

COSMETIC SPECIFICATION FOR LARGE FORMAT SCREENS ABOVE:-
1000MM X 600MM OR 46" DIAGONAL AND ABOVE.

1. SCOPE

This document is intended to specify the cosmetic and inspection criteria for Large Format Screens. This document is intended to serve as a default specification when a formal customer specification is not referenced or available.

Performance and cosmetic characteristics for anti-glare or multi-layer anti-reflective surface coatings will default to the coating manufacturer's specifications.

Customer furnished material for incorporation into a Zytronic laminate must be accompanied by a formal written cosmetic specification. If no formal specification is available, then the cosmetic specification will default to that of this document.

However, Zytronic cannot be held responsible for defects in the final laminate, which are as a direct consequence of the quality of customer furnished material.

2. INSPECTION METHOD

The screen shall be mounted vertically and shall be viewed by a person without visual aids other than spectacles if these are normally worn. The screen must be viewed through the front face.

Laminates to be inspected shall be viewed only from the end use viewing side only.

The minimum viewing distance shall be 2-metres and the ambient lighting shall be normal factory lighting.

Vision is to be focused at a point not less than 1-metre on the opposite side of the screen to the observer to ensure that vision is not concentrated on the surface.

Any defect in the screen which is not visible under these conditions shall be deemed acceptable.

The total observation time shall not exceed 20 seconds.

3. OPTICAL SPECIFICATION

a) Linear Defects,

This class of defects includes hairs, fibres, and scratches, which are generally long in nature.

Less than 30mm shall be deemed acceptable. No more than 2.

Greater than 30mm shall be deemed unacceptable.

Irregular shapes shall be within 10 Squares (1mm per square) No more than 2.

b) Circular Defects.

This class of defects includes digs, bubbles, foreign matter, coiled hairs/lint and coating blemishes, which are generally round or circular in nature.

Defect Description.	Defect Allowance.
Mean Diameter (D) > 3mm (0.12")	None.
D > 1mm (0.039") < 3mm (0.12")	3 per Laminate.
D > 0.5mm (0.02") < 1mm (0.039")	No limit min. spacing 100mm.
D < 0.5mm (0.02")	Disregard.

c) Edge Chips

Edge chips are permissible so long as they do not encroach into the viewing area and do not exceed, 6mm x 1mm in size and 5-off total in frequency, so long as they are no closer than 100mm to one another.

d) Screen Print Defects

Print Defects which are detected when examined from 2 metres shall be accepted if they are:

- 1) Pinholes less than 2mm mean diameter
- 2) Contamination between the glass and the ink which is less than 3mm mean diameter.
- 3) Water marks and Moiré pattern are inherent in the screen print process and these are acceptable if not readily observed during the initial inspection from 2 metres.

CHANGE LOG

CHANGE	Date	REQUESTED BY	ITEM/SECTION	MODIFICATION OR REASON
1	03/04/2014	C Thompson	All Sections	Initial Document Creation/Approval
2	12/02/2015	C Thompson	All Sections	Review
3	01/12/2016	C Thompson	All Sections	Review
4	16/01/2017	K Gleghorn	All Sections	Document reformatted