

KSTONE-ACRYLIC SOLID SURFACE SHEETS INSPECTION STANDARDS

SERIAL	ITEMS	INSPECTION STANDARDS	INSPECTION METHOD	INSPECTION AMOUNTS
1	Impurities (Surface of White Colors)	(1) 、 Not Allowed to appear more than 0.4mm ² size impurities on full sheet	Visual test under fluorescent light	Inspect all
		(2) 、 Not Allowed to appear more than 3 impurities of 0.3mm ² ~0.4mm ² within 30cm circle		
		(3) 、 Not Allowed to appear more than 10 impurities of 0.1mm ² ~0.3mm ² within 10cm circle		
2	Impurities (Back of White Colors)	(1) 、 Not Allowed to appear more than 5.0mm ² impurities on full sheet	Visual inspection under fluorescent light	Inspect all
		(2) 、 Not Allowed to appear more than 5 impurities of 3.0mm ² ~5.0mm ² within 30cm circle		
		(3) 、 Not Allowed to appear more than 10 impurities of 1.0mm ² ~3.0mm ² within 10cm circle		
3	PIN HOLES	Without any pin holes on surface of sheets	Visual inspection under fluorescent light	Inspect all
4	HOLLOW	No any hollow, including chips sunken	Visual inspection under fluorescent light	Inspect all
5	BREAKAGE (Orthogonal)	(1) 、 The maximum damage length in the extended side direction at the right angle of each sheet is not allowed to exceed 3mm	Visual inspection under fluorescent light/tape measure	Inspect all
		(1) 、 The maximum damage length in the direction of the wide side at the right angle of each sheet is not allowed to exceed 5mm		
	BREAKAGE (Long edge)	(1) 、 Damage to the edge along the length direction is not allowed to exceed 1mm		
	BREAKAGE (Wide edge)	(1) 、 The damage along the edge in the width direction is not allowed to exceed 3mm, and the maximum length in the length direction does not exceed 25mm		
6	BENDING	(1) 、 Small chips color : The maximum gap between the sheet and the reference level does not exceed 1.3mm	Datum level/plug gauge/steel ruler	Inspect all
		(2) 、 Big chips color : The maximum gap between the sheet and the reference level does not exceed 1.7mm		
7	CRACKS	No any cracks on surface and back of sheet	Visual inspection	Inspect all
8	WAVE PATTERN	No any wave patterns on surface and back of sheet	Visual inspection	Inspect all
9	POLISHING LINES	No any polishing marks on surface and back of sheet	Visual inspection	Inspect all
10	BARCOL HARDNESS	55~60 by Modified Acrylic, 65 by 100% Acrylic solid surface	Barcol hardness tester	Inspect all
11	COLOR DIFFERENCE	(1) 、 The light color difference between the sheet and the standard sample is controlled below 1.0, and the color difference between chips color is below 1.6	Visual inspection/Colorimeter	Inspect all/Sampling
		(2) 、 There must be no color difference and uneven chips distribution on the same sheet		
		(3) 、 Same lot number and continuously of sheet no color difference		
		(4) 、 The color paste is uniformly dispersed, and the sheet is not allowed to appear color spots and chromophores.		
		(5) 、 The phenomenon of whitening of more than 3 particles is not allowed in a circle with a diameter of 10cm, Especially the phenomenon of whitening of large and dazzling particles must be prohibited.		
		(6) 、 There must be no obvious color difference between the sheets produced within six months and the standard sample (that is, there can only be one standard sample)	Visual/UV Anti-aging Inspection	
		(7) 、 At the same time, there should be no chromatic aberration at the repair point of the sheet.		
12	POLISHING (Surface)	More than 1200#	Visual/Gloss instrument	Inspect all/Sampling
	POLISHING (Back)	More than 320#		
13	RESIN ADHESION	No any resin adhesion on the surface and back of sheet (Especially, The back side of sheet resin adhesion without polishing)	Visual inspection	Inspect all
14	CHIPS UNEVEN	No chips uneven on the surface and back side of sheets.;From the cross section of the plate, there is no obvious sedimentation distribution of the particles.	Visual inspection	Inspect all
15	LATERAL LINEARITY	±1.5 mm	Nylon thread/tape measure	Sampling
16	DIAGONAL DEVIATION	Maximum deviation ≤3mm	Tape measure	Sampling
17	LENGTH	±3mm	Tape measure	Sampling
18	WIDTH	±2mm	Tape measure	Sampling
19	THICKNESS	±0.3mm	Vernier caliper	Sampling
20	PACKING AND MAKRS	(1) .The content of the printing is correct and clear, and the anti-counterfeiting signs must be intact;	Visual inspection	Inspect all
		(2) .PE protect films should cover the entire surface of the sheet flat, there should be no air bubbles in the middle, and the PE films should not be loose, wrinkled, dirty, etc.		
		(3) .There should be no obvious footprints, dirt and dust accumulation on the surface and surrounding of the board. If the phenomenon of stepping on the board cannot be avoided when the finished product warehouse is stocked, the dirty board must be cleaned after stocking.		
		(4) .The sheets are stacked neatly, the bottom sheet must face up, and the top sheet must be bottom up to prevent scratches on the board surface. Special requirements shall be implemented according to special requirements.		
		(5).The structure of the tray meets the customer's requirements, it is firm and flat, the horizontal strips are uniform, and there is no defect or nail protrusion.		