

# QUALITY INSPECTION

## DIMENSION

Content	Inspection Tool
Length and width tolerance not exceed $\pm 0.3\%$ Squareness (right-angle /diagonal tolerance) $\leq 10\text{mm}$	Tape measure
Thickness tolerance not exceed $\pm 3\%$ for 760cm width. (more than 760cm width $\pm 0.7\text{mm}$ ) Thickness tolerance between two sheets $\leq 2\text{mm}$	Vernier caliper

**Frequency: Selective inspection of 10%**

## APPEARANCE

### Color and pattern

Content	Inspection Tool
No color difference between continuous number sheets in one batch slight color difference between difference batches Distribution of chips / particulars in the sheets has to be even and clear Quantity proportion of the biggest chips/particulars of 250 x 250mm size area on two sheets from one batch should be not exceed 80 : 100	Visual, production sample

**Frequency: 100%**

FOR SHEETS

## CONTAMINATION

Front side of solid colors sheets

Content	Inspection Tool
Whole sheets $\leq$ 5pcs diameter of contaminations $<$ 0.2mm; If diameter $\geq$ 0.1mm and $\leq$ 0.2mm not exceed 3pcs and distance between each 2pcs should be more than 20cm	Visual

**Frequency: 100%**

## CONTAMINATION

Front side of sheets of colors white od transparent chips

Content	Inspection Tool
Whole sheets $\leq$ 5pcs, diameter $\leq$ 0.2mm and distance between each 2pcs should be more than 20cm	Visual

**Frequency: 100%**

## CONTAMINATION

Front side of sheets for colors with white or other colored powder

Content	Inspection Tool
No contamination bigger than the biggest chips in the sheet, whole sheet 5pcs and distance between each 2pcs should be more than 30cm	Visual

**Frequency: 100%**

## PINHOLE

All front side of solid color sheet

Content	Inspection Tool
No Pinholes	Visual

**Frequency: 100%**

## PINHOLE

All front side of sheete of colors with normal chips

Content	Inspection Tool
No More than 10pcs pinholes diameter $\leq 0.1\text{mm}$ within space of 20cm in diameter	Visual
No more than 20pcs pinholes diameter $>0.1\text{mm}$ and $\leq 0.3\text{mm}$ on one sheet	
No more than 10pcs pinholes diameter $> 0.3\text{mm}$ and $\leq 0.5\text{mm}$ on one sheet	
Pinholes diameter $> 0.5\text{mm}$ is unacceptable	

**Frequency: 100%**

## PINHOLE

All back side of sheets of all colors

Content	Inspection Tool
No pinholes diameter $\geq 2.5 \text{ mm}$	Visual
No more than 20pcs pinholes $1.9\text{mm} \leq \text{diameter} \leq 2.5\text{mm}$	
No more than 30pcs pinholes diameter $\leq 1.9\text{mm}$ withinf space of 30cms in diameter	

**Frequency: 100%**

## SUNKEN AREA

Not Flat

Content	Inspection Tool
No any sunken area on the sheet	Visual

**Frequency: 100%**

## DAMAGE

Content	Inspection Tool
No damage on all edges	Visual

**Frequency: 100%**

## WARPAGE / DEFORMATION

Content	Inspection Tool
$\geq 1.5\text{mm/m}$	Visual

**Frequency: 100%**

# QUALITY INSPECTION

## CRACK

Content	Inspection Tool
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No crack on top surface and back surface	Visual
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**Frequency: 100%**

## BACKSIDE

Content	Inspection Tool
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Flat Backside no leftover oxidation layer	Visual
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**Frequency: 100%**

FOR SHEETS

# QUALITY INSPECTION

## ROUGHNESS

### Front Side

Content	Inspection Tool
According to the standard sample from 400grid water sanding	Visual & Hand Touch

**Frequency: 100%**

## ROUGHNESS

### Back Side

Content	Inspection Tool
According to the standard sample from 120grid dry sanding	Visual & Hand Touch

**Frequency: 100%**

FOR SHEETS

# QUALITY INSPECTION

## PACKAGE

Content	Inspection Tool
Sheets are clean and without water spots	
Film on the sheet is flat, not damage	
Printing on side and back is clear and in order, printing is right	Visual
Edges are clean, trimming with no leftover oxidation layer.	
No damage on all edges	

**Frequency: 100%**

FOR SHEETS