

**COSMETIC FINISH STANDARD****MACHINE WINDOWS****DSF 3.2.9****Definition:**

This standard defines the minimum acceptable cosmetic criteria for all windows of all ASM (DEK) Printing Machines and its subsidiaries.

**ASM (DEK) Application:**

This standard applies to any ASM (DEK) window used on a machine, or supplied as a spare by the vendor.

All windows must meet the criteria set out in this standard, unless a concession has been granted by ASM (DEK).

Where conflict is found between this standard and any other specification, the priority should be as follows:-

- |                                                      |                                     |
|------------------------------------------------------|-------------------------------------|
| 1 <sup>st</sup> Customer Specified Requirement.      | 3 <sup>rd</sup> Purchasing contract |
| 2 <sup>nd</sup> ASM (DEK) Engineering specification. | 4 <sup>th</sup> This standard       |

This standard is not an exhaustive list, any window displaying a non-specified symptom which may cause a customer issue should be reviewed only by authorised ASM(DEK) personnel.

Only upon this approval can the component be released from ASM (DEK) or its vendor.

**Glossary:**

**Window:** Any transparent or semi-transparent machine panel which, when closed, allows the operator to see into the machine

**Damage:** Any unexpected change to the surface can be labelled as damage that affects its value, purpose & appearance.

**Viewing Area:** The area of the window which is in the operator's (line of sight), whilst viewing the print process.

**Non Viewing Area:** The area of the window that is not classed as the viewing area.

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**COSMETIC FINISH STANDARD****MACHINE WINDOWS****DSF 3.2.9****ASM (DEK) Discolouration Inspection procedure:**

Mount the item to be inspected onto the machine. If not possible, ensure that it is in the same orientation as used on the machine.

Set the distance between the item and the inspector to 2,5metres.

1. Ensure the lighting system in the inspection area is normal and that light intensity is in the region of 800 LUX.
2. Without using any optical magnifying equipment, look at the item with the naked eye only. (The inspector is allowed to wear their normal prescription glasses but these must be clear transparent glasses and not coded glasses or sun glasses).
3. If the discoloration is visible within 30 seconds, and the item is set to the correct distance; it can be considered rejected.
4. If the discolouration is hardly visible or completely invisible within 30 seconds and the item is set to the correct distance; it can be considered acceptable.
5. Ensure the colour of all windows parts on view for one machine is a match.

**ASM (DEK) Visual Inspection procedure:**

Mount the item to be inspected onto the machine. If not possible, ensure that it is in the same orientation as used on the machine.

Determine whether it is a Viewing Area or Non Viewing Area. See **Glossary**.

**Viewing Area:** The distance between the object and the inspector is 0.7metres.

**Non Viewing Area:** The distance between the object and the inspector is 1.0 metres.

1. Ensure the lighting system in the inspection area is normal and that light intensity is in the region of 800 LUX.
2. Without using any optical magnifying equipment, look at the damaged area with the naked eye only. (The Inspector is allowed to wear their normal prescription glasses but these must be clear transparent glasses and not coded glasses or sun glasses).
3. If the damage is clearly visible within 30 seconds at the correct distance, the part is rejected.
4. If the damage is hardly visible or completely invisible within 30 seconds at the correct distance, the part is acceptable.

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## COSMETIC FINISH STANDARD

### MACHINE WINDOWS

#### DSF 3.2.9

#### ASM (DEK) Acceptable Criteria:

|                         |                                     |                                                                                     |
|-------------------------|-------------------------------------|-------------------------------------------------------------------------------------|
| Type of Damage          | "Blister"                           |  |
| Material                | Toughened Glass ASM *.* (DSM 3.4.4) |                                                                                     |
| Visual Inspection       | See Visual Inspection Rules         |                                                                                     |
| Damage Quantity Allowed | None                                |                                                                                     |

|                         |                                     |                                                                                      |
|-------------------------|-------------------------------------|--------------------------------------------------------------------------------------|
| Type of Damage          | "Chip"                              |  |
| Material                | Toughened Glass ASM *.* (DSM 3.4.4) |                                                                                      |
| Visual Inspection       | See Visual Inspection Rules         |                                                                                      |
| Damage Quantity Allowed | None                                |                                                                                      |

|                         |                                                                                                                                                      |                                                                                       |
|-------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------|
| Type of Damage          | "Scratch"                                                                                                                                            |  |
| Material                | Toughened Glass ASM *.* (DSM 3.4.4)<br>P'carbonate Sheet ASM *.* (DSM 3.4.5)<br>Eslon DC Plate ASM *.* (DSM 3.6.2)<br>Perspex ASM *.* (DSM 3.4.1)    |                                                                                       |
| Visual Inspection       | See Visual Inspection Rules                                                                                                                          |                                                                                       |
| Damage Quantity Allowed | <b>Viewing Area</b> -No greater than 1 scratch, 2.5mm long, 0.2mm wide<br><b>Non-Viewing Area</b> -No greater than 2 scratches, 5mm long, 0.2mm wide |                                                                                       |

|                         |                                    |                                                                                       |
|-------------------------|------------------------------------|---------------------------------------------------------------------------------------|
| Type of Damage          | "Patination (Oil Marks)"           |  |
| Material                | Eslon DC Plate ASM *.* (DSM 3.6.2) |                                                                                       |
| Visual Inspection       | See Visual Inspection Rules        |                                                                                       |
| Damage Quantity Allowed | None                               |                                                                                       |

|       |       |       |       |    |    |    |    |    |    |
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