

KES

Inspection Standard for Plastics

KES R – C201

(EST.) 1991 – 04 – 30

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1. Scope of Application

This standard applies for complete inspection for injected and coated parts for cars.

2. Rank Standard for Injected and Coated Products

The application scope of rank is as table 1.

Table 1

Rank	Scope of application
A	Parts where have a lot of aesthetic values as recognizable spots after assembly
B	Parts where have less aesthetic values than A as recognizable spots
C	Parts where have poor aesthetic values or are not recognizable
D	Parts where have no aesthetic values but need a surface processing

3. Inspection Items for Coated Products and Inspection Method

Inspection Items and Inspection Method shall follow as table 2 indicated.

Table 2

Inspection	Items	Inspection method	Inspection condition	Measuring instruments
External appearance inspection	Dust(1)	Non-distruction inspection	All products	By eyes Scale
	Flow(2)			
	Scratch(3)			
	CraterIng(4)			
	Metallic stain(5)			
	Color			
	Pin hole(6)			
	Orange pill(7)			
	Lack of paint and paint flow			
Coat hardness	Hardness measurement	Distruccion inspection Sampling inspection	N = more than 5	Pencil hardnesser
Tightness Hardness	Tightness measurement			Tape
Inside impact				Inside impact measuring instruments
Resistance softening	Resistance softening measurement			Resistance softening measuring instruments

Notes (1) Dust

Dust in the paint or attached ones when the pot is dry.

(2) Flow

A condition that is like paint flows and shapes a column or curtain.

(3) Scratch

A condition that coated surface is scratched or ripped off by contacting with other things during the dry package transfer after coating.

(4) Cratering

A condition that tiny bean big crater shapes come out on the coated surface.

(5) Metallic Stain

When coating metallic paint, the flow shape is mottled rather than the metal particles are organized equally.

(6) Pin Hole

Holes like small bubbles on the coated surface

(7) Orange Pill

A condition that hard and lumpy things like an orange pill come out on the coated surface.

4. Method of Sample Picking

You shall sample according to KS A 3151 (Random sampling method).

5. Inspection Method and Inspection Standard

5.1 External Appearance

(1) Standard of Amount of Dust

The standard of amount of dust is as table 1 indicates.

Table 1

Items		Level A	Level B	Level C	Level D
Particle shaped dust (mm)	Below 0.75	Less than 4	Less than 6	Less than 8	It shall not be ugly.
	0.75 – 1.25	None	Less than 4	Less than 6	
	1.25 – 1.75	None	None	Less than 4	
	1.75 – 2.25			Less than 2	
	More than 2.25			None	
Fabric shaped dust (mm)	More than 3	Shall be apart more than 100 mm	More than 50mm	More than 30mm	
	More than 3	None	None	More than 25mm	

(2) Standard of Flow State

The standard of Flow State shall be as table 2.

Table 2

Unit : mm X mm

Inspection standard	Level A	Level B	Level C	Level D
Size(Length and width) and quantity	None	1EA of 2 X 2	2EA of 5 X 5	7EA X 5

5.1.3 Standard of Scratch

The standard of scratch shall be as table 3.

Table 3

Items	(Length X Width)	A	B	C
Area (Smaller than 500mm²)	Less than 5 X 0.2mm	Less than 2 EA	Less than 3 EA	Less than 5 EA
	Less than 7 X 0.2mm	Less than 1 EA	Less than 2 EA	
	Less than 10 X 0.2mm	None	Less than 1 EA	