

**Cosmetic Acceptance Criteria Chart for Mechanical Components**

Defect	Visibility Class	Max Defect Size Allowed	Max Number Allowed per 100 sq. in.
<b>APPLICABLE TO ALL PARTS</b> <i>(Includes Stainless Steel, flat form Aluminum, etc.)</i>			
Burrs and Sharp Edges <i>(Note: Time saver NOT to be used on pre-plated parts)</i>	N/A	Defect Not Allowed	
Fractures, Splits, Cracks	N/A	Defect Not Allowed	
Scuff, Abrasion, Mark (light) <i>(Note: Must not catch fingernail)</i>	A	None	0
	B	1.0"	4
	C	Acceptable	Any
Scratch (catches fingernail)	A	None	0
	B	.5"	2
	C	Acceptable	6
Bend Line (Edge Area)	A	None	0
	B	length of part	1 per surface
	C	Acceptable	Any
Gouge <i>(Note: Max depth 0.010")</i>	A	None	0
	B	None	0
	C	0.125" x 0.5"	2
Dent, Ding, Nick <i>(Note: No exposed metal. Max depth 0.010")</i>	A	None	0
	B	0.125" dia	1
	C	0.25" dia	2
<b>PRE-PLATED, PLATED, PAINTED &amp; POWDER COATED PARTS</b> <i>(Includes defects listed under "Applicable to All Parts")</i>			
Corrosion, Oxidation, Rust	N/A	Defect Not Allowed	
Blistering, Peeling, Flaking, Chipping	N/A	Defect Not Allowed	
Surface Delamination	N/A	Defect Not Allowed	
Runs <i>(Note: No pooling in corners)</i>	A	None	0
	B	.25"	2
	C	Acceptable	Any
Water Spots/Surface Contamination	A	None	0
	B	less than 1 in <sup>2</sup>	1
	C	Acceptable	Any
Non-Uniform Texture / Orange Peel	A	None	0
	B	less than 0.5 in <sup>2</sup>	1
	C	Acceptable	Any

**Surface Visibility Class Definitions:**

- A:** All primary appearance areas, as the customer views or interacts with the product part.
- B:** Areas that are visible only when special effort is made to see a sizable defect.
- C:** All areas that are not exposed once unit is assembled.

**\*View each surface no more than 10 seconds at a distance of 24"**

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Defect	Visibility Class	Max Defect Size Allowed	Max Number Allowed per 100 sq. in.
<b>NON-COATED PARTS, EXTRUSIONS &amp; CASTINGS</b> <i>(Includes defects listed under "Applicable to All Parts")</i>			
Corrosion, Oxidation, Rust	N/A	Defect Not Allowed	
Incomplete Fill/Cold Shot in Cast Metals	N/A	Defect Not Allowed	
Flash  <i>(Note: Must not exceed drawing tolerances)</i>	A	None	0
	B	Per drawing	Per drawing
	C	Per drawing	Per drawing
Ejector Pin Mark	A	None	0
	B	Per drawing	Per drawing
	C	Per drawing	Per drawing
<b>PLASTIC PARTS</b> <i>(Includes defects listed under "Applicable to All Parts")</i>			
Short Shots/Voids	N/A	Defect Not Allowed	
Surface Delamination	N/A	Defect Not Allowed	
Burns	N/A	Defect Not Allowed	
Flash  <i>(Note: Must not exceed drawing tolerances)</i>	A	None	0
	B	Per drawing	Per drawing
	C	Per drawing	Per drawing
Sinks	A	None	0
	B	.007"	4
	C	.015"	6
Specks/Bubbles	A	None	0
	B	less than 0.5 in <sup>2</sup>	1
	C	Acceptable	Any
Discoloration	A	None	0
	B	None	0
	C	Acceptable	Any
Non-Uniform Texture	A	None	0
	B	less than 0.5 in <sup>2</sup>	1
	C	Acceptable	Any
Gates	A	None	0
	B	Per drawing	Per drawing
	C	Per drawing	Per drawing
Ejector Pin Mark	A	None	0
	B	Per drawing	Per drawing
	C	Per drawing	Per drawing

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