7.20.3 Quality requirements

Test method	Requirement	Remarks	Frequency
3.5 visual assessment	internal 0 defects external max. 5 defects/m² (*)		in production 100 %
3.9.3 hardness	hardness mohs ≥ 5	on test sheets	when taking into production a sig.diff. enamel recipe, but at least 1 x a year
4.3 thickness enamel coating	0.34 ± 0.16 mm		S4 AQL 2.5
4.4 cold citric acid cold sulphuric acid cold hydrochloric acid	min. class A min. class A min. class A	EN ISO 28706-1 solution 10 % test duration 15 minutes	in production 1 x per month in production 1 x per month in production 1 x per month
4.5 boiling citric acid	weight loss: max. 5 g/ m² per 2.5 hours	on test sheets conform to EN ISO 28764, test duration 2,5 hours, EN ISO 28706-2	when taking into production a sig.diff. enamel recipe, but at least 1 x a year
4.6 boiling water	weight loss: max. 10 g/m² per 48 hrs vapour phase weight loss: max. 5 g/m² per 48 hrs liquid phase	on test sheets conform to EN ISO 28764, test duration 48 hours, EN ISO 28706-2	when taking into production a sig.diff. enamel recipe, but at least 1 x a year
4.7 detergent solutions	weight loss: max. 5 g/m² per 24 hours	EN ISO 28706-3	when taking into production a sig.diff. enamel recipe, but at least 1 x a year
4.9 impact resistance	max cracking: at 20 N no damage > 2 mm ø after 24 hours	ISO 4532	when taking into production a sig.diff. enamel recipe, but at least 1 x a year
4.10 adherence or 4.39	min. 2 min. "good"	on test sheets conform to EN ISO 28764 on test sheets conform to EN ISO 28764	in production 1 x a month in production 1 x a month
4.12 porosity	internal 0 defects	EN 14430	in production 100 %
4.25 sodium hydroxide 80° C	max. 8 g/m² per 24 hours	test duration 24 hours EN ISO 28706-4	when taking into production a sig.diff. enamel recipe, but at least 1 x a year
4.28 steel quality	double-sided enamellable steel quality or suitable construction steel for applied processing		

(*) Defects at the outside: 5 defects of max. 1 mm diameter (on a test surface of 1 m²);
Max. 5 defects are allowed to be repaired, f.e. by means of a sealing kit.