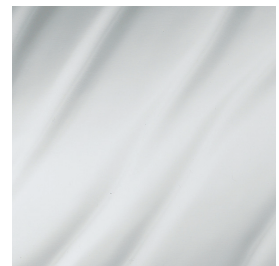
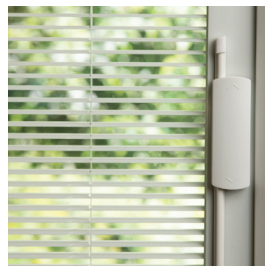




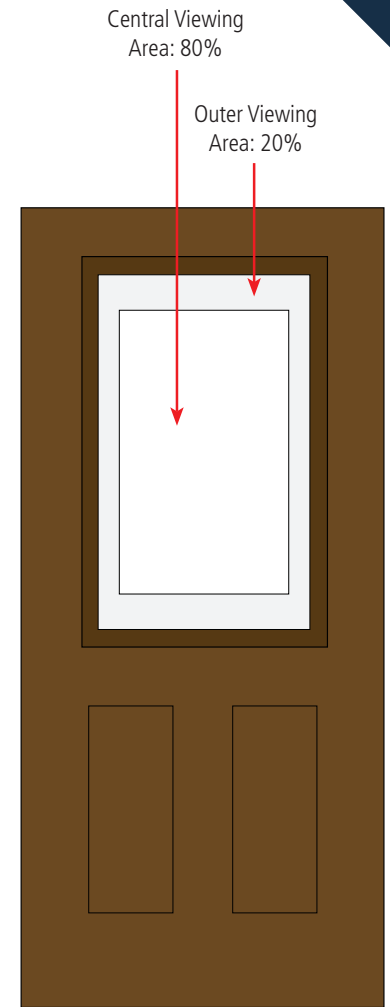
Visual Quality Standards

These visual quality standards will guide you in evaluating the issues within the inner air space, glass and blinds.

Key characteristic, method, and measurement details outlined on back of this sheet.



INNER AIR SPACE		
KEY CHARACTERISTIC	METHOD	MEASURE
1. Dirt particle (DSE, Dirt, etc) inside of glass	1.1 Using a backlight fixture, inspector positioned at 36" standing in front of panel, duration of inspection is 5 - 6 second.	1.1.1 Central Viewing Area: One Particle up to 1/16" in size is allowed. 1.1.2 Outer Viewing Area: No more than two, 1/16" in size allowed a minimum of 6" apart.
2. Dirt particle on decorative cover caps	2.1 Method same as above.	2.1.1 No more than two particles up to 1/32" in size allowed a minimum of 6" apart.
BLIND		
KEY CHARACTERISTIC	METHOD	MEASURE
1. Tilt direction & quality	1.1 View @ 90° from 36" standing in front of panel, tilt blinds fully forward and backward.	1.1.1 Must not be able to see through the unit when viewed from eye level.
2. Dirty slats (smudges, spots, dirt particles, etc.).	2.1 View from 36" away with the blind lowered.	2.1.1 Central Viewing Area: No visual defects. 2.1.2 Outer Viewing Area: No more than two defects, 1/16" in size allowed a minimum of 6" apart.
3. Level blind slats	3.1 Blind dropped fully and open, view against grid backdrop.	3.1.1 Blind slats must be level to within 1/4" on full size (20" or greater in width) and 1/8" on anything narrower than 20".
4. Level blind stack	4.1 Blind raised fully, view against grid backdrop.	4.1.1 Bottom rail must be level to within 1/4" on full size (20" or greater in width) and 1/8" on anything narrower than 20".
GLASS		
KEY CHARACTERISTIC	METHOD	MEASURE
Conforms to ASTM C1036-16 (annealed), C1048-12 (tempered) & C1376-15 (pyrolytic) standards		
GLASS INSPECTION METHOD		
WORK ELEMENT	KEY POINT	REASON
1. Place glass on glass viewing apparatus	1.1 Put on protective cut gloves and safety glasses 1.2 Carefully remove glass from rack and place on the viewing apparatus 1.3 Secure glass to fixture	1.2.1 Ensures no glass scratches or debris gets on glass
2. Move to glass viewing area	2.1 Start 13' away from the glass	2.1.1 Specified start length in ASTM standard
3. Start glass inspection	3.1 Walk toward glass while looking at the glass at a 90-degree angle 3.2 While viewing the glass, look through the central viewing area	3.1.1 Duration from 13' to glass should take approximately 10 seconds 3.2.1 Imagine looking through a quarter sized area in the center of the glass
4. Blemish detection	4.1 When a blemish is detected, measure the distance between your location and the glass 4.2 Record distance and determine blemish intensity 4.3 Check blemish intensity chart (Table 1)	4.1.1 Determines size of blemish 4.2.1 Heavy Blemish: Detected 13' - 11' away 4.2.2 Medium Blemish: Detected 11' - 3' away 4.2.3 Light Blemish: Detected 3' - 8" away 4.2.4 Faint Blemish: Detected 8" - 0" away 4.3.1 Shows allowable blemish sizes for a Quality 3 Distribution center
5. Chip Detection	5.1 When a chip is detected, refer to Table 2	5.1.1 Table 2 shows chip sizes. Distance from the glass does not matter.



TECHNICAL DRAWING

Viewing Areas

Central Viewing Area: A square or rectangle defined by 80% of the length and 80% of the width shifted toward the top of IG.

Outer Viewing Area: The remaining area outside the central viewing area.

Particle Size (Not to Scale)

- 1/32"
- 1/16"

TABLE 1. ALLOWABLE LINEAR BLEMISH SIZE		
LINEAR BLEMISH SIZE		Q3
INTENSITY	LENGTH	Quality 3 Distribution
Faint	≤ 75 mm (3")	Allowed
Faint	> 75 mm (3")	Allowed
Light	≤ 75 mm (3")	Allowed
Light	> 75 mm (3")	Allowed
Medium	≤ 75 mm (3")	Allowed with a minimum separation of 600 mm (24")
Medium	> 75 mm (3")	None Allowed
Heavy	≤ 75 mm (3")	None Allowed
Heavy	> 75 mm (3")	None Allowed

TABLE 2. ALLOWABLE CHIP SIZE	
DESCRIPTION	Q3
Chip Depth	Chip depth ≤ 50% of glass thickness
Chip Width	Chip width ≤ glass thickness or 6 mm (1/4") whichever is greater
Chip Length	Chip length ≤ 2 times the chip width



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