PINCH MARKS
An area of the extruded sheet that appears to have bonded to itself. Generally this will appear as a small “bow-tie”.

DIE LINE
Straight sharp lines in either cap surface or substrate the is visible in the finished part, probable cause-material hang up in die creating an interruption of the flow of polymer during extrusion process.

GEL/BUMP
Spherically shaped defect, potentially visible in both unformed and formed sheet, typically non-contrasting and originates from an unmelted portion of the resin. Often identified with a “tail” in the extrusion direction.

DIE DROOL
Degraded talc residue the builds up and breaks off from die lip. Generally seen on the backside of sheet. Varies in size and shape.

CONTAMINATION
Incompatible material within the substrate that manifests itself in the formed part as a protrusion in “A” surface. Typically will see a correlating depression in the backside of the formed sheet.

BREAKOFF - DEGRADING MATERIAL
Appears as a sharp line followed by a deposit of material that typically looks like a small ball or bump.

ORANGE PEEL APPEARANCE
Typically seen in high gloss surfaces as a wavy pattern of light and dark areas. Depending on the slope of the material, the light is reflected in various directions.

BREAKOFF - COLOR
Swirling appearance of a contrasting color.

MOTTLING APPEARANCE
Similar to orange peel, but larger, more cloud-like patches.

POCK MARK/DIMPLE
Circular depression generally seen on the backside surface of the sheet. Depending on sheet thickness/depth of draw minor pock marks may not appear in the “A” surface after forming.

PINHOLE
Concave recess in “A” surface of sheet-probable cause-out gassing during forming process due to moisture in the cap resin.

BLACK SPECK
Typically carbonized or chared material, from either resin pellet or extruder, that is generally seen in flat sheet surface.

PIT
Concave defect circular in shape and generally void of material in the area or poorly dispersed color concentrate. Size varies and can be on both “A” and “B” surfaces.

PATTERN WASHOUT
Embossed pattern appears very shallow or undefined.
DEFECT DEFINITIONS

**PHANTOM LINES**
An interruption or restriction of resin flow through the die. Obvious weld line on B surface, typically visible after forming.

**GAUGE VARIATION**
Thickness variation across the web width of the extruded sheet. Variation exceeds PMC Standard or specified tolerances determined by the customer.

**CAP OPACITY**
Does not match Master Sheet (not opaque) core color may show through, changing the color appearance.

**GLOSS**
Gloss evaluation, typically in smooth products, appears to be more or less reflective than the target or expected results. This is sometimes referred to as more dull or more shiny.

**OFF COLOR**
Expected color either visually does not match the target or the numeric readings exceed the customers specified tolerance.

**MOISTURE**
Where excessive moisture in the material evaporates during the extrusion process and leaves small visual depressions in the surface of the product.

**CORE/ANGEL HAIRS**
Thin pieces of plastic or masking from the shear process that can be trapped between sheets and cause an impression or remain imbedded.

**OUT OF SPEC- LENGTH, WIDTH**
Dimension exceeds specified tolerances determined by the customer.

**CORE SHOWING**
Cap or laminate does not cover entire core, leaving core exposed.

**ROLL BOUNCE**
An area of the product where the stack rolls were opened or the bead forced the stack roll to open. This appears as an semi-irregular line in the tranverse direction of the sheet.

**DELAMINATION**
When two components in a product will not adhere completely to each other.

**WARPED MATERIAL**
Sheet material that bows or lifts from a flat surface beyond the acceptable tolerance.

**FLOW LINES**
An interruption or restriction of resin flow through the die. Less severe than a Phantom line, can’t feel, and typically visible after forming.

**DEFECT REFERENCE CARD**