

QUALITY REQUIREMENTS**Hand made glass shades****1. The subject of quality requirements**

The subject of quality requirements are qualitative criteria for glass shades hand made by blowing method.

2. Division criteria of glass shades**2/1. In view of finish**

Depending on finish the glass shades are divided on:

O- clear glass

1- opal glass

2/2. In view of dimensions.

Depending on dimensions the glass shades are divided on:

to 180mm- small

above 180 to 300mm- medium

above 300 to 400mm- large

above 400mm- very large

3. The color of glass

Depending on finish:

Clear glass – are allowed faint shade colors: green, blue or pink.

Opal glass – are allowed slightly visible differences

4. Defects of melted glass according to the table 1.

Defect's name	Appearance of defect
Glassy inclusions	Slightly visible on highlighted glass shades from distance approx. 50 cm are acceptable.
4/1. Streaks	Slightly visible on highlighted glass shades from distance approx. 50 cm are acceptable.
4/2. Threads	Are acceptable slightly weakly perceptible or weakly visible.

Miejsce prowadzenia działalności gospodarczej
Company business address

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4/3. Black dots, stones	Unacceptable
Gas inclusions. 4/4. Cracking and open air bubbles	Unacceptable
4/5. Non cracking air bubbles in dimension to 0,5 mm	Are acceptable not concentrated, not-numerously occurring on whole surface of glass
4/6. Air bubbles above 0,5 to 3 mm	Acceptable
	a) 1 pcs on small shades
	b) 2 pcs not concentrated on medium shades
	c) 3 psc not concentrated on large and very large shades
4/7. Air bubbles above 3 to 4 mm	Acceptable
	a) 2 pcs not concentrated on large and very large shades
4/8. Air bubbles above 4 to 5 mm	Acceptable
	a) 1 pcs in shades large and very large in place through which does not pass the main stream of light
4/9. Air bubbles above 5 mm	Unacceptable
4/10. Opal glass transparency	Using high power bulbs the minimum visibility of filament, is acceptable.

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5. Realization

5/1. The surface of glass shades should be:

- Smooth and gloss in shades made in clear and in opal glass
- Smooth mat in shades made in clear mat and in opal mat glass
- Smooth gloss or smooth mat in painted shades depending on type of paint used for decoration
- Smooth and decoratively cutted or painted and decoratively cutted.

Dimensions and tolerances must comply with the technical drawing

6. Defects of workmanship according to the table 2.

6/1. Ovality	To 2% of max diameter are acceptable
6/2. Surface waviness	Not flagrant are acceptable
6/3. Marks after mould surface, cavities on surface, seams blurred	Acceptable not much seen in glasses that are not rotated during production (for example in glasses with screw)
6/4. Scratches on the surface	Not visible form distance approx. 50 cm are acceptable
6/5. Chips on decorative surface	Not flagrant are acceptable
6/6. Chips on montage surface	Not flagrant and blurred are acceptable
6/7. Cracks and microcraks	Intentional are not unacceptable

7/1. Balancing of shades

- Without balancing
- Only in case of specific arrangements with the customer

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