 inches.
 - Allowed as long as paint adhesion and functioning of the part is not affected.
- 3.11 Substrate/Surface Discontinuities
- Non-uniform surface appearances such as streaks, die lines, stains, carbon marks, or discoloration are allowed if not visible when viewed for 3 seconds at a nominal distance of 24 inches.
 - Allowed as long as paint adhesion and functioning of the part is not affected.

4.0 Revision History

Rev.	Date	Sections Affected / Description
A	10/04/07	Initial Release
B	12/15/08	Reviewed and approved by PSV Manager. Corrected footer and header, and added Revision History. No changes made to document contents.
C	07/31/12	Changed scope from "All painted metal enclosures or brackets" to "All powder coated aluminum enclosures endplates, or brackets" and "Does not apply to internal module applications and non-exposed surfaces". Added "Paint Build-up on Tapped Holes (from plugs) – Allowed up to a maximum height of .007" from dry spray."