

Class	Allowable Bow per Inch in Flat State		Allowable Burrs	Allowable Nibs	Corner Condition	Allowable Surface Defects					Interleave at all stages?
	For Formed Parts	For Flat Parts				A	B	C	D	E	
P1	0.003"	0.001"	None	None	C1	U	U	1	None	None	Yes
P2	0.006"	0.002"	Normal	Normal	C2	U	U	4	1	None	If noted on router
P3	0.010"	0.004"	Normal	Normal	C3	U	U	U	6	1	None
F1	0.003"	0.001"	None	None	C1	0/0/2	None	None	None	None	Yes
F2	0.006"	0.002"	Minimal	Normal	C2	U	1/1/6	0/0/4	0/0/1	None	If noted on router
F3	0.010"	0.004"	Normal	Normal	C3	U	U	6	2	1	None
N1	0.003"	0.001"	None	None	C1	0/0/2	None	None	None	None	Yes
N2	0.006"	0.002"	Minimal	Normal	C2	U	1/1/6	0/0/4	0/0/1	None	If noted on router
N3	0.010"	0.004"	Normal	Normal	C3	U	U	6	2	1	None

Legend:
 P = Powder coated
 F = Finished (plated, such as anodized, zinc plated, or chromated)
 N = No finish

1 = Best possible standard of workmanship - not usually used, reserved for highly critical cosmetic parts

2 = Good standard of workmanship – most parts fit into this category

3 = For non-visible surfaces or for parts that are designed for rough duty. Most often used for inside surfaces or on parts that will be welded into a finished unit. This class can also be used for parts that will be coated with textured paint. Testing may be required to verify that the paint will hide P3 defects.

C1 = shaker tabs removed, corners broken

C2 = shaker tabs removed for safe handling

C3 = normal shaker tabs allowed, must not be unsafe to handle.

U = Unlimited

X/X/X = quantities of combination of the three types of defect.

For example, 1/1/5 means 1 scratch, 1 scuff, and 5 pits.

No burr – see sample board

Minimal burr – see sample board

Normal burr – see sample board

Refer to the tables below for definitions of surface defects.

SURFACE DEFECT DEFINITION TABLE

Scratch - longer, narrow lines caused by sharp edges or objects

Type	Width	Length		Minimum Separation
		F or N	P	
A	≤ .005	any	any	any
B	> .005 - ≤ .010	≤ 4"	any	2"
C	> .010 - ≤ .015	≤ 2"	any	2"
D	> .015 - ≤ .020	≤ 1"	any	2"
E	> .020 - ≤ .050	≤ 1"	any	2"
scratches wider than .050 are rejectable - check with coordinator				

Scuff / Mar -similar to scratches but usually wider and not as deep
- usually associated with operator made, not machine made

Type	Width	Length		Minimum Separation
		F or N	P	
A	≤ .020	≤ .250	any	any
B	> .020 - ≤ .060	≤ .250	any	2"
C	> .060 - ≤ .100	≤ .250	any	2"
D	> .100 - ≤ .250	≤ 1"	any	2"
E	> .250 - ≤ .500	≤ 1"	any	2"
scuffs wider than .500 - check with coordinator				

Gouge / Pit - sharp blows to surface
- measured within 4 sq in (2" x 2")

Type	Width	Length		Minimum Separation
		F or N	P	
A	≤ .010	≤ .250		any
B	> .010 - ≤ .015	≤ .250		2"
C	> .015 - ≤ .020	≤ .250		2"
D	> .020 - ≤ .025	≤ 1"		2"
E	> .025 - ≤ .050	≤ 6"		2"
gouges & pits wider than .050 should be rejected.				

Note: These defects are to be measured prior to the end finish being applied.