

COACH GLASS[®]

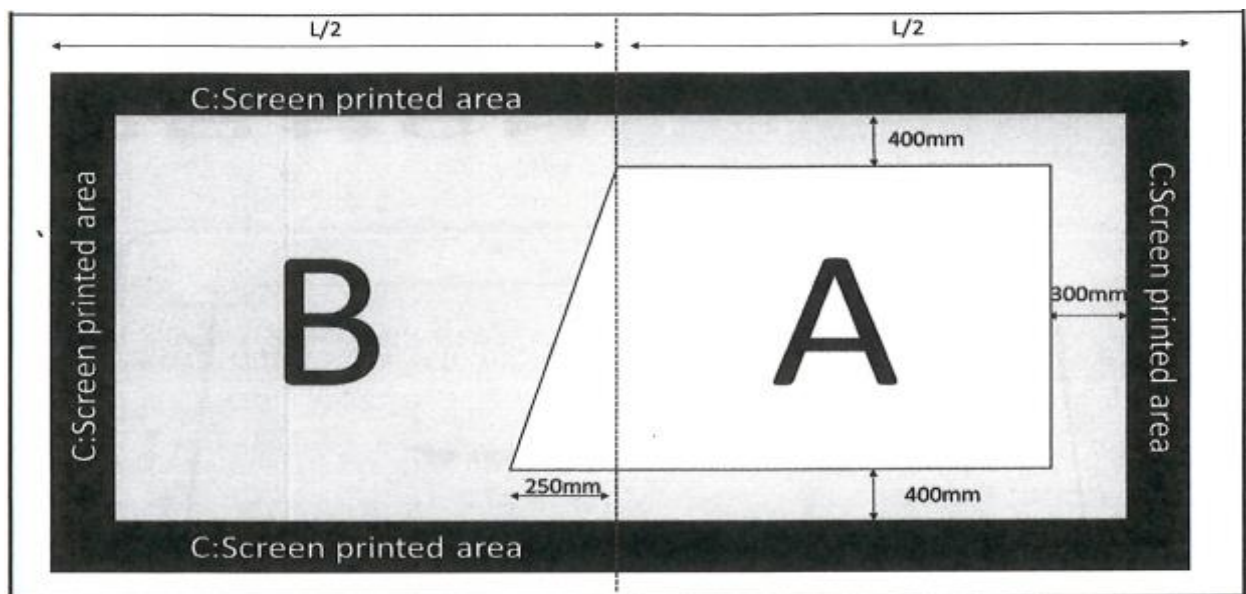
SPECIALTY VEHICLE GLASS

Quality Inspection Standards

The following quality standards are guidelines for the evaluation of laminated glass provided by Coach Glass.

General:

- This guide is intended to provide a standard for inspecting laminated glass and the tolerances allowed. All inspections are to be performed at a distance of 5 feet with normal daylight conditions. All inspections are to be performed with a 90-degree viewing angle to the glass surface, and the inspector looking “through” rather than “at” the glass surface.
- The area of most importance is the central viewing area (please see section “A” on diagram – Drivers side of window). Sections “B” and “C” are considered outer areas.
- No more than 25 seconds should be spent viewing the glass



view from outside of vehicle looking in

Defect Type	Area "A"	Area "B"	Area "C"	Definitions
Scratches	Heavy = NONE. Medium = allowed up to 6mm in length. Light = allowed up to 70mm in length.	Heavy = NONE. Medium = allowed up to 15mm in length. Light = allowed up to 125mm in length.	Heavy = All allowed Medium = All allowed Light = All allowed	Heavy = Deep scratches that catches with finger nail and cannot be polished out. Medium = Scratch that catches with finger nail but can be polished out. Light = Cannot be felt with finger nail. Can be polished out if needed.
Laminating Smear	Not to interfere with vision	Not to interfere with vision	Allowed	Faint cloudy streak in the vinyl interlayer
Shell Chips	None allowed	None allowed	(2) 4.76mm by 4.76mm per part separated by 300mm.	Flaking of small particles of glass. Usually on the edge.
V Chips	None allowed	None allowed	None allowed	A chip that forms a sharp V shape on the edge of the glass. Has potential to interfere with the strength and integrity of the glass.
Ceramic Paint Voids	N/A	Areas of less than 7mm can be repaired using primer or color matching paint pen.	Areas of less than 7mm can be repaired using primer or color matching paint pen.	Ceramic border painted areas with missing or paint voids.
Delamination	None allowed	None allowed	None allowed	Air pocket appearance due to Laminated vinyl releasing adhesion from glass.
Distortion	None allowed	Less than 50mm distortion area and within 100mm from C area.	Allowed	Spot in glass causing circular distortion around a central area.