



# F-860-001 Visual Inspection Guidelines for Cosmetic Surfaces

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For components or assemblies, cosmetic inspection shall use the Time and Distance Inspection process described below unless otherwise defined by customer documentation.

Cosmetic Class Codes- The cosmetic class codes use letters “A” through “D”.

**Class A** - generally the top or front, the most often viewed surface (High visibility).

**Class B** - generally the front edge and sides of a part. Not viewed as often as an “A” surface but easily seen by user.

**Class C** - generally the back and bottom surface.

**Class D** - generally internal surface. Normally, D surfaces are not inspected for cosmetic attributes. Where necessary, D surface inspection will be specified as an exception.

Viewing Conditions - The dimension, degree angle, and lighting are approximations.

Lighting intensity - Quality decisions of cosmetic acceptability will be made under lighting conditions between 80-120 foot candles.

Viewing Angle - Viewing angle is dependent on surface classification with direct overhead lighting. In every case, parts will be held such that the light is NOT REFLECTED directly to the viewer.

**Class A** surface- Hold part 30° from the horizontal plane.

Part is in direct line with your eyes. ROTATE part 30° to the right and to the left.

**Class B** surface- Hold part 90° from the horizontal plane.

Part is in direct line with your eyes. DO NOT Rotate the parts.

**Class C** surface- Hold part 90° from the horizontal plane.

Part is NOT in direct line with your eyes. Part is held 45° below the plane of your eyes. DO NOT rotate the part.

Viewing Distance

**Class A** surface-18 inches

**Class B** surface-24 inches

**Class C** surface-30 inches

Inspection interval (time)

Surface area	A Surfaces	Non-A surfaces
<4 in <sup>2</sup> (2” x 2”)	2 sec.	1 sec.
4-16 in <sup>2</sup> (4” x 4”)	4 sec.	2 sec.
16-64 in <sup>2</sup> (8” x 8”)	6 sec.	3 sec.
64-144 in <sup>2</sup> (12” x 12”)	8 sec.	4 sec.
>144 in <sup>2</sup> (12” x 12”)	10 sec.	5 sec.

Inspection results disposition:

**Class A** - coating imperfections not inherent to process are not allowed, imperfection/scratch not allowed.

**Class B and C** – coating imperfections (smudge, texture, gloss) allowed, imperfection/scratch does not penetrate coating

**Class D** - coating imperfections allowed, imperfection/scratch does penetrate coating but does not leave a burr