





MTS-Test Workmanship Standards

Workmanship Standards Number: 05-03	Rev: A
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- 1.1 Name: Painted Surfaces
- 1.2 Workmanship Standards Category: Protective Finishes
- 1.3 Purpose/Description (why/when/how): Standard of Work applicable to painted surfaces for all deliverable product. The standard applies to the results from paint operations. The standard is intended to be used in conjunction with WS 05-02, “Identification Methods for Finished Surface Classes”.
- 1.4 Illustration: The following illustrations depict “Acceptable” and “Unacceptable” workmanship results.

Class 1 per WS 05-02.

User interface or closely observed areas.

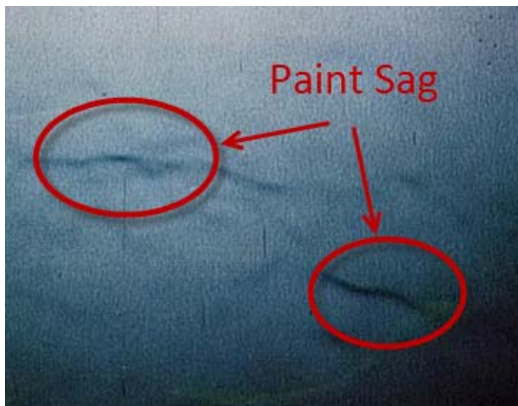
Acceptable Workmanship	Acceptable Notes
	<p>At a distance of 18” there is no inconsistency or discontinuances in the finish. There are no machining marks, scratches, abrasions, dust particles, fisheyes, orange peel, or bare metal showing. This is a surface that the end customer sees.</p>
Unacceptable Workmanship	Unacceptable Notes
	<p>Orange peel is not allowed in a class 1 finish as this gives the appearance of poor quality.</p>



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Paint sag is not allowed in a class 1 finish as this gives the appearance of poor quality.

Class 2 per WS 05-02.

Areas subject to casual observation during routine operation of equipment. If a finish class is NOT specified, it will default to a class 2.

Acceptable Workmanship	Acceptable Notes
	<p>Orange peel is acceptable in a class 2 finish if the orange peel is not detectable from a distance of 3 feet or greater under fluorescent lighting.</p>
	<p>Paint sag is acceptable in a class 2 finish if the paint sag is not detectable from a distance of 3 feet or greater under fluorescent lighting.</p>

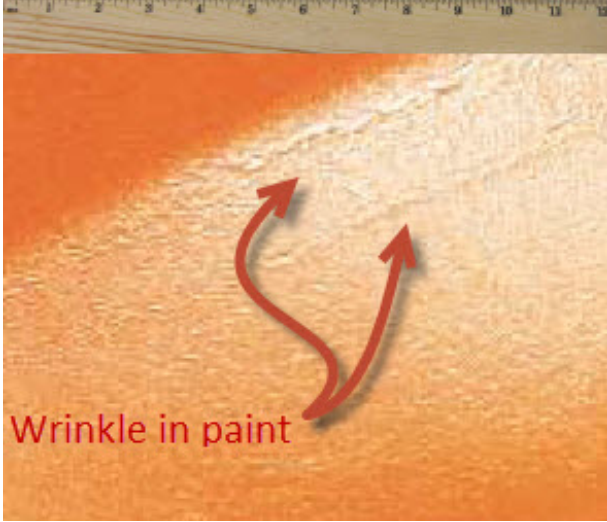
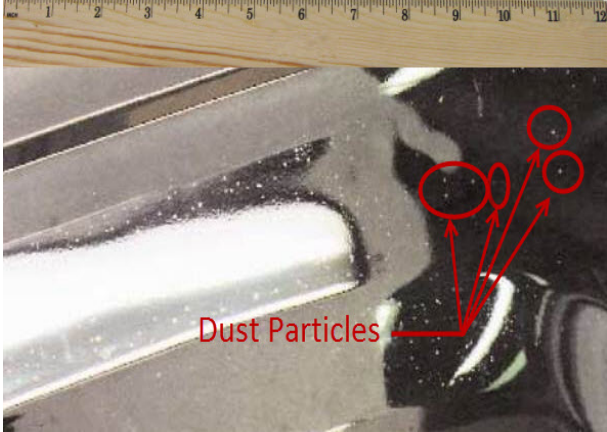
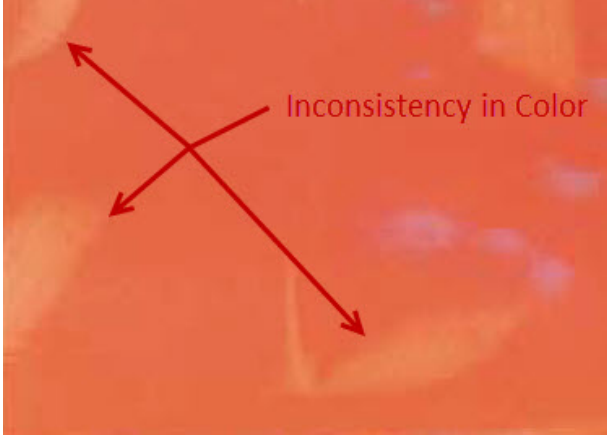


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Unacceptable conditions in Class 2 are also unacceptable in Class 1.

Unacceptable Workmanship	Unacceptable Notes
 <p>Wrinkle in paint</p>	<p>Wrinkles in paint that are larger than .030 and causes a discontinuance of texture is not acceptable as this causes assembly issues and this gives the appearance of poor quality.</p>
 <p>Dust Particles</p>	<p>More than two particles within a 12" x 12" square area when visible from a distance of 3 feet, or when particles are larger than .030 in diameter are unacceptable. This gives the appearance of poor quality.</p>
 <p>Inconsistency in Color</p>	<p>Inconsistency in color when viewed at a distance of 3 feet or greater under fluorescent lighting is unacceptable as this gives the appearance of poor quality.</p>

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Print date: 12/19/14

Workmanship Standards are minimum requirements and may be superseded by engineering drawings, purchase orders, and/or referenced specifications

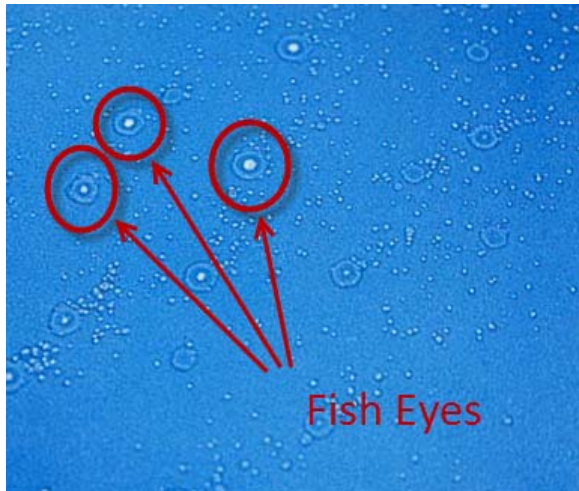
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Fish Eyes are never acceptable in a class 2 finish as it gives the appearance of poor quality.

Class 3 per WS 05-02.

Typically areas are internal surfaces that are not seen, viewed from long distances, or only occasionally observed by the customer or service technician for routine maintenance.

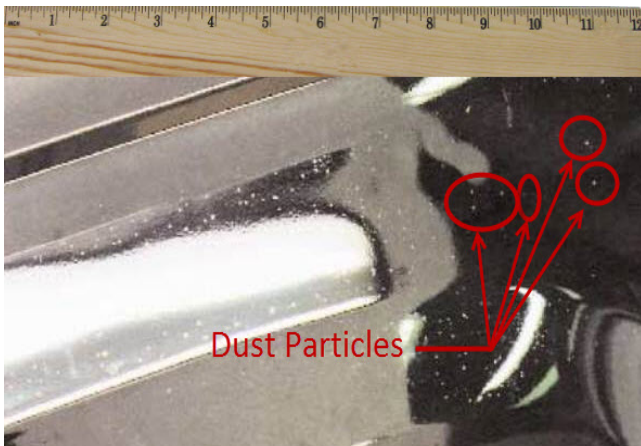
Acceptable Workmanship	Acceptable Notes
	<p>A wrinkle in paint in a class 3 area is acceptable as long as the physical integrity of the paint film is not broken and does not interfere with the assembly process.</p>



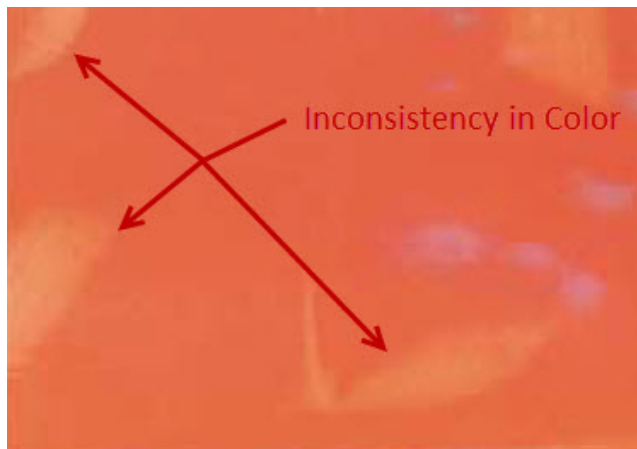
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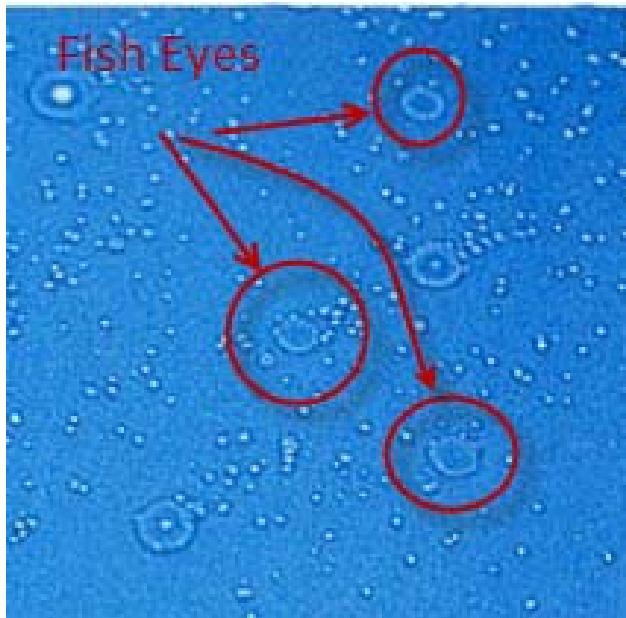
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Dust particles in a class 3 area are acceptable as long as the physical integrity of the paint film is not broken and does not interfere with the assembly process.



Inconsistency in color is acceptable as long as the physical integrity of the paint film is not broken.



Fish Eyes are acceptable on a class 3 finish as long as there is no base metal showing.

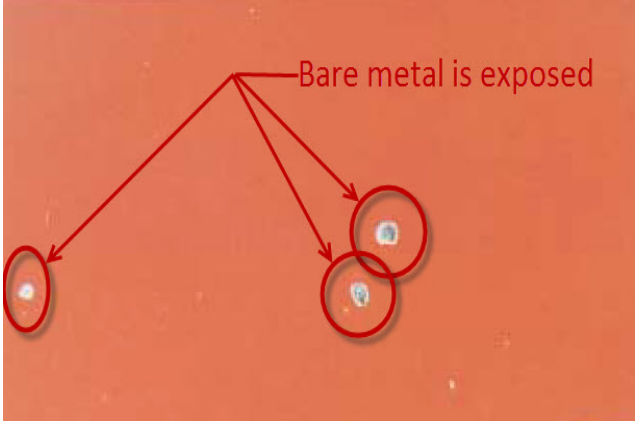
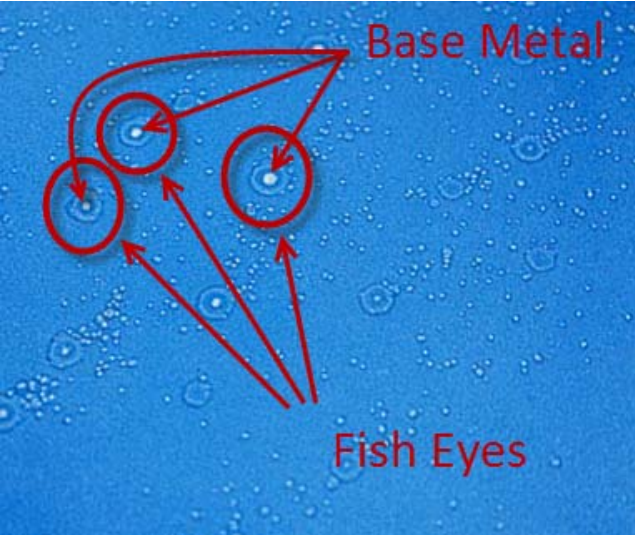


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Unacceptable conditions in Class 3 are also unacceptable in Class 1 and class 2.

Unacceptable Workmanship	Unacceptable Notes
 <p>Bare metal is exposed</p>	<p>Exposed bare metal is never acceptable as this compromises the integrity of the finish and overall quality of the product.</p>
 <p>Base Metal</p> <p>Fish Eyes</p>	<p>Fish Eyes are never acceptable if base metal is showing. This leads to corrosion of base metal and premature product failure.</p>



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2 REVISION HISTORY & APPROVAL

REVISION HISTORY			
Rev	Description of Change	Author	Effective Date
A	Initial release	D Winslow	4/15/2013

APPROVAL OF CURRENT REVISION		
Name / Function	Signature	Date
Stephen Jordheim / Workmanship Standards Process Owner	(approval on file)	
Al Rivers / Workmanship Standard Co- pilot	(approval on file)	