



# DAE HEUNG CO.

## Painting Test Evaluation Sheet

### 1. 발주정보 Ordering information

Company Name	Project Name	Test Date	Test Number
한화시스템	KF-21	2025-01-07	DHC-2501007-6

### 2. 요구 사양 Specification requirements

Process classification	Standard	Color
Pretreatment bottom	N/A	N/A
Primer coat paint	MIL-PRF-23377, TYPE I	YELLOW
Top coat paint(1)	MIL-PRF-85285	AMS-STD-595, No.36231, 회색
Top coat paint(2)	N/A	N/A
Inking	N41B620	BLACK

### 3. 적용 목록 Items applied

추가 목록 첨부 Attachment of additional list

NO	Product name	Part number	Work order number	Quantity
1	하우징, 전자 구성품용	84520111	WO-HSC-H03138-1	7 EA

### 4. 시험 정보 및 결과 Exam information and results

Classification	Standards and related standards	Target	Inspection quantity	Examination results	Decision																
Visual inspection	긁힘, 찌힘, 부풀음, 오렌지 필, 흐름, 주름, 핀홀, 박리, 균열 등 결함이 없을 것. scratch, scratch, swelling, orange peel Flow, wrinkles, pinholes, peeling, cracking These defects are not allowed	제품 Product	전수	이상없음 Fine	PASS																
Masking Inspection	도면과 일치 할 것 must be identical with design plan		전수	이상없음 Fine	PASS																
Silk and Inking	도면과 일치 할 것 must be identical with design plan		전수	이상없음 Fine	PASS																
Tape adhesion test	DHC-0810-71-09_6항에 따라 이상없을 것 According to DHC-0810-71-09 Section 6, there should be no abnormality.		N=2	이상없음 Fine	PASS																
Solvent resistance test	이상 없을 것 Nothing will happen		N=1	이상없음 Fine	PASS																
Coating thickness (μm)	<table border="1"> <thead> <tr> <th>Process classification</th> <th>기준값 Reference value</th> <th>누적값 Cumulative value</th> </tr> </thead> <tbody> <tr> <td>Pretreatment bottom</td> <td>N/A</td> <td>N/A</td> </tr> <tr> <td>Primer coat paint</td> <td>15~23 μm</td> <td>15~23 μm</td> </tr> <tr> <td>Top coat paint(1)</td> <td>43~58 μm</td> <td>58~81 μm</td> </tr> <tr> <td>Top coat paint(2)</td> <td>N/A</td> <td>N/A</td> </tr> </tbody> </table>	Process classification	기준값 Reference value	누적값 Cumulative value	Pretreatment bottom	N/A	N/A	Primer coat paint	15~23 μm	15~23 μm	Top coat paint(1)	43~58 μm	58~81 μm	Top coat paint(2)	N/A	N/A	제품 Product or 시편 Specimen	Target	Inspection quantity	Min / Max / Average	Decision
	Process classification	기준값 Reference value	누적값 Cumulative value																		
	Pretreatment bottom	N/A	N/A																		
	Primer coat paint	15~23 μm	15~23 μm																		
Top coat paint(1)	43~58 μm	58~81 μm																			
Top coat paint(2)	N/A	N/A																			
	N=2	N/A	N/A	N/A	N/A																
	N=2	16.4 μm	20.2 μm	18.1 μm	PASS																
	N=2	62.0 μm	67.7 μm	64.8 μm	PASS																
Gloss (GU/60°)	Top coat paint(1)	0~5 GU	N/A	N/A	N/A																
	Top coat paint(2)	N/A	N/A	N/A	N/A																
Wet adhesion test	ASTM D3359 4A 적용 Applied	시편 Specimen	N=1	Specimen No. DWT-250018	PASS																
Dry adhesion test	KS M ISO 2409- 밀착성시험방법 표1의 "구분1" 적용 Knife Adhesion Test Method Category 1 of Table 1 apply	시편 Specimen	N=1	이상없음 Fine	PASS																

Decision 위 내용은 당사 도장 프로세스에 따라 시험 관리하였으며, 결과에 따라 자체 합격으로 인정함.  
**In fact, it is considered acceptance of self.**

Note) 이 성적서는 시험자 또는 승인자의 승인없이 수정 또는 재발행 불가함.

**This certificate can not be modified or reissued without the approval of the tester or approver.**

Date : 2025. 01. 07.

Inspector : 공 혜 미 Hye-Mi Kong

Approver : 김 윤 태 Yun-Tae Kim

DAE HEUNG CO.

경기도 시흥시 산기대학로 268

HEAD OFFICE & FACTORY : 203-3NA B/L , SIWHAGONGDAN ,  
SANKIDAEHACK-RO , SIHEUNG-CITY , GYEONGGI-DO , KOREA

E-MAIL : dhikh@dhckr.com Tel) 031-499-3458~9

