

**To:**

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Quality Claim Engineer

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**From:**

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Quality Lab Technician

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**Object:** RELEASE OF A NEW CASTING MOULD FOR PRODUCTION 442710333041 BRP102 HOUSING MALAGA  
LARGE - PAINTED AT LVL SUPPLIER

**Product description:**

**Brand:** Philips

**Family name:** Coreline \_Malaga\_Led

**Family code:** BRP102

**Tests according to:**

☒ QS-014207

**Test Equipment:**

☒ Salt chamber

☒ Thickness apparatus

☐ Container with demineralized water

☒ Cross test apparatus

☒ Adhesive

**Test Results:**

☐ PASS / ☒ N/A

☐ FAIL

**Tested by:**

☒ Aneta Lewandowska

☐ Dalida Fuks

☐ Michał Szepietowski

☐ Piotr Jakubiec

☐ Konrad Micinski

☐ Andrzej Haluszka

**Approved by:**

☒ Dariusz Pierzchanowski

**Test date:** 01.08.2020 to 28.08.2020

**Issue date:** 28.08.2020

**1. Thickness measurements**

**Program:**

☒ Program 1 & 1bis: thickness=60-80µm for 500hrs Salt spray test

☐ Program 1 & 1bis: thickness=120-160µm for 1000hrs Salt spray test

☐ Program 2: thickness=60-80µm for 48hrs salt spray test

☐ Program 3: thickness=35-45µm per layer

☐ Program 4, 4bis & 5: thickness=according type of treatment

☐ Program 6: thickness=60-80µm for 72hrs salt spray test

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### Thickness measurements

**Maximum coating** thickness on parts thickness shall never exceed **double value** of targeted layer thickness unless otherwise stated.

#### Program:

- ☐ thickness= 60 µm for standard single layer painting  
☐ thickness= 120 µm for double layer MSP painting and double layer SPW painting

SAMPLE	*Area 1 ( µm)	*Area 2 ( µm)	*Area 3 ( µm)
Sample 1 Cover	67	42	69
Sample 1 Cover	60	60	62
Sample 1 Cover	78	73	81

### 2. Evaluation from a distance 3m

SAMPLE	P	F	N/A	Comments
Sample 1	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Smooth coating without bubbles
Sample 2	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Smooth coating without bubbles
Sample 3	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Smooth coating without bubbles

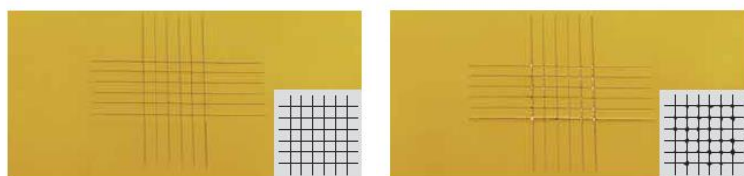
Test result	PASS	FAIL	N/A
	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

### 3. Cross cut test

**Evaluation: Adhesion: acceptable level between level 0 and 1**

Level 0 total surface remove 0%

Level 1 total surface remove below 5%



#### Before SST:

SAMPLE	Level in Area *1	Level in Area *2	Level in Area *3	P	F	NA
Sample 1 Cross cut + adhesive before SST	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Sample 2 Cross cut + adhesive before SST	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Sample 3 Cross cut + adhesive before SST	0	0	0	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Test result	PASS	FAIL	N/A
	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

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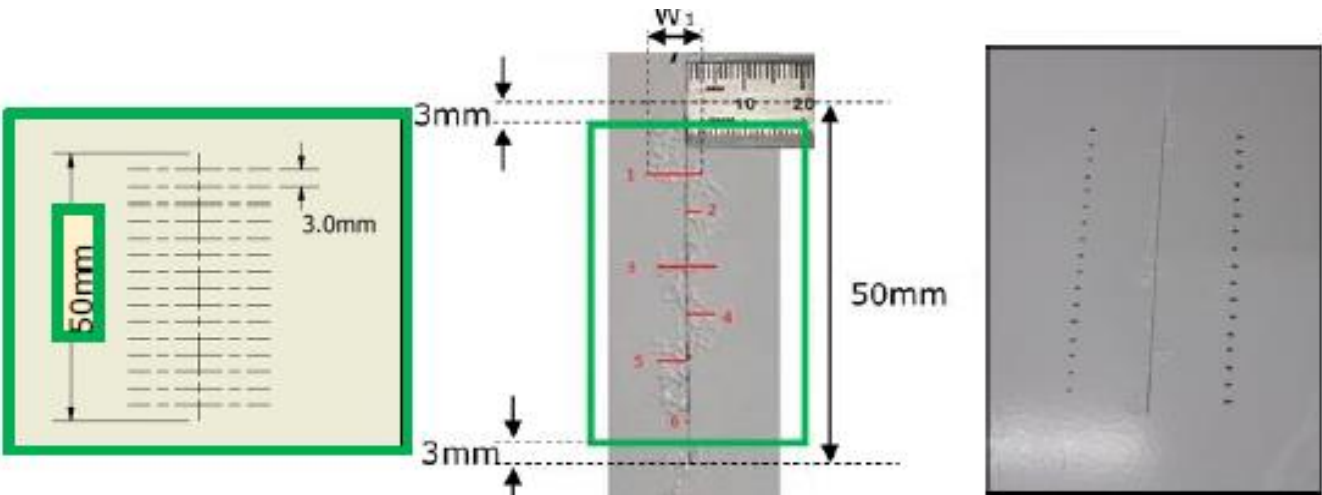
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4.Salt test

Filiform corrosion assessed according ASTM D1654:



Creep (mm)	Rating
0	10
0-0.5	9
0.5-1.0	8
1.0-2.0	7
2.0-3.0	6
3.0-5.0	5
5.0-7.0	4
7.0-10.0	3
10.0-13.0	2
13.0-16.0	1
>16.0	0

Tab. Rating levels based on creep assessment (from ASTM D1654)

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**Check after 500h SST: C = CROSS (CREEP Level)**

SAMPLE		CREEP	Creep level
Sample 1	HOUSING	C1	8
		C2	5
		C1	8
Sample 2	HOUSING	C1	6
		C2	8
		C1	7
Sample 3	HOUSING	C1	5
		C2	9
		C1	9

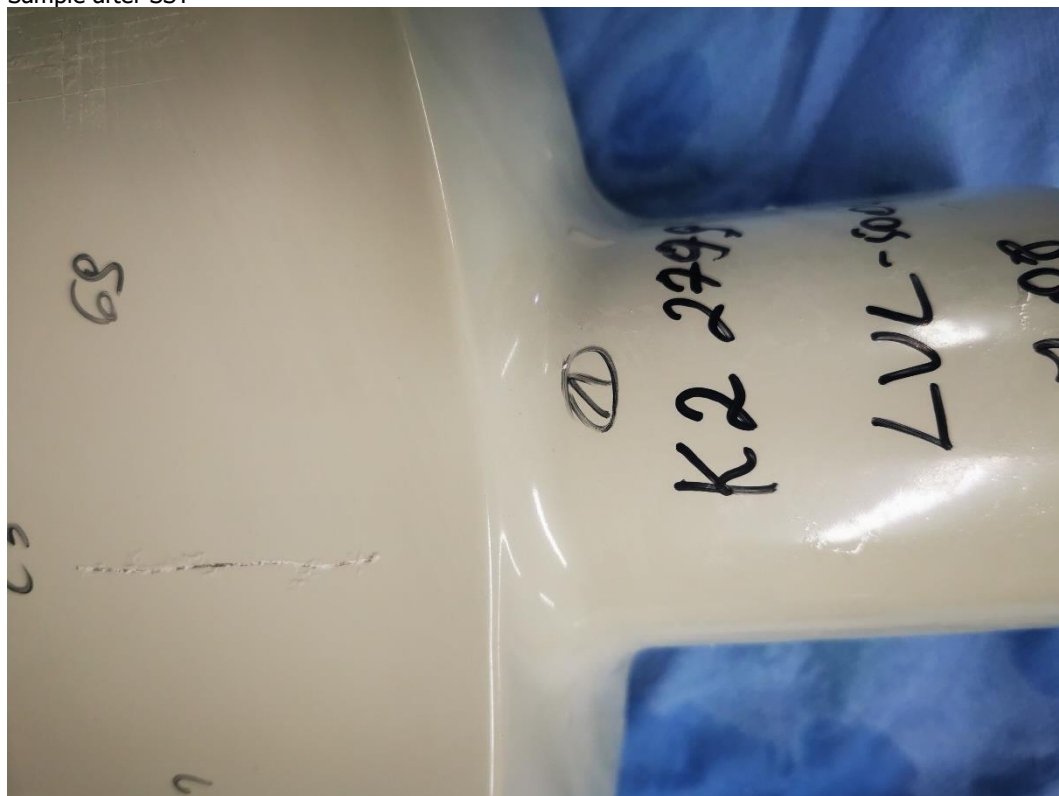
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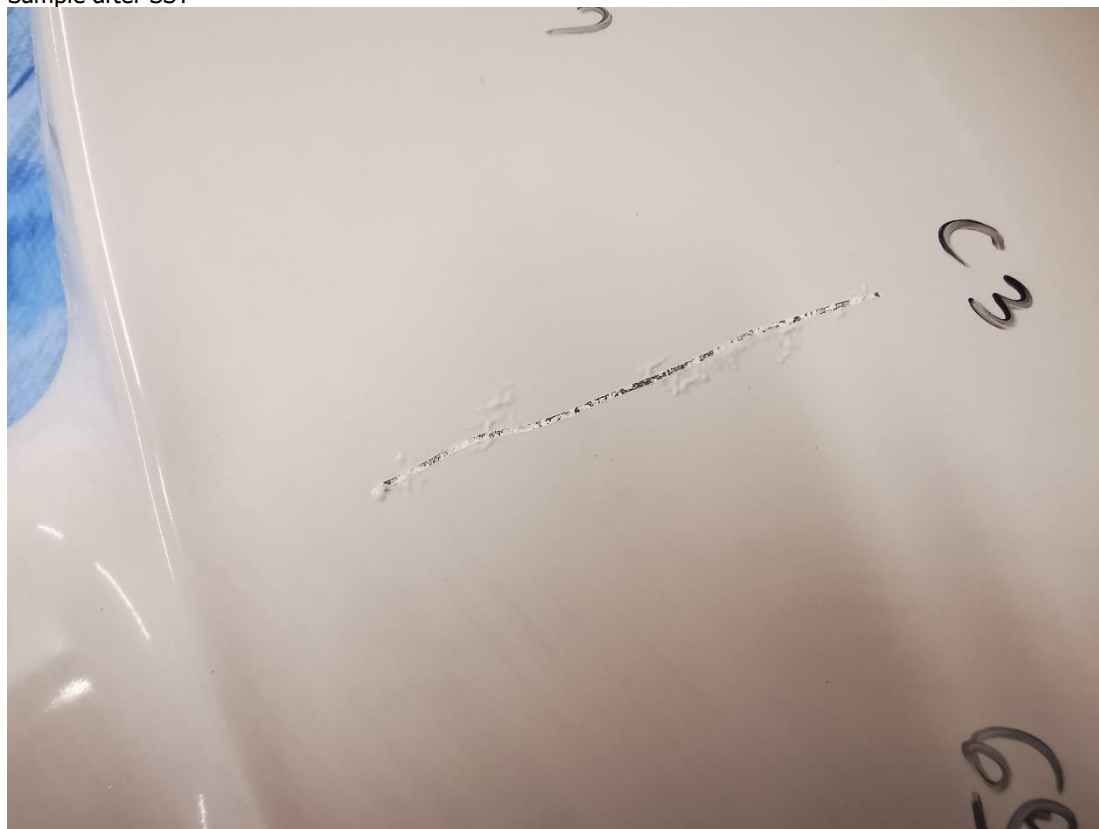
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Sample after SST



Sample after SST



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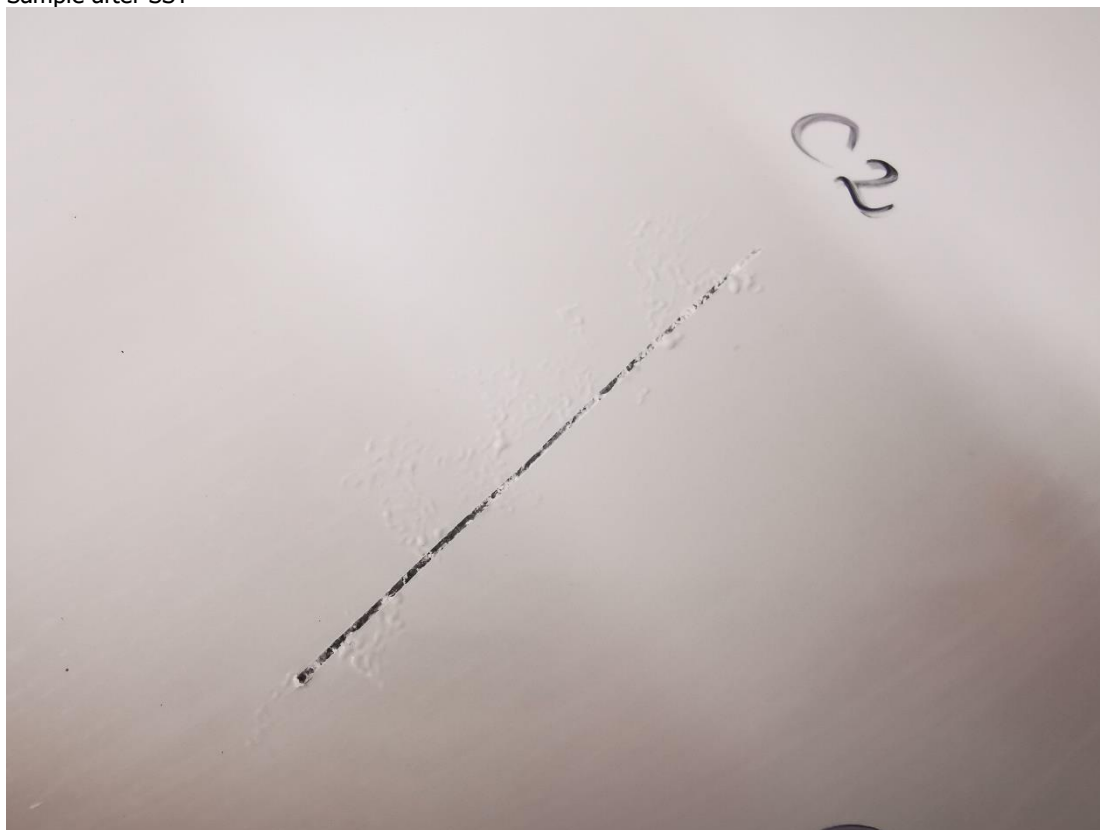
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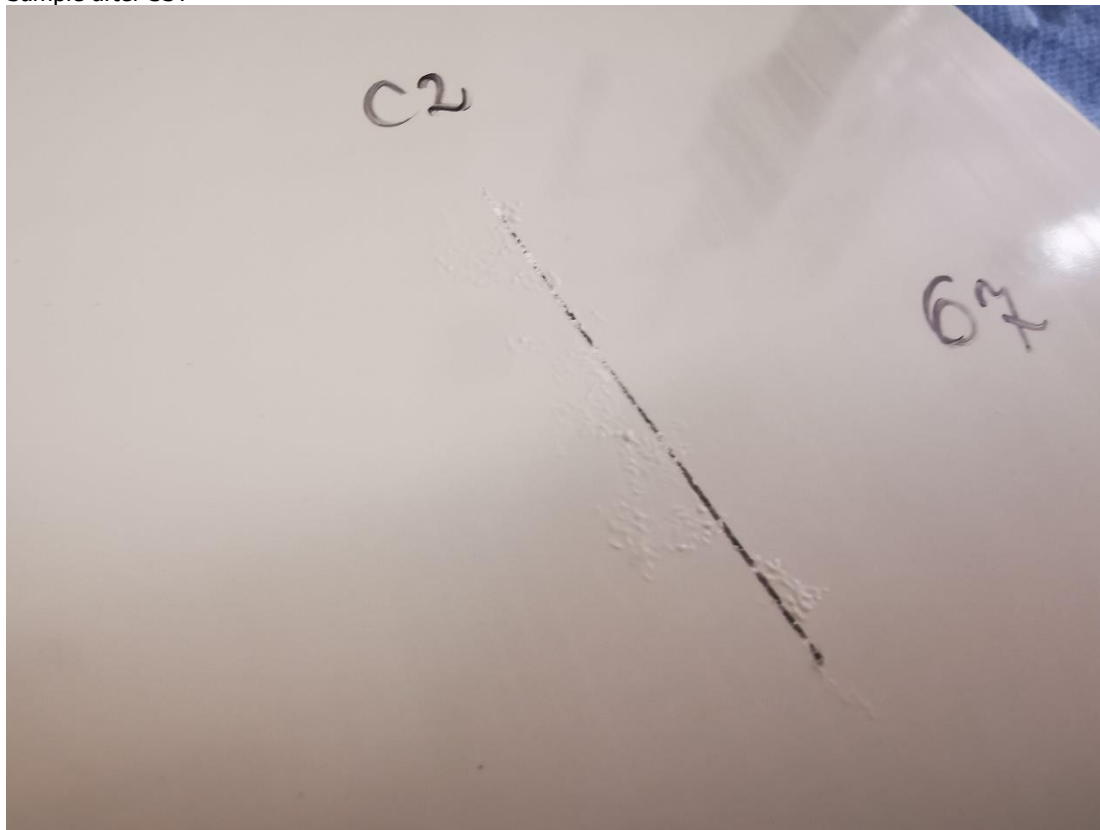
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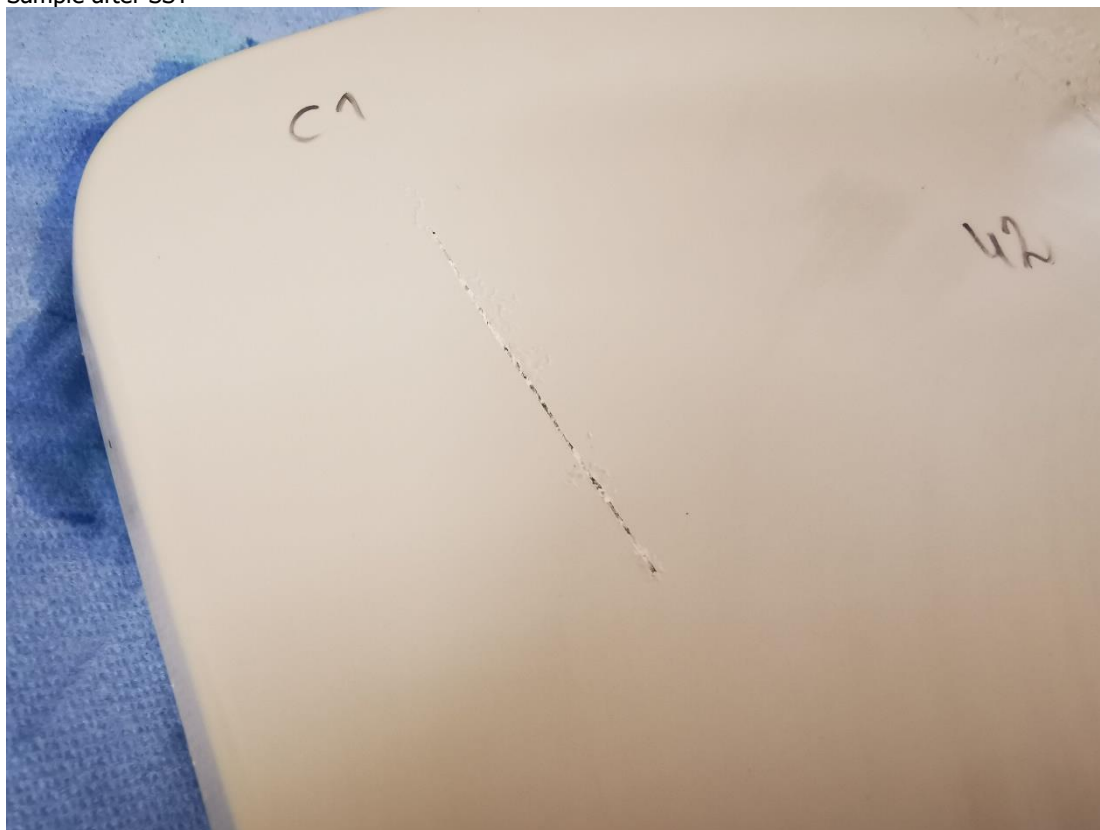
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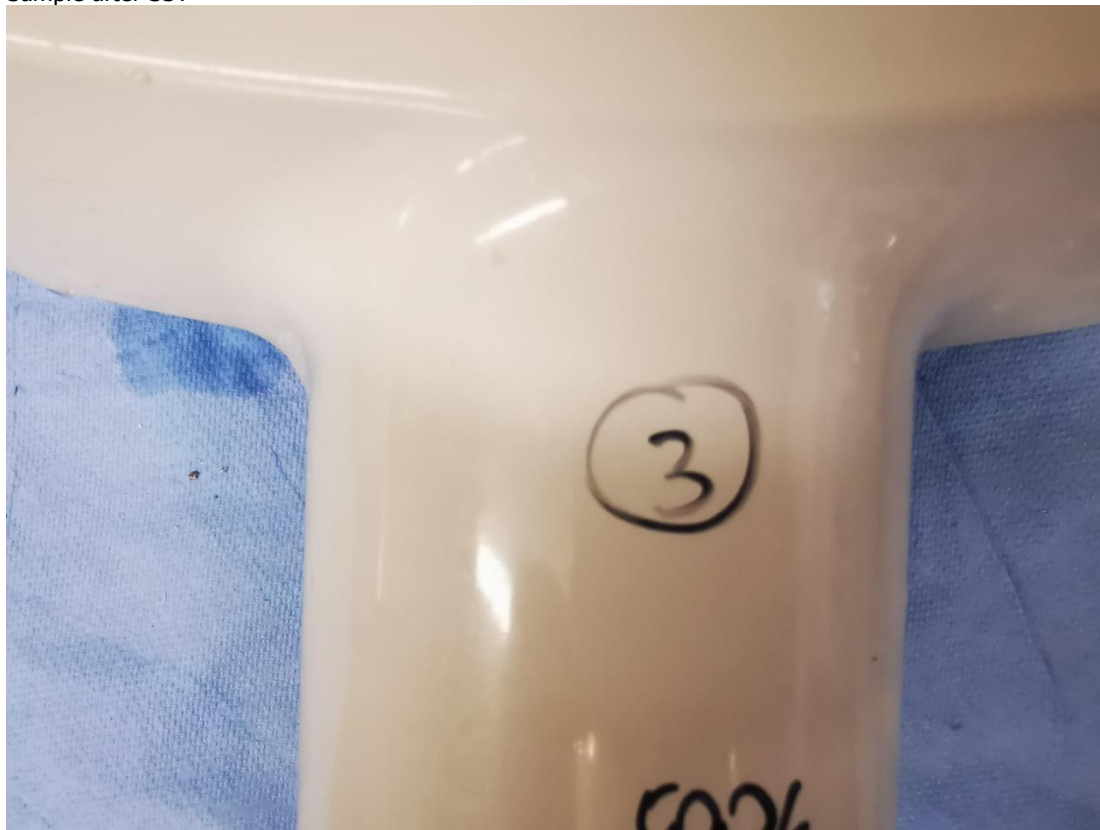
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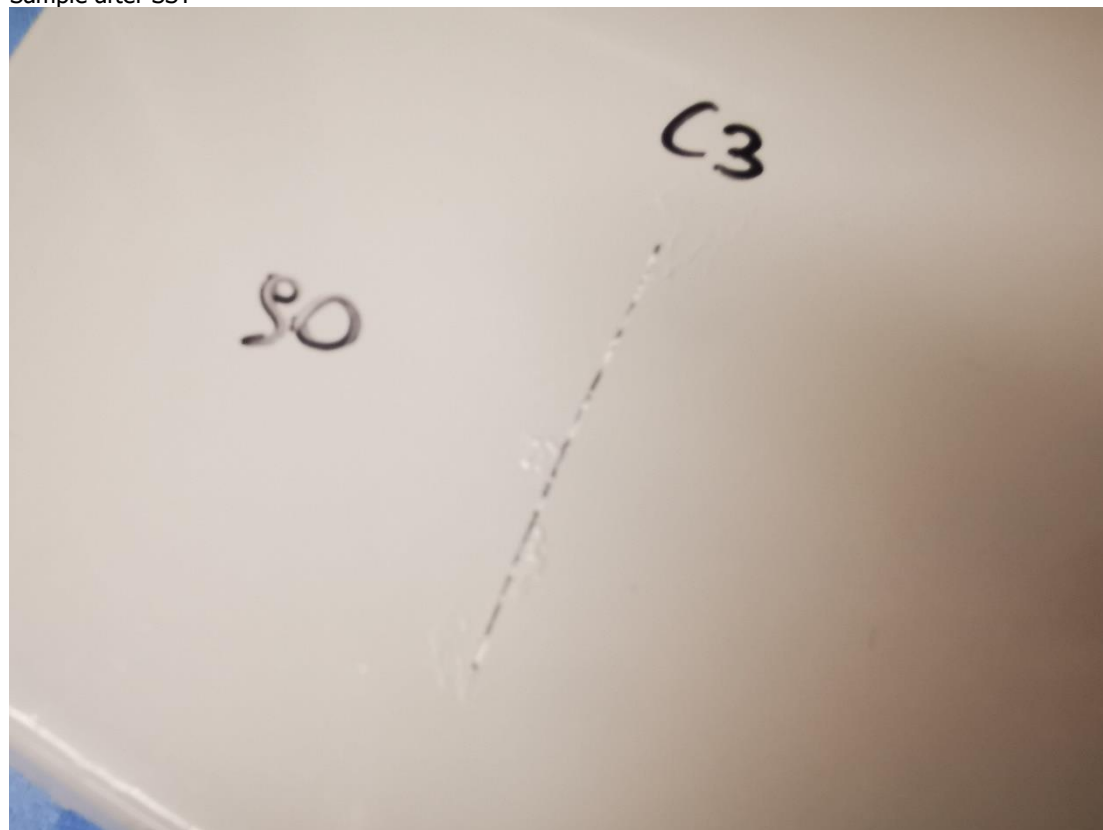
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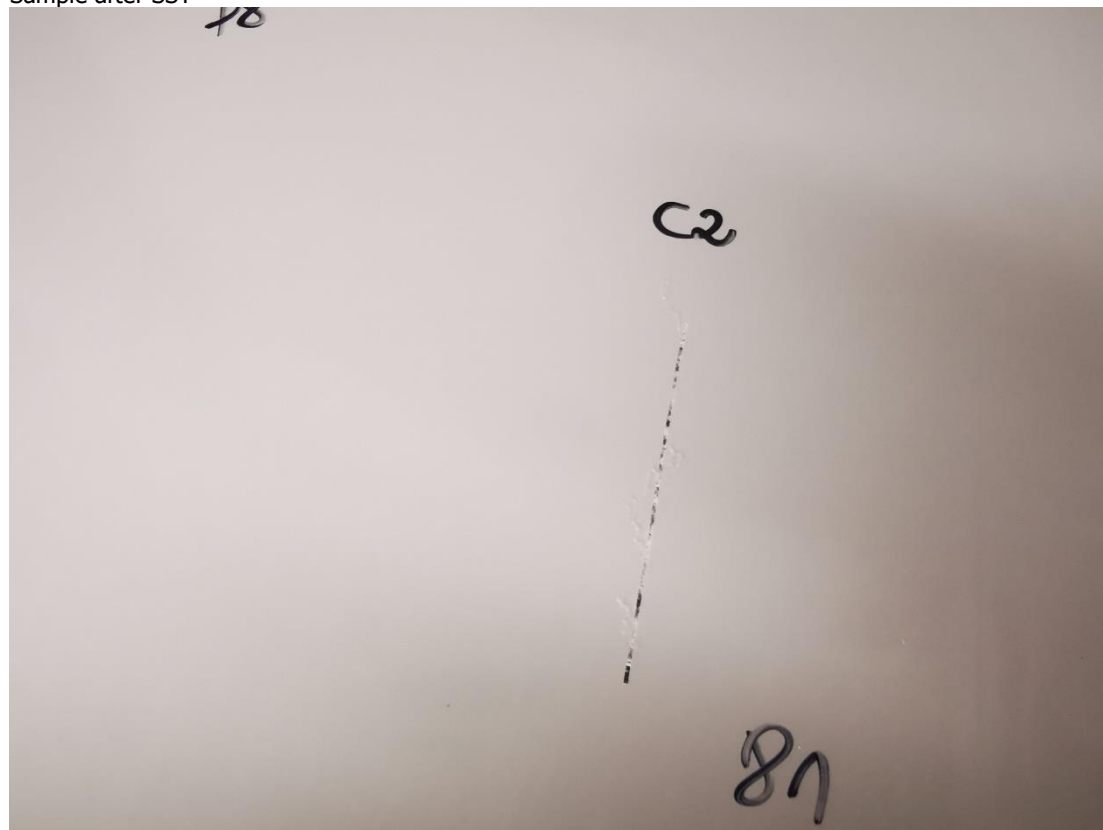
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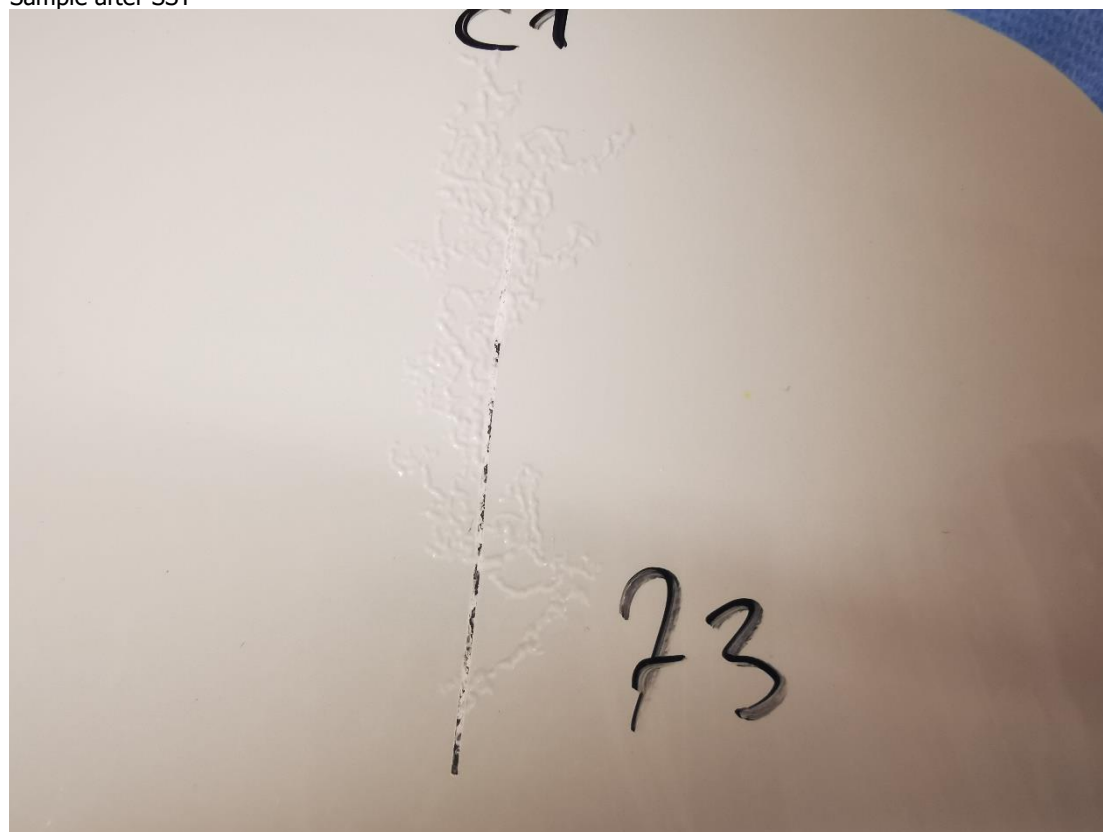
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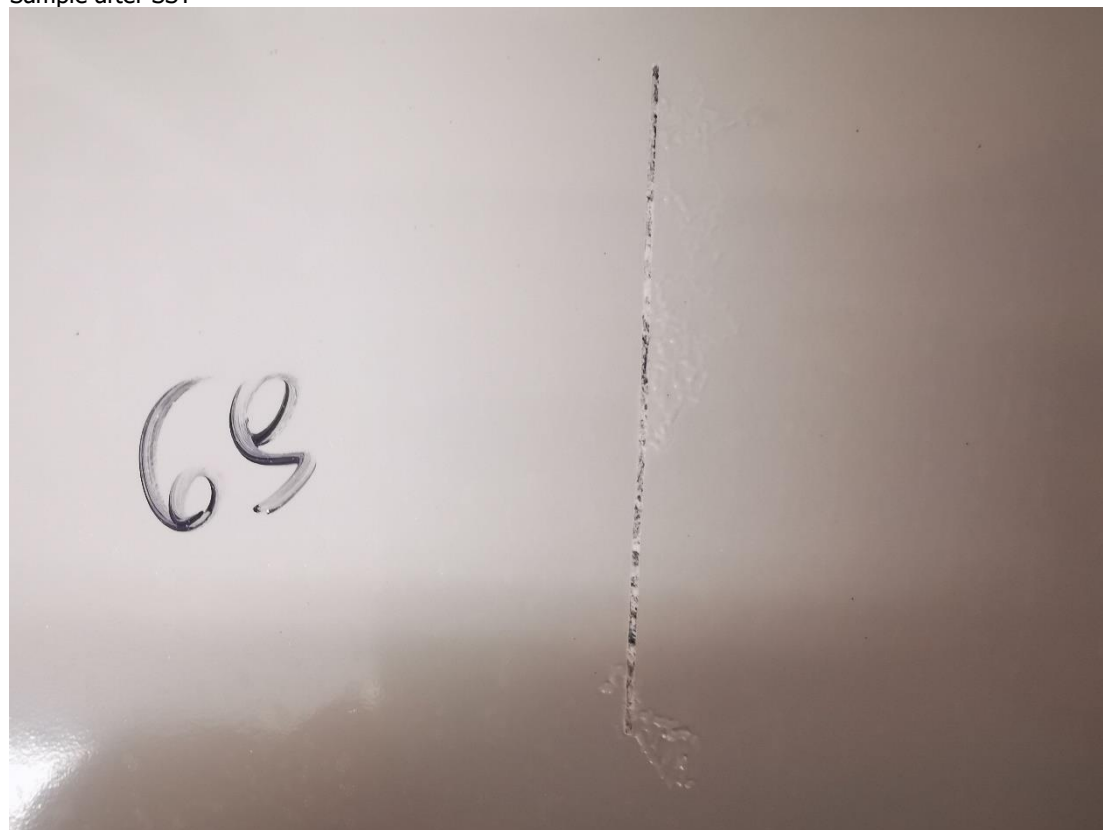
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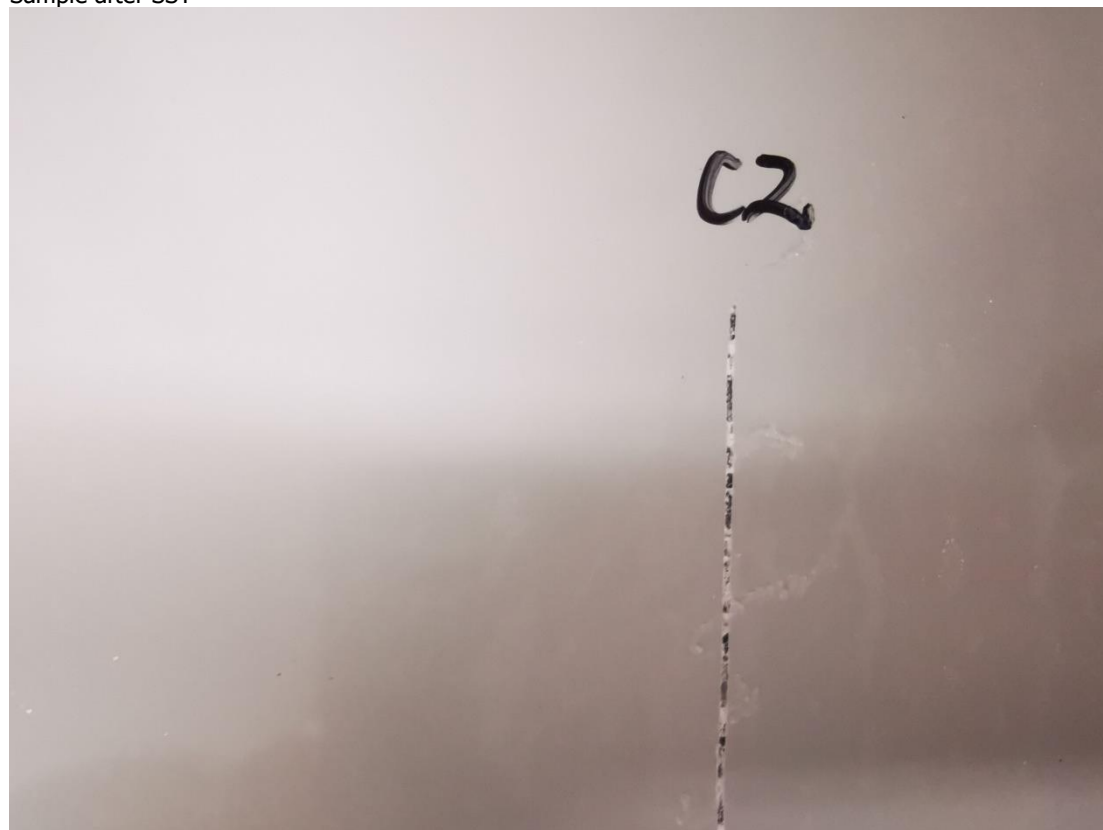
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Sample after SST



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Sample	after	SST	
Sample after SST			

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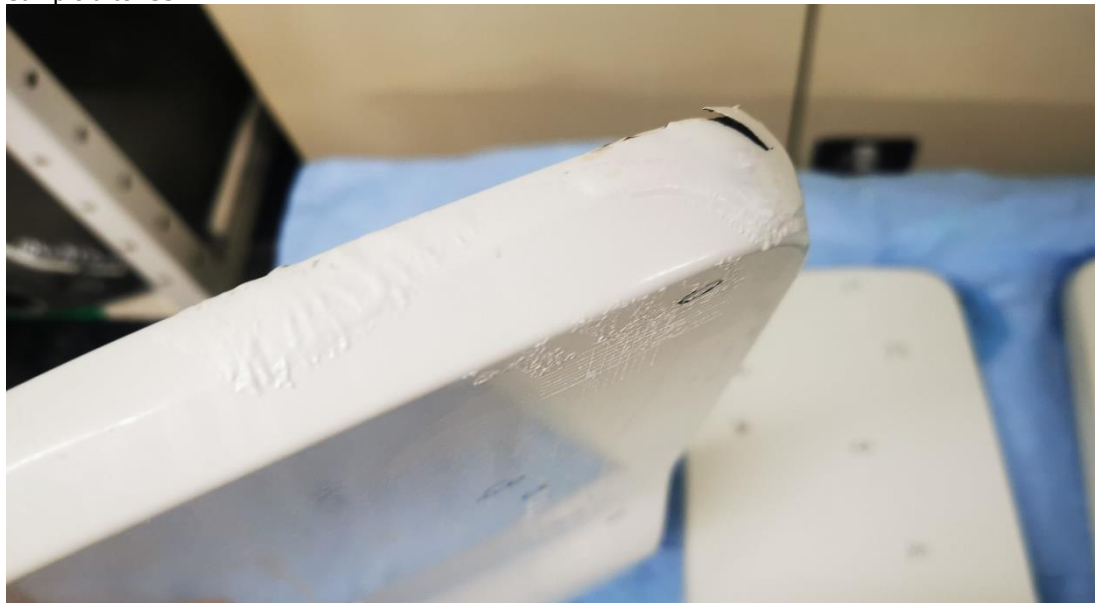
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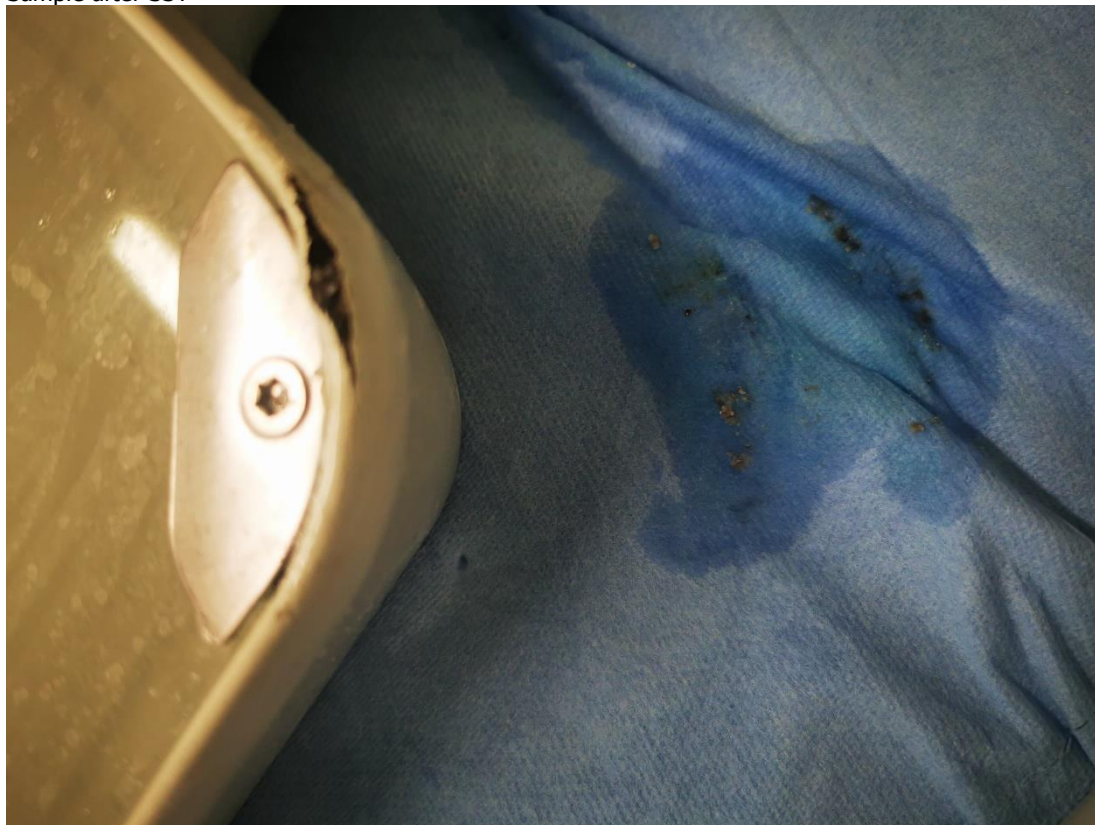
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Sample after SST



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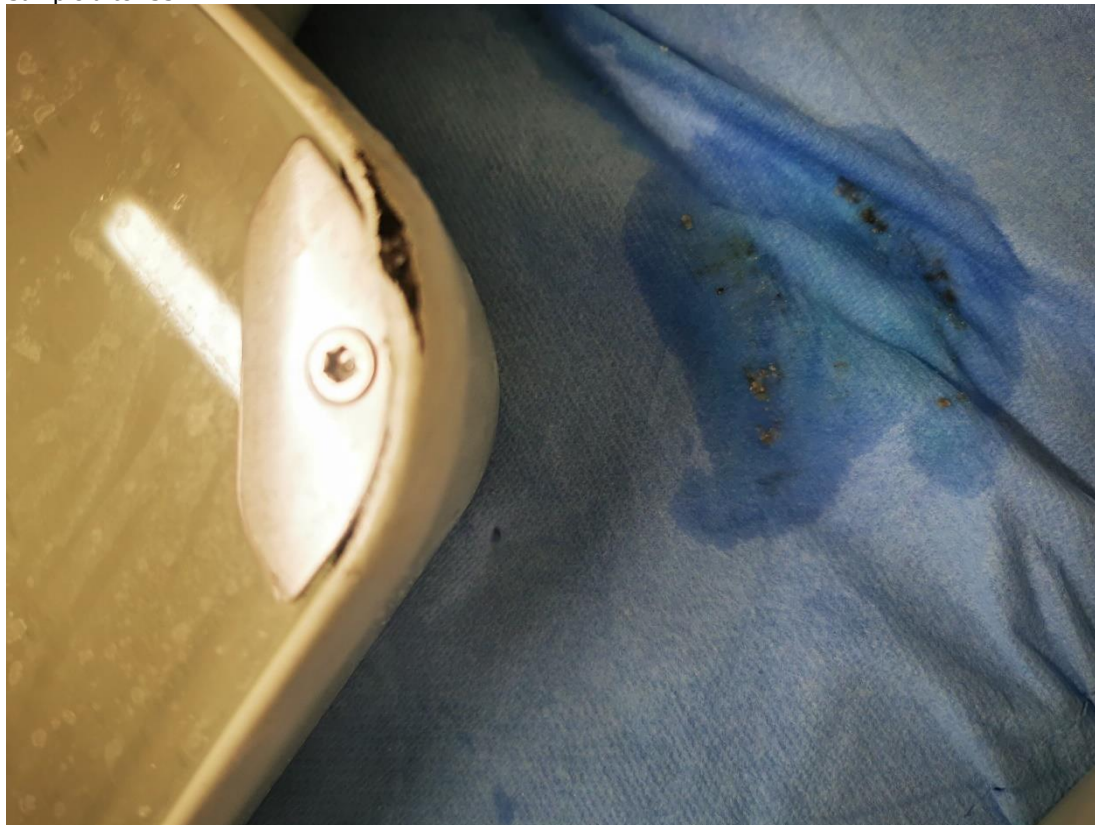
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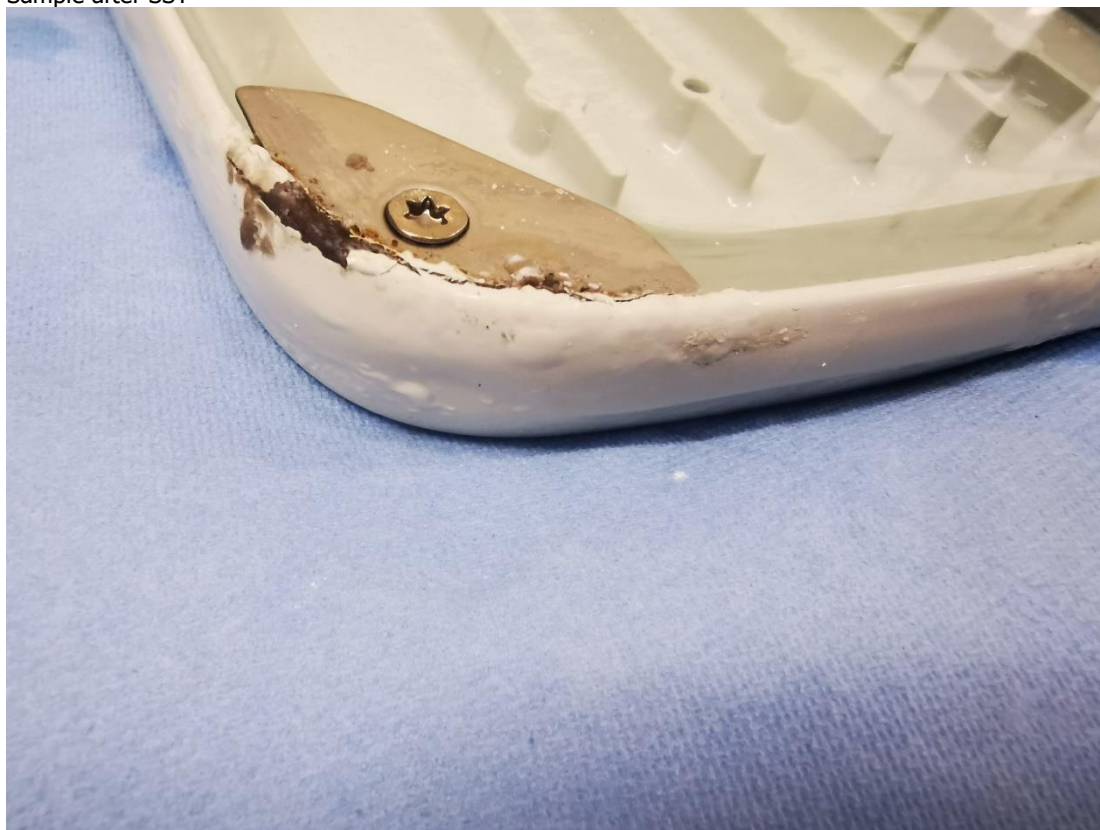
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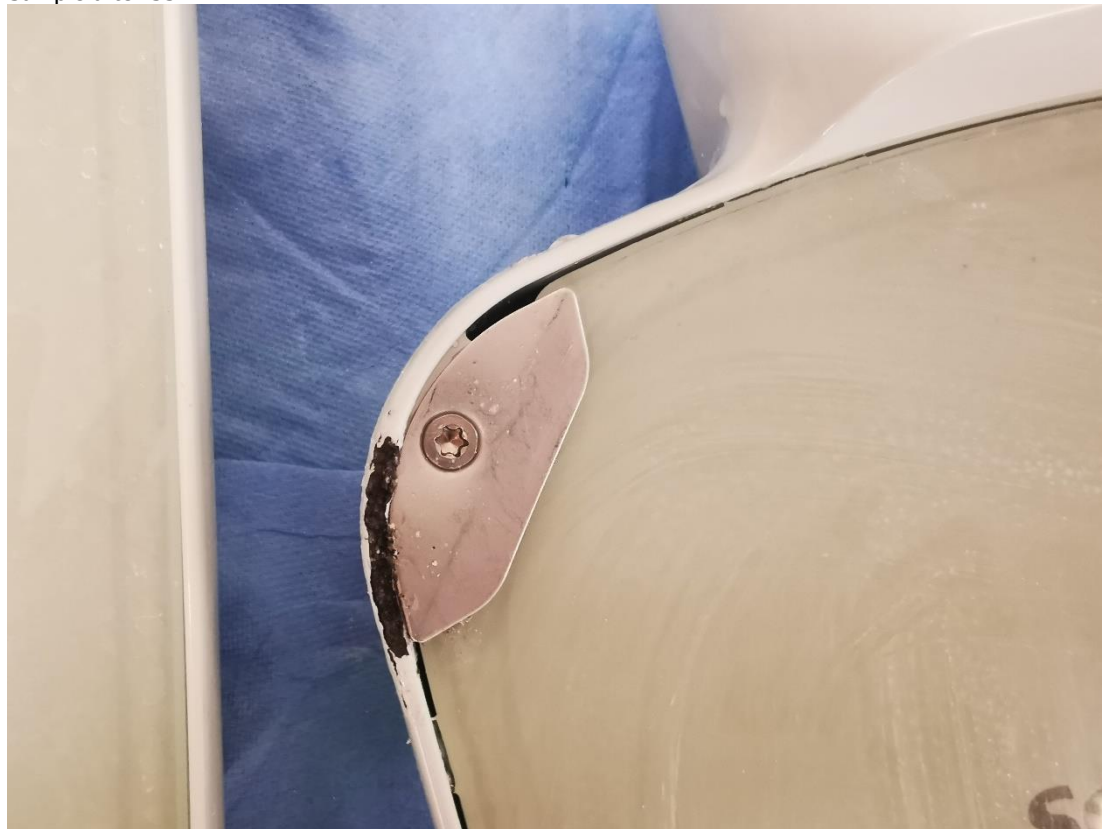
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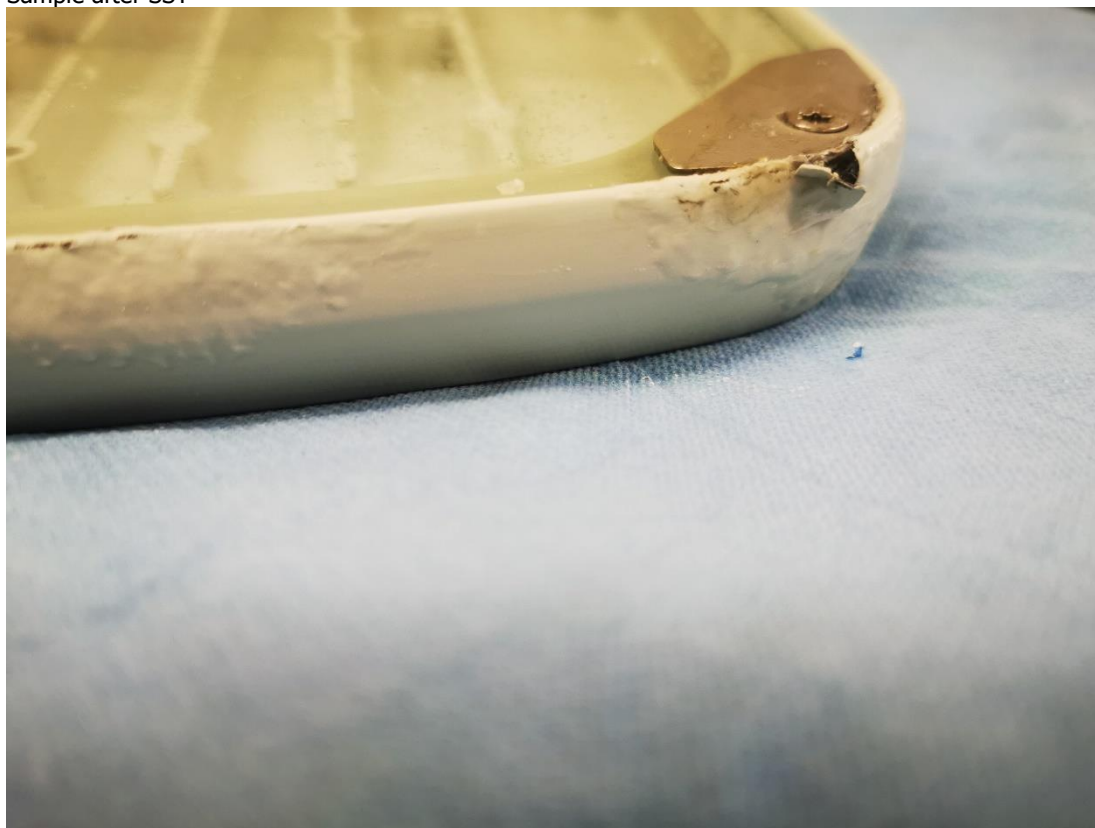
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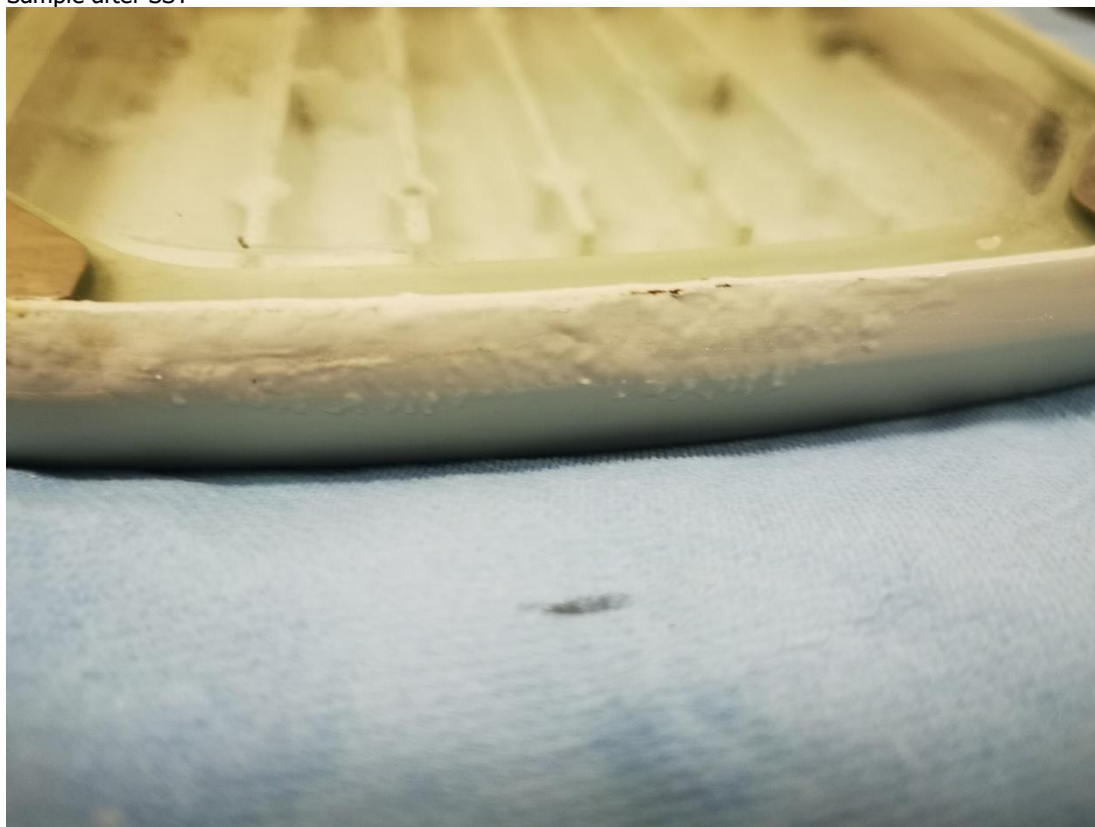
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Sample after SST



**CONCLUSIONS AND REMARKS**

rust penetration length around an edge beyond 10 mm

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