

SPRAY PAINTING & PRINTING QUALIFICATION										
Part No 20103680			Part Description ASSY WASTE DOOR-CASTING				Supplier Hansin			
Date of Testing 31-May-2024			Tested By/Date Chu Libo 31-May-2024				Reviewed By/Date Lu Chuanhai 31-May-2024			
PAINT INFORMATION										
Base Coat E61AP5027-020P1			Manufacturer Code SHERWIN WILLIAMS				Type of Solvent Used/Manufacturer R07KP1039/SHERWIN WILLIAMS			
Top Coat Polane 8300 F63SP3805			Manufacturer Code SHERWIN WILLIAMS				Type of Solvent Used/Manufacturer R07KP1004/SHERWIN WILLIAMS			
PROCESS INFORMATION										
Spraying Pressure 喷射压力 1~2 Kg/cm ²		Spraying Distance 喷涂距离 15-25 cm		Paint/Thinner Ratio 油漆稀释剂比 Base Coat : 10:1 Top Coat : 6:4-5		Number of Spray 喷涂次数 Base Coat : 1 Top Coat : 2-3		Drying Temp (°C) 干燥温度(0°C) 50°C		Drying Time (Min) 干燥时间(Min) 60分钟
EVALUATION CRITERIA										
A		Visual Inspection (Paint & Print)								
Criteria 标准		Uniform Paint Coverage (no pin holes) 油漆覆盖均匀(无针孔)		No blistering and paint build up (edges & holes) 油漆覆盖均匀(无针孔)		No scratches & abrasion mark. 无划痕和磨损痕迹。		No smearing and bleeding 没有涂抹和流漆		No orange peel 没有橘子皮
Sample	1	OK		OK		OK		OK		OK
	2	OK		OK		OK		OK		OK
	3	OK		OK		OK		OK		OK
B		Physical Properties (Spray Paint)								
Criteria 标准		Film Thickness 膜厚度		Hardness Test 硬度试验		Adhesion 附着力		Abrasion Test 磨损试验		Alcohol Test 酒精测试
Method 方法		ASTM D1005, ASTM D1186, ASTM D1400, ASTM D4138		ASTM D3363 Method Using HB pencil.		ASTM D3359 Method B, 70 oz inch tape (3M 250)		>50 rubs per minute with load of 1.65kg using cotton cheesecloth		> 70 rubs per minute with load of 500g using cotton cheese cloth
Spec 规范		74 to 110 micron (1遍底, 3遍面漆)		HB		Scale 5B		No noticeable color change, some color on cloth		
Sample	1	80micron		OK(色板F)		OK		OK		OK
	2	80micron		OK(色板F)		OK		OK		OK
	3	80micron		OK(色板F)		OK		OK		OK
C		Color Variation & Gloss Level Inspection (Spray Paint)颜色变化和光泽度检查(喷漆)								
Criteria 标准		Visual Inspection for Color 颜色目视检查	Visual Inspection for Texture	Measurement L : 86.55 a : -0.59 b : -0.1 dE< 2				Gloss Level	Visual Inspection for printed graphics	
Method 方法		Compare with Limit Color Chip 与极限彩色芯片比较	Compare with limit standard 与限量标准比较	Color Spectro-photometer				60° Gloss Meter	Compare with Artwork and PMS chart	
Spec 规范		Within limit 在限制	Within limit 在限制	L	a	b	dE	20 to 30	Within limit 在限制	
Sample	1	OK	OK	85.67	-0.58	-0.03	0.88	25.00	N/A	
	2	OK	OK	86.37	-0.57	-0.08	0.18	24.03	N/A	
	3	OK	OK	85.72	-0.58	-0.04	0.83	25.15	N/A	
D		Color Variation & Physical Properties (Printed Graphics) 颜色变化及物理特性(印刷图形)								
Criteria 标准		Visual Inspection for Color 颜色目视检查	Uniform Paint Coverage (no pin holes) 油漆覆盖均匀(无针孔)		Correct positioning of Graphics 图形的正确定位			Adhesion 附着力		Alcohol Test 酒精测试
Method 方法		Compare with Limit Color Chip 与极限彩色芯片比较	Visual 视觉		Visual Template 视觉模板			ASTM D3359 Method B, 70 oz inch tape (3M 250) 方法B, 70盎司英寸胶带(3M 250)		> 20 rubs per minute with load of 500g using cotton cheese cloth 用奶酪棉布每分钟擦拭 > 20次, 重量为500g
Spec 规范		Within Limit 在限制	Within Limit 在限制		Within Limit 在限制			No peeling allowed 禁止剥皮		No noticable color change 没有明显的颜色变化
Sample	1	N/A	N/A		N/A			N/A		N/A
	2	N/A	N/A		N/A			N/A		N/A
	3	N/A	N/A		N/A			N/A		N/A
* Sample Size : Minimum 3 pieces										