



TITLE: SURFACE PLAN

		001	002	003
		Standard Terminology	Standard Terminology	Standard Terminology
		Starting Point	Starting Point	Starting Point
A	Pits	Can't see or feel	<.005" Deep	.005" - .010" Deep
L	Black Scale/Pits	Can't see or feel	<.005" Deep	.005" - .010" Deep
L	Burr	<5% of material thickness	<5% of material thickness	<8% of material thickness
	Scratches	Can't see or feel	Can't see or feel	Can't see or feel
M	Friction Digs	Can't see or feel	See, but can't feel light	See and feel light
A	Bad Mill Edge	Can't see or feel	See and feel	See and feel
T	Edge Damage	Can't see	See OK	See OK
E	Mandrel Breaks	Can't see or feel	Feel lightly	Medium
R	Coil Breaks	Can't see or feel	See and can't feel	See and feel
I	Shadow Breaks	Can't see	See OK	See OK
A	Water Stain	Can't see or feel	Up to 25% covered	25-50% covered
L	Rust	Can't see or feel	Up to 25% covered	25-50% covered
	Dents/Dimples	Can't see or feel	See and feel light (<.005")	Feel easily (.005" - .010")
T	Chatter	Can't see or feel	Shadows, but can't feel	Feel lightly
Y	Strain/Stress Marks	Can't see or feel	See and feel (Light)	See and feel (Med-Heavy)
P	Laminations	Can't see or feel	Can't see or feel	See and feel
E	Roller Marks (Raised)	Can't see or feel	See, but can't feel	< .010"
S	Pickup Marks (Impressions)	Can't see or feel	See but can't feel	< .010"
----	Oil (Indicate Desired Amt)	None, Light, Heavy, Any Amt, Any Amount <u>Except</u> None	None, Light, Heavy, Any Amt, Any Amount <u>Except</u> None	None, Light, Heavy, Any Amt, Any Amount <u>Except</u> None
P	Scale (P&O)	Can't see or feel	<.005" Deep	.005" - .010" Deep
&	Scale Flashing (P&O)	Can't see	See OK	See OK
O	Pickling Stain (P&O)	Can't see or feel	Up to 25% covered	25-50% covered
----	Saw Tooth Edge	Can't see or feel	1/16" in from edge	1/8" in from edge
C	White Rust	Can't see or feel	Up to 25% covered	25-50% covered
O	Green Stain	Can't see or feel	Up to 25% covered	25-50% covered
A	Buildup/Dross	Can't see or feel	See and feel light (<.005")	Medium (.005 - .010")
T	Crease	Can't see	See OK	Texture Diff (not raised)
E	Stencil Smudge/Smear	Can't see or feel	Can't see or feel	Exists
D	Flaking	Can't see or feel	Up to 10% covered	10-20% covered
----	Discoloration	Can't see or feel	Up to 25% covered	Up to 50% covered
----	Sag Lines	Can't see or feel	See and Feel Light	See and Feel Medium
----	Bare Spots in Coating	Can't see or feel	< 1 spec / sq ft	Accept As Is
CR	Annealing Stain	Can't see or feel	Up to 25% covered	25-50% covered
CR	Sticker Breaks	Can't see or feel	See and feel (Light)	See and feel (medium)
CR	Flopper	Can't see or feel	See OK	Texture Diff (not raised)
CR	Pincher	Can't see or feel	See OK	Texture Diff (not raised)
Pre	Orange Peel	Can't see or feel	See Slight	See any amount
P	Paint Finish	Not dull or no discoloration	Dull and shiny areas	Discoloration
A	Chipping	Can't see or feel	Can't see or feel	<5%
I	Dirty	Can't see or feel	Can't see or feel	Can't see or feel
NT	Paint Voids (No paint)	Can't see or feel	Can't see or feel	<5%
N O T E S				



TITLE: SURFACE PLAN

		Actual Example 1	Actual Example 2	Actual Example 3
		Transformer	Appliance Manufacturer	Automotive Manufacturer
		Manufacturer	Starting Point	Chassis part
A	Pits	< .005" Deep	Can't see or feel	< .005" Deep (scattered OK)
L	Black Scale/Pits	< .005" Deep	Can't see or feel	< .005" Deep (scattered OK / not clustered)
L	Burr	<8% of material thickness	Can't see or feel	<5% of material thickness
	Scratches	See but Can't Feel	<5% of material thickness	Can't see or feel
M	Friction Digs	See and Feel Light	Can't see or feel	Can't see or feel
A	Bad Mill Edge	See and Feel	Can't see or feel	Can't see or feel
T	Edge Damage	See	Can't see or feel	Can't see or feel
E	Mandrel Breaks	Medium OK	Can't see	Can't see or feel
R	Coil Breaks	* (See Below)	Can't see or feel	Can't see or feel
I	Shadow Breaks	See	Can't see or feel	Can't see or feel
A	Water Stain	25-50% covered	Can't see or feel	Can't see or feel
L	Rust	25-50% covered	Can't see or feel	Can't see or feel
	Dents/Dimples	Feel easily (.005" - .010")	Can't see or feel	Can't see or feel
T	Chatter	Feel lightly	Can't see or feel	Can't see or feel
Y	Strain/Stress Marks	See but can't feel	Can't see or feel	Can't see or feel
P	Laminations	Can't see or feel	Can't see or feel	Can't see or feel
E	Roller Marks (Raised)	See and feel light	Can't see or feel	See, but can't feel
S	Pickup Marks (Impressions)	See and Feel light	Can't see or feel	See, but can't feel
----	Oil (Indicate Desired Amt)	None	None	Medium
P	Scale (P&O)		<.005" Deep	< .005" Deep
&	Scale Flashing (P&O)			See OK
O	Pickling Stain (P&O)			Light stain is OK
----	Saw Tooth Edge			
C	White Rust			
O	Green Stain			
A	Buildup/Dross			
T	Crease			
E	Stencil Smudge/Smear			
D	Flaking			
----	Discoloration			
----	Sag Lines			
----	Bare Spots in Coating			
CR	Annealing Stain			
CR	Sticker Breaks			
CR	Flopper			
CR	Pincher			
Pre	Orange Peel		Can't see or feel	
P	Paint Finish		Not dull or no discoloration	
A	Chipping	l	Can't see or feel	
I	Dirty		Can't see or feel	
NT	Paint Voids (No paint)		Can't see or feel	
N O T E S		*Feel when using a shop towel to enhance feel OK -- feel with bare hand not acceptable	Pressure Mottling -- an uneven pattern, often seen as glossy spots usually caused by pressure within a painted coil - OK (After application of heat, condition will disappear.)	



TITLE: SURFACE PLAN

		Actual Example 4	Actual Example 5	Actual Example 6
		Transformer	Appliance Manufacturer	Automotive Manufacturer
		Manufacturer	Starting Point	Chassis part
A	Pits	See or feel (light)	< .005" Deep	< .005" Deep
L	Black Scale/Pits	See or feel (Light)	See but can't feel	< .005" Deep
L	Burr	<5% of material thickness	<5% of material thickness	<5% of material thickness
	Scratches	See or feel (Light)	None	Can't see or feel
M	Friction Digs	See or feel (Light)	See, but can't feel	See, but can't feel
A	Bad Mill Edge	See or feel (Light)	Accept as is	Can't see or feel
T	Edge Damage	See or feel (Light)	Can't see or feel	Can't see
E	Mandrel Breaks	See or feel (Light)	See but can't feel	Can't see or feel
R	Coil Breaks	See or feel (Light)	See but can't feel	See and feel lightly
I	Shadow Breaks	See or feel (Light)	See but can't feel	Can't see or feel
A	Water Stain	See or feel (Light)	Slight OK	Can't see or feel
L	Rust	None	None	Can't see or feel
	Dents/Dimples	See or feel (Light)	None	Can't see or feel
T	Chatter	See or feel (Light)	Shadows, but can't feel	Can't see or feel
Y	Strain/Stress Marks	See or feel (Light)	None	Can't see or feel
P	Laminations	See or feel (Light)	Can't see or feel	Can't see or feel
E	Roller Marks (Raised)	See or feel (Light)	See, but can't feel	See, but can't feel
S	Pickup Marks (Impressions)	See or feel (Light)	See, but can't feel	See, but can't feel
----	Oil (Indicate Desired Amt)	None	None	Light
P	Scale (P&O)			
&	Scale Flashing (P&O)			
O	Pickling Stain (P&O)			
----	Saw Tooth Edge	See or feel (Light)		Can't see or feel
C	White Rust	None		Can't see or feel
O	Green Stain	None		Can't see or feel
A	Buildup/Dross	See or feel (Light)		Medium (.005 - .010)
T	Crease	See or feel (Light)		Can't see or feel
E	Stencil Smudge/Smear	Minor		Can't see or feel
D	Flaking	None		Can't see or feel
----	Discoloration	None		See, but can't feel
----	Sag Lines	See or feel (Light)		See, but can't feel
----	Bare Spots in Coating	Small, Scattered Specs OK		Can't see or feel
CR	Annealing Stain			
CR	Sticker Breaks			
CR	Flopper			
CR	Pincher			
Pre	Orange Peel			
P	Paint Finish			
A	Chipping			
I	Dirty			
NT	Paint Voids (No paint)			
N O T E S				