


DESCRIPTION			E	C	P
H P D L 	4.4.15.19	At HPDL and PVC , edges shall be machined flush and filed, sanded, or buffed to remove machine marks and sharp edges, and:			
	4.4.15.19.1	VISIBLE OVERLAP (over-filing) shall not exceed:			
	4.4.15.19.1.1	0.005" (0.13 mm) for a maximum length of 2" (50.8 mm) in any 48" (1220 mm) run	●		
	4.4.15.19.1.2	0.005" (0.13 mm) for a maximum length of 1" (25.4 mm) in any 24" (610 mm) run		●	
	4.4.15.19.1.3	NO VISIBLE OVERLAP			●
	4.4.15.19.2	CHIP-OUT shall be inconspicuous when viewed at:			
	4.4.15.19.2.1	72" (1829 mm)	●		
	4.4.15.19.2.2	48" (1220 mm)		●	
	4.4.15.19.2.3	24" (610 mm)			●
	4.4.15.19.3	REMOVAL of color or pattern of face material due to over-machining limited to:			
	4.4.15.19.3.1	3/32" x 4" (2.4 mm x 102 mm) and may not occur within 48" (1220 mm) of a similar occurrence.	●		
	4.4.15.19.3.2	1/16" x 1-1/2" (1.6 mm x 38.1 mm) and may not occur within 60" (1524 mm) of a similar occurrence.		●	
	4.4.15.19.3.3	1/16" x 4" (1.6 mm x 102 mm) and may not occur within 72" (1829 mm) of a similar occurrence.			●