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| Milestone AV Technologies TECHNICAL SPECIFICATION | |
| Number: | 8900-000002 |
| Title: | Materials & Finishing Specification |
| Revision: | 35 |
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Revision History

| Date | Rev | Reason for Change |
|----------|-----|---|
| 3/1/05 | A | ECO 1746. Initial Release |
| 4/27/05 | B | ECO 1768. Added finishing codes 267, 272, 273, and 274 |
| 8/19/05 | C | ECO 1934. Added flammability requirement for plastic materials |
| 1/16/06 | D | ECO 2134. Multiple changes including: Changed to CSAV and included Sanus Systems in the scope, changed title to include materials, added specifications for glass and wood materials. Added appearance criteria. |
| 11/21/06 | E | ECO 2622. Added reference to BS6206 for tempered glass. Fixed typo on manufacturer column for 012 finish code. Added color samples to paint appearance criteria. Added finishing codes 005, 006, 011, 027, 029, 030, 031, 032, 033, 034, 035, 036, 037 and 293. |
| 2/1/07 | F | ECO 2825. Added finishing codes 038, 039, 040, 041, 042, 043, 044 and 045. |
| 2/26/07 | G | ECO 2954. Added finishing codes 046, 047, 048, 049, 050, 051, 052, 053 and 295. |
| 5/11/07 | H | ECO 3137. Added finishing codes 054, 055, 056, 057, 058, 059, 060, 061, 062, 063, 064, 065, 066, 067 and 253. |
| 7/24/07 | I | ECO 5156. Added finishing codes 068, 069, 070 and 284. Removed "Specification Pending" from finishing codes 061 through 065. |
| 8/14/07 | J | ECO 5221. Added finishing code 071. |
| 11/20/07 | K | ECO 5461. Added note to section 4.6.1 specifying minimum plastic requirements per UL standard. Added 3.1.6 note - UL94 as a reference document. Added liquid paint specification. |
| 7/1/08 | L | ECO 6083. Administrative change to company name from CSAV to Milestone. Removed section 4.6.1 as section is no longer needed in light of CoC meeting UL requirements. Added Finishing codes 76 – 79 (color codes for Cisco product) and 289. |
| 8/1/08 | M | ECO 6148. Corrected ECO # for rev L and added leading zeros to finish codes 077-079. Changed the CSAV logo to Milestone. Added finish codes 072-075, 254, 278, 300-303. Changed Morton to Rohm & Haas because of buyout. |
| 9/10/08 | N | ECO 6276. Added finish code 304 |
| 10/6/08 | O | ECO 6419. Added ECO #'s for traceability to rev changes M and N. Added finish code 080. |
| 10/15/08 | P | ECO 6443. Added finish code 081. |
| 12/23/08 | 00 | ECO 500000091. Added finish code 084 and changed revision to numerical accommodate SAP conversion. |
| 02/16/09 | 01 | ECO 500000212. Added finish code 085 and material code 305. Changed the paint color description on 044 to Titanium. |
| 3/26/09 | 02 | ECO 500000481. Added finish code 082 and 083. |
| 04/10/09 | 03 | ECO 500000697. Added material codes 306 and 307. |
| 06/19/09 | 04 | ECO 500000842. Updated finish code 060. Added plating code 086 and Material Codes 308 and 309. |
| 7/13/09 | 05 | ECO 500001107. Added Finish Codes 087, 088, 310, 311, 312 |
| 7/29/09 | 06 | ECO 500001193. Added Finish Code 089 |
| 9/02/09 | 07 | ECO 500001375. Added finish code 090 and updated codes 087 and 089. |
| 9/22/09 | 08 | ECO 500001442. Added finish codes 091- 096 |
| 12/22/09 | 09 | ECO 500001660. Added material codes 097 and 313. |
| 8/13/10 | 10 | ECO 500002077. Modified finish code 029 to add Cardinal Industrial Finishes T006-BK66, added new code for wood finish (code 099), soft touch paint (code 100), and outdoor powder coat (code 098), modified finish code 088 under and over coat. |
| 3/4/11 | 11 | ECO 500003714. Added finish codes 101, 104, 105, 106, 107, Added note for min plating thickness required by UL for zinc in outdoor finishes |
| 3/22/11 | 12 | ECO 50004280. Added finish codes 102, 114, 115, Added CARB compliance requirements to section 4.8, Updated finish code 088 with minimum plating thickness, updated out of date manufacturers for multiple codes, Removed obsolete codes 006, 096, and 026 |
| 5/18/11 | 13 | ECO 500004489. Added Die casting section 4.9 and added die cast specifications to section 3.0, Added new finish codes 111, 113, 116, 117 |

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| 12/15/11 | 14 | ECO 500005413, Updated glass requirements section 4.7.1, Added Panolam - W370 Noble Mahogany to finish code 104, Added new codes 120, 121, 122, 123, 126 |
| 1/05/12 | 15 | ECO 5000005502. Added finish code 109, 110, 127 |
| 2/07/12 | 16 | ECO 5000005558. Added finish code 103, 112, 119, 125, 128, corrected finish code 115 typo |
| 4/18/2012 | 17 | ECO 500005826. Changed 013 from paint to coating, added e-cote description, added US & AP manufacturers for e-cote, and updated section 4.4 for e-cote requirements. Updated finish code 119 and 128, Added finish code 118, removed reference to primer in section 4.4, Updated code 029 because cardinal replaced T006-BK66 with T006-BK05. Added requirement plated threads must pass thread gauge in section 4.5.2 |
| 5/31/2012 | 18 | ECO 500006036. Added United States manufacturer for code 106, Added codes 124, 131, 132, and 133 |
| 10/23/12 | 19 | ECO 500006541. Added codes 129, 130, 134, 135. Updated codes for clarification: Added Anodized to Paint/Texture Other column to code 086 and 131, re-orientated code Color/Plate description for codes 126 and 127, changed Manufacture from vendor supplying parts to paint vendor on codes 106, 124, and 133 |
| 1/8/2013 | 20 | ECO 500006912. Section 4.0: Added United States manufacturer for code 107, and added new codes 108, 136, 139, 140, 314, 315, 316 and 266. |
| 4/24/2013 | 21 | ECO 500007791. Section 3.0 Added 3.1.13 Section 4.0: Added new codes 141, 142, 143, 144, 145, 317, 318, 319 and 320 Section 4.3: Added 4.3.2, 4.3.5 and updated 4.3.3 Section 4.3.4 and 4.4.6.2: Added metric measurements Section 4.8.2: Added 4.8.2.2, 4.8.2.3, 4.8.2.4 and 4.8.2.5 appearance criteria for wood or composite panels Added Figure 1 - Milestone Appearance Acceptance Criteria Size Template |
| 8/6/2013 | 22 | ECO 500008201 Added new finish codes 146, 147, 148, 149, 150, 151, 152, 321 and 322 |
| 8/13/2013 | 23 | ECO 500008529: Added new material/finish codes 153, 323, and 324 Section 4.1: Deleted "Dupont" from the manufacturer column for code 136, deleted "Soft Touch" from the manufacturer column for codes 142 and 248, and deleted "Soft Touch" from the Paint Texture/Other column for code 319. |
| 11/1/2013 | 24 | ECO 500008645: Added material codes 325 and 326 |
| Not Applicable | 25 | ECO 500007682: Cancelled ECO - change to add weld standard rejected by Tracy Hartwig |
| 2/19/2014 | 26 | ECO 500009391: Added finish code 154; added material code 327 |
| 4/15/2015 | 27 | ECO 500011451: Added finish codes 155, 156 and 157; added material codes 328, 329, 330 and 331; added India paint manufacturer to finish codes 002, 012, 022 and 024 |
| 10/13/2015 | 28 | ECO 500012349: Added finish codes 158, 159 and 160; added material codes 332, 333 and 334 |
| 4/11/2016 | 29 | ECO 500013502: Changed manufacturer finish code information for 158 and 159; added section 4.10 hot-rolled and cold-rolled steel requirements |
| 8/5/2016 | 30 | ECO 500013951: Added new finish codes 161 and 162; added new material codes 335 and 336; added 8900-000007 Milestone Finish Code -161 Outdoor Paint Test Specification to section 3.0 (3.1.5) |
| 3/23/2017 | 31 | ECO 500015270: Added new material codes 337, 338, 339, 340 and 341 |
| 4/26/2017 | 32 | ECO 500015485: Added new material codes 342, 343, 344, 345, 346, 347 and finish code 163 |
| 9/5/2017 | 33 | ECO 500015940: Added new finish codes 164, 165, 166, 167, 168, 169, 170 and 171 and material codes 348, 349, 350, 351, 352 and 353 |
| 12/7/2017 | 34 | ECO 500016565: Added new finish code 172, added new material codes 354, 355, 356, 357 and 358; added manufacturer information for material codes 348 through 353 |
| 12/21/2017 | 35 | ECO 500016710: Corrected finish code 152 – should be liquid paint; not powdercoat, added material codes 359 and 360 |

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1.0 Purpose

The purpose of this specification is to define the finishing requirements for product purchased by Milestone

2.0 Scope

The scope of this specification includes all parts and component parts of assemblies purchased by Milestone which reference this specification on purchasing documents (Purchase order, part drawing, etc.)

3.0 Documents

3.1 Reference documents

- 3.1.1 ASTM D3359 – 02 Standard Test Methods for Measuring Adhesion by Tape Test
- 3.1.2 ANSI A208.2 – 2002 Medium Density Fiberboard for Internal Use
- 3.1.3 ANSI A208.1 – 1999 Particleboard, Mat-Formed Wood
- 3.1.4 Milestone Purchasing Specification 8900-000001
- 3.1.5 Milestone 8900-000007 Finish Code -161 Outdoor Paint Test Specification
- 3.1.6 BS6206:1981 Appendix B Specification for impact performance requirements for flat safety glass and safety plastics for use in buildings
- 3.1.7 UL94 Tests for Flammability of Plastic Materials for Parts in Devices and Appliances
- 3.1.8 Airborne Toxic Control Measure (ATCM) to Reduce Formaldehyde Emissions from Composite Wood Products [Sections 93120 to 93120.12, title 17, California Code of Regulations (CCR)]
- 3.1.9 ASTM B85 Standard Specification for Aluminum Alloy Die Castings
- 3.1.10 NADCA A-3-1-09: Product Specification Standards for Die Castings/2009 – Aluminum Alloys, Chemical Compositions
- 3.1.11 ASTM E155 Standard Reference Radiographs for Inspection of Aluminum and Magnesium Castings
- 3.1.12 UL1678:2004 Section 20 Household, Commercial, and Professional-Use Carts and Stands for Use with Audio-Video Equipment
- 3.1.13 UL2442:2011 Section 61.3 Safety for Wall and Ceiling Mounts and Accessories
- 3.1.14 Milestone Appearance Acceptance Criteria Size Template (see Figure 1 in this specification)

4.0 Requirements

4.1 Finishing/Material codes

The following table lists the finishes designated by the three-digit suffix of the part number. E.g. for part #1021-000004-002, 002 is the finishing code.

| Code | Type | SubType | Color/Plate | Paint Texture/Other | Manufacturer |
|------|------------|------------|-------------|---------------------|--|
| 000 | Unfinished | | | | |
| 001 | Paint | Powdercoat | Black | Smooth | Valspar IF2135 Low Gloss Black <u>or</u> DuPont EFB-408-S3 |
| 002 | Paint | Powdercoat | Black | Wrinkle | DuPont Black Wrinkle GFB600W3 <u>or</u> Akzo Nobel 12-7001 Corvel Midnight Black <u>or</u> Paramount U8NO 180ZZ0 (India) |
| 003 | Plating | Normal | Black | Anodized | |
| 004 | Plating | Normal | Clear Zinc | | |
| 005 | Plating | Normal | Black Zinc | | |

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4.1 Finishing/Material codes continued

| Code | Type | SubType | Color/Plate | Paint Texture/Other | Manufacturer |
|------|-----------------|------------|---|---------------------|---|
| 007 | Plating | Normal | Nickel Chrome | | |
| 008 | Paint | Powdercoat | Spartan Bronze | Smooth | DuPont Spartan Bronze PFJ-507-A5 |
| 009 | Heat Treat | | | Case Hardening | |
| 010 | Plating | Normal | Zinc Phosphate | | |
| 011 | Paint | Powdercoat | Platinum Grey | | |
| 012 | Paint | Powdercoat | Pure White | | Sherwin Williams HWS6-20002 POWDURA® Hybrid Powder Coating, Pure White <u>or</u> Akzo Nobel SC19AN (India) |
| 013 | E-Cote | | Black | | PPG Powercron 6000CX Epoxy, Unires Chemical Co., Ltd EEB-060 <u>or</u> EEB-068, NIPPON PAINT POWERNICS EXCEL 2100 F-1 Black, <u>or</u> XinQing JingCheng Paint Co., Ltd JC-01, <u>or</u> HuBeiZhaoYang XiangRui Chemical Co, Ltd F11-51 |
| 014 | Paint | Primer | Grey | | |
| 015 | Plating | Normal | Black Zinc | Baked | |
| 016 | Plating | Flash | Clear Zinc | | |
| 017 | Plating | Normal | Black Oxide | | |
| 018 | Plating | Normal | Nickel Chrome | Rack Plated | |
| 019 | Paint | Powdercoat | Light Grey | Texture | Akzo Nobel 41-7169 Corvel™ Light Grey Texture |
| 020 | Plating | Normal | Clear anodized | | |
| 021 | Plating | Normal | Hard Chrome | | |
| 022 | Paint | Powdercoat | Stardust Silver (Britebond) | | DuPont Stardust Silver III PFA639B6 <u>or</u> Akzo Nobel 23-9430 Britebond™ Stardust Silver <u>or</u> Paramount D6NOO637M8 (India) |
| 023 | Paint | Powdercoat | Flint (Charcoal/ Dark Gray) | | Akzo Nobel 21-7017 Corvel™ Flint Texture |
| 024 | Paint | Powdercoat | Raven Black | | Akzo Nobel 30-7262 Corvel™ Raven Black <u>or</u> Rapid Coat PN 35069 |
| 025 | Plating | Normal | Black Anodized | | |
| 027 | Paint | Powdercoat | Silvadillo Silver | | DuPont Silvadillo PFA500M9 |
| 029 | Paint | Powdercoat | Vulcan Black | | Valspar IF7948M Coal TGIC <u>or</u> Cardinal Industrial Finishes T006-BK05 <u>or</u> Dupont Vulcan Black PFB652S6 |
| 030 | Paint | Liquid | RPM Black | | |
| 031 | Paint | Liquid | RPM Silver | | |
| 032 | Paint | Liquid | RPM White | | |
| 033 | Plating | Normal | Yellow Zinc | | |
| 034 | Paint | Normal | Black_Silver iC Combination Color | | |
| 035 | Die Sublimation | | Cabela's Seclusion 3D-Kolorfusion International | | |

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| Code | Type | SubType | Color/Plate | Paint Texture/Other | Manufacturer |
|------|---------------------|------------|---|---------------------------------------|--|
| 036 | Plating | Normal | Nickel Teflon | | |
| 037 | Paint | Liquid | Piano Black | | |
| 038 | | | Silver Anodized Finish for Aluminum Extruded Pillars (CF) | | |
| 039 | | | Black Anodized Finish for Aluminum Extruded Pillars (CF) | | |
| 040 | | | Hand Sanded Black Lacquer Finish | | |
| 041 | | | Cherry Finish for Component Furniture | | |
| 042 | | | Espresso Finish for Component Furniture | | |
| 043 | | | TS Piano Black Gloss | | |
| 044 | Paint | | Titanium | | Akzo Nobel 23-9435 Britebond™ Black Chrome |
| 045 | Paint | | Bowe White | BBH Spec: EC-1229 | Sherwin Williams #HAT6-90018 POWDURA® Hybrid Powder Coating, Bowe Gray |
| 046 | Paint | Wet Paint | Mat Black | Ltd Product Name: mat black 14 degree | |
| 047 | Paint | AC Lacquer | AC Black | YS | |
| 048 | Paint | Powdercoat | Euro Accurate Silver | YS Bright | DuPont EP9020-0047333 |
| 049 | Paint | Powdercoat | Black Wrinkle | Crackle 4649/3 Euro Wrinkle | DuPont EPIO0400-4000132 |
| 050 | Paint | Powdercoat | High Gloss Black | SF Black | |
| 051 | Paint | Powdercoat | Silver Texture | HF Base | |
| 052 | Paint | | Silver Vein Hybrid | | |
| 053 | Paint | | Taos Silver | | PPG Envirocron PCFP73103 |
| 054 | Paint | Wet Paint | Alusilver | PFFP Metal | |
| 055 | Paint | Wet Paint | Plasilver | PFFP Plastic | |
| 056 | Paint | Wet Paint | Gloss Black | PFFP Feet | |
| 057 | Paint | Powdercoat | PFFPb Black | PFFPb Pillar | |
| 058 | PFFPs Silver Base | | Silver | | |
| 059 | PFFPs Frosted Glass | | | | |

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4.1 Finishing/Material codes continued

| Code | Type | SubType | Color/Plate | Paint Texture/Other | Manufacturer |
|------|---------------------|---------------------|---|---------------------------|---|
| 060 | PFFP2b Smoked Glass | | 50% Visible Light Transmittance, 29% UV Transmittance, and 48% Total Solar Energy Transmittance (PFFP2b SMOKED GLASS) | | |
| 061 | | | Black Lacquer Finish for Natural Furniture | Hand Sanded | |
| 062 | | | Cherry Finish for Natural Furniture | | |
| 063 | | | Maple Finish for Natural Furniture | | |
| 064 | | | Mocha Finish for Natural Furniture | | |
| 065 | Paint | | Black | Textured Matt Wood Finish | |
| 066 | Paint | Powdercoat | Graphite | | Akzo Nobel SM QX116Q Interpon™ |
| 067 | | Anodize | Bright Dip Frost-Kote | | Pioneer Metal Finishing |
| 068 | Plating | | Black | Electroless Nickel | |
| 069 | | Mechanical | | #4 Brushed Stainless | |
| 070 | A-coat | | Autophoretic | | |
| 071 | Plating | | Nickel | Electroless Nickel | |
| 072 | Paint | Textured Powdercoat | VMAV Silver TT272A | | |
| 073 | Paint | Textured Powdercoat | VMAV Black EN320C | | |
| 074 | Material | Clear Glass | | | |
| 075 | Material | Clear glass | Clear glass painted Black on one side | | |
| 076 | Paint | Wet Paint | Stardust Silver color match | | |
| 077 | Paint | Powdercoat | Cisco IP Matte Black | | Cardinal Industrial Finishes H341-BK224 |
| 078 | Paint | Powdercoat | Cisco Metallic Gray | | Cardinal Industrial Finishes H341-GR673 |
| 079 | Paint | Powdercoat | Cisco IP Matte White | | |

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4.1 Finishing/Material codes continued

| Code | Type | SubType | Color/Plate | Paint Texture/Other | Manufacturer |
|------|---------------|--------------------------|--|--|-----------------------|
| 080 | Plating/Paint | Normal/ Powdercoat | Clear zinc plating then Black Powdercoat | Milestone 002 Black Wrinkle Powdercoat Milestone 004 Clear zinc plating | |
| 081 | Paint | Lacquer | Black (textured) | Textured lacquer for TVXX turntables | |
| 082 | Paint | Powder Coat | Aged Bronze | Finish SM MT | Tiger Drylac 38/60090 |
| 083 | Paint | Wet Paint | Aged Bronze | | |
| 084 | Paint | | Chinese Black Pearl | | |
| 085 | Paint | Powdercoat | Basalt Metallic | | |
| 086 | Plating | Normal | 204-R1 Hot Etch Natural | Anodized | |
| 087 | Plating | Normal | Black Anodized, Mil- A-8625C Type 2 Class 2 | Brushed finish: 150 grit. Brushed on all surfaces. Form lines not permissible | |
| 088 | Paint | Paint over black zinc | Black zinc (005) plus Black Outdoor Powder coating (098) | Minimum of 0.00041 " coating thickness for Zinc | |
| 089 | Plating | Normal | Clear Anodized | Brushed finish: 150 grit. Brushed all surfaces. Form lines not permissible | |
| 090 | Wood Finish | | Chocolate Wood Finish, 30 Sheen | | |
| 091 | Wood Finish | Melamine | Nutmeg Cherry # W 272 <u>or</u> approved equivalent | | Panolam |
| 092 | Wood Finish | Melamine | Select Walnut #W 194 <u>or</u> approved equivalent | | Panolam |
| 093 | Wood Finish | Melamine | Ebony Sand # P 895 <u>or</u> approved equivalent | | Panolam |

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4.1 Finishing/Material codes continued

| Code | Type | Sub Type | Color/Plate | Paint Texture/Other | Manufacturer |
|------|----------------|-------------|--|-----------------------|--|
| 094 | Wood Finish | Melamine | Country Maple # W256 or approved equivalent | | Panolam |
| 095 | Wood Finish | Melamine | Black Cathedral Ash G2S or approved equivalent | Black Ash Wood Finish | Panolam |
| 097 | Plating | Normal | Clear Anodized | #1 Polished | |
| 098 | Paint | Powdercoat | Black Outdoor Powder coating | | HeShan DongXu Chemical Co. Ltd Outdoor low-light black powder PL5950 |
| 099 | Wood Finish | | NC, 30 sheen, chestnut finish | | Circle and Yuefeng |
| 100 | Paint | Soft touch | Black | Soft touch | Manfield Coatings 503 series |
| 101 | Plating | | Bright Dipped Chrome | | Jurong metal product company |
| 102 | Vacuum coating | | Chrome | | Jurong metal product company |
| 103 | Paint | | Gloss Black | | Qianrui Chemical Industrial (Huizhou) Co., Ltd. |
| 104 | Wood Finish | | Mahogany | | Uniboard USA LLC or Panolam - W370 Noble Mahogany |
| 105 | Wood Finish | | Black | | Uniboard USA LLC |
| 106 | Paint | | Silver texture | | Jurong metal product company or Cardinal Silver Texture T391-GR1031 |
| 107 | Paint | | Black texture | | Jurong metal product company |
| 108 | Paint | Powder coat | Gun metal | | Dongrong Metal Products Co., Ltd |
| 109 | Wood Finish | Laminate | Graphite/ Gun metal | | Omnova Carbon Fiber thermofoil |
| 110 | Wood Finish | Laminate | Brushed Stainless | | PFA60 Negotiating in Geneva melamine |
| 111 | Paint | Liquid | Vulcan Black | | Dong Guan Xin Yi Chemical Paint Co. Ltd Zhuhai Kai Jun Precision Plastic Products Co, Ltd |
| 112 | Plating | | Black Phosphate | | |
| 113 | Wood Finish | Melamine | Ebony Sand | | Panolam |
| 114 | Paint | | Silver Hammertone Semi gloss | | Cardinal T064-GR05 |
| 115 | Paint | | RAL7035 Gray Lite Texture 89/71530 | | Tiger Drylac |

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| Code | Type | Sub Type | Color/Plate | Paint Texture/Other | Manufacturer |
|------|---------------|------------------------|--|--|---|
| 116 | Painted ABS | ABS | White ABS (251) painted Pure White RAL9003 | | Sherwin-Williams |
| 117 | Paint | | Silver Fine Texture | | Tiger Drylac 09/90530 |
| 118 | Paint | Powder coat | Ship Black | | Sherwin-Williams "New Rockwell Black texture" PBT2-20026 <u>or</u> Ningbo YinZhou PULITE Powder Coating factory PE304M.PT309P.PT404XB.PJ001W <u>or</u> FUMEIQI Industry Co., Ltd Black Powder |
| 119 | Paint | Powdercoat | White | Wrinkle | CARDINAL C031-WH120 WHITE RIVER |
| 120 | Lacquer | | Leggy (Antique Black) | | QIANRUI CHEMICAL INDUSTRIAL (HUIZHOU) CO.LTD |
| 121 | Lacquer | | Craftsman (Walnut) | | QIANRUI CHEMICAL INDUSTRIAL (HUIZHOU) CO.LTD |
| 122 | Lacquer | | Little L (Dark Brown) | | QIANRUI CHEMICAL INDUSTRIAL (HUIZHOU) CO.LTD |
| 123 | Smoked Glass | | Amber | | Donguan Zhongsen Glass Products Factory |
| 124 | Paint | Powder coat | Coffee | | Dongguan Lianying Powder Goods Co., Ltd. |
| 125 | Paint | Liquid | Brown | | HuaRun |
| 126 | Plating/Paint | Normal/ Powder coat | Clear zinc plating then Titanium | Milestone 004 Clear zinc plating Milestone 044 Titanium Powdercoat | |
| 127 | Plating/Paint | Normal/ Powder coat | Clear zinc plating then black wrinkle | Milestone 004 Clear zinc plating Milestone 002 Black Wrinkle Powdercoat | |
| 128 | Wood finish | Vinyl | Thermofoil Omnova brushed Aluminum | | |
| 129 | Wood Finish | | "Graphite": Dark grey wood stain | | Guangdong Huarun Paint Chemical Co., Ltd. |
| 130 | Wood Finish | | "Caramel": Medium brown wood stain | | Guangdong Huarun Paint Chemical Co., Ltd |
| 131 | Plating | Normal | Extreme Etch Black | Anodized | |

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|------|----------------|------------------------------------|---------------------------------|-----------------------------------|--|
| 132 | E-cote | | White | | Tatung Fine Chemicals Co., Ltd. Acrylic Electroposition Resin |
| 133 | Paint | Powdercoat | White | | LETONG CHEMICAL CO.,LTD |
| 134 | Paint | Oil | | | Zhuhai Cailong Plastic Printing Ink Products Co., Ltd. Metallic Paint 410205# |
| 135 | Paint | Powdercoat | Pearl Gray | Smooth | Sherwin Williams HAS4-20050 POWDURA® Hybrid Powder Coating, Pearl Gray |
| 136 | Paint | Powdercoat | Black Magic II - UFB-657-S0 | | |
| 137 | Paint | Powdercoat | Black Gloss | | Pantone 426C, Gloss |
| 138 | Paint | Powdercoat | Silver | | Pantone 8240C |
| 139 | Wood Finish | Melamine | Dark Walnut | | |
| 140 | E-Cote | | Silver | | |
| 141 | Paint | Powdercoat | Gray | | Sherwin Williams - 49 Gray PAS6-C0001 |
| 142 | Paint | Powdercoat | Silver | | Pantone 8240C |
| 143 | Hydro-dip film | | Mahogany | | |
| 144 | Hydro-dip film | | Birch | | |
| 145 | Paint | Oil | Black | | Pantone 419C |
| 146 | Wood Finish | | Natural Walnut Stain | | |
| 147 | Wood Finish | Ash Veneer | Charcoal | | |
| 148 | Painted Glass | Low Iron Glass | Glass painted white on one side | | |
| 149 | Wood Finish | Melamine | Dark Walnut | | |
| 150 | Wood Finish | Veneer | Dark Cherry | | |
| 151 | Wood Finish | Melamine | Dark Cherry | | |
| 152 | Paint | Liquid Paint | Antique White | | |
| 153 | Plating | Normal | Green Zinc | | |
| 154 | Wood Finish | Melamine | Black | Wood Grain | |
| 155 | Paint | Powdercoat EP7030B-C Supplier Code | Light Grey | Texture | Huaguang Powder Coatings |
| 156 | Paint | Powdercoat EP7031B-C Supplier Code | Dark Grey | Texture | Huaguang Powder Coatings |
| 157 | Paint | Powdercoat | Grey | 166-077 Texture Lowes Grey Powder | Akzo Nobel Supplier P/N: 41-71016 Pantone 422M |
| 158 | Paint | | Sonos White | | Substrate: Trinseo PC8600 Substrate Color: IC8800381Paint Paint System: BC+PU CC |
| 159 | Paint | | Sonos Black | | Substrate: Trinseo PC8600 Substrate Color: IC7700181Paint Paint System: BC+PU CC |
| 160 | Paint | Powdercoat | Black | None | Shenzhen Xinadda IR-PI Products |

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4.1 Finishing/Material codes continued

| Code | Type | Sub Type | Color/Plate | Paint Texture/Other | Manufacturer |
|------|--------------------------|---|-------------------|---------------------|---|
| *161 | Outdoor Paint and Primer | Paint: TGIC – Polyester Primer: Epoxy – Polyester Hybrid | Black | Rich Matte | Paint: Axalta Alestal AR400 Rich Black Matte Primer: Axalta ACE Black 32 *Refer to 8900-000007 Milestone Finish Code -161 Outdoor Paint Test Tech Spec for testing criteria |
| 162 | Paint | Liquid | Sonos White | | Pantone 11-0601TPX |
| 163 | Paint | Powdercoat | Yuda Black | | |
| 164 | Plating | Acid Etch | Sonos Graphite | Anodize | |
| 165 | Plating | Acid Etch | Sonos Gray | Anodize | |
| 166 | Plating | Acid Etch | Sonos Silver | Anodize | |
| 167 | Paint | Powdercoat | Sonos Gray | | |
| 168 | Nylon Dipped | PA11 | Pantone Black, 3C | | |
| 169 | Nylon Dipped | PA11 | Sonos White | | |
| 170 | Paint | Powdercoat | Sonos Silver | | |
| 171 | Paint | Liquid | Sonos White | | |
| 172 | E-Coat | | Gray | Glossy | Sheng Xiang Xin Hardware technology (Zhong Shan) Ltd.Co |
| 246 | Material | Delrin | Black | | Pantone 419C, MT11001 |
| 247 | Material | Delrin | Silver | | Pantone 8240C, Gloss SP1-C1 |
| 248 | Material | Delrin | Silver | | Pantone 8240C |
| 249 | Material | ABS | Black | | Pantone 426C, Gloss |
| 250 | Material | ABS | Black | | |
| 251 | Material | ABS | White | | |
| 252 | Material | ABS | Natural | | |
| 253 | Material | ABS | Silver | | |
| 254 | Material | ABS | Off White | | |
| 256 | Material | Acrylic | Black | | |
| 257 | Material | Acrylic | Clear | | |
| 258 | Material | Acrylic | Gray | | |
| 259 | Material | Acrylic | Smoked | | |
| 261 | Material | Delrin | Black | | |
| 262 | Material | Delrin | Silver | | |
| 263 | Material | Delrin | Natural | | |
| 264 | Material | Delrin | Silver | Painted | VMC18278 |
| 266 | Material | Nylon | Black | 30% Glass filled | |
| 267 | Material | Nylon | Medium Gray | | |
| 268 | Material | Nylon | Black | | |
| 269 | Material | Nylon | Natural | | |
| 270 | Material | Nylon | Black | 13% Glass Filled | |
| 271 | Material | Nylon | Natural | 13% Glass Filled | |
| 272 | Material | Nylon | White | | |
| 273 | Material | Nylon | Dark Gray | | |
| 274 | Material | Nylon | Dark Blue | | |
| 275 | Material | PVC | Black | | |
| 276 | Material | PVC | White | | |
| 277 | Material | PVC | Natural | | |
| 278 | Material | PVC | Silver | | |

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4.1 Finishing/Material codes continued

| Code | Type | Sub Type | Color/Plate | Paint Texture/Other | Manufacturer |
|------|----------|---------------------|---------------|---|--|
| 280 | Material | RPVC | Black | | 1017 |
| 281 | Material | RPVC | Silver | | VMC18278 |
| 282 | Material | RPVC | White | | |
| 283 | Material | RPVC | Natural | | |
| 284 | Material | IC Titanium | Black Chrome | To match powdercoat (044) Rohm & Haas 23-9435 (or equivalent) | |
| 286 | Material | UHMW | Natural White | | |
| 287 | Material | UHMW | Black | | |
| 289 | Material | Polycarbonate Sheet | Clear | | |
| 293 | Material | Celcon M90 | Matte Black | | |
| 295 | Material | Hardrock Maple Film | | | Casco H602 or equivalent |
| 300 | Material | PP | White | | |
| 301 | Material | PP | Natural | | |
| 302 | Material | PP | Light Grey | | |
| 303 | Material | PP | Dark Grey | | |
| 304 | Material | PP | Black | | |
| 305 | Material | PET | Black | | |
| 306 | Material | ABS | Light Grey | | |
| 307 | Material | ABS | Dark Grey | | |
| 308 | Material | ABS | Charcoal | | Pantone DS 327-5 U |
| 309 | Material | RPVC | Charcoal | | Pantone DS 327-5 U |
| 310 | Material | ABS | Almond | | |
| 311 | Material | ABS | Ivory | | |
| 312 | Material | Teflon | | | |
| 313 | Material | PET | Transparent | | |
| 314 | Material | PP | Charcoal | | Pantone DS327-5U |
| 315 | Material | Delrin | Charcoal | | Pantone DS327-5U |
| 316 | Material | PC | Charcoal | | Pantone DS327-5U |
| 317 | Material | PVC | Off-White | | |
| 318 | Material | Polypropylene | Black | Gloss | Black Pantone 426C |
| 319 | Material | ABS | Silver | Soft Touch | Silver Pantone 8240C |
| 320 | Material | ABS | Black | | Black Pantone 419C, MT11020 |
| 321 | Material | Nylon | Black | 30% Glass Filled | Black Pantone 419c, MT11020 |
| 322 | Material | LDPE | Black | | LLDPE (Taisox LLDPE Film Cast Film Grade Polymer 3224) |
| 323 | Material | ABS Impact | Gray | | Pantone 427C |
| 324 | Material | Polypro | Gray | | Pantone 427C |
| 325 | Material | Polycarbonate | Black | | |
| 326 | Material | Polycarbonate | Charcoal | | Pantone DS327-5U |
| 327 | Material | HDPE | Black | | HDPE 5000S or equivalent |
| 328 | Material | Red Nylon PA 6/6 | Red | | Pantone 485 |
| 329 | Material | HDPE | Black | | HDPE 5502-01ST |
| 330 | Material | POM Copolymer | Red | | Pantone 485 Safety Red |
| 331 | Material | Nylon 6/6 (PA66) | Black | 33% Glass Filled | ZIG SHENG INDUSTRIAL Co. LTD |
| 332 | Material | ABS | Light Blue | | Pantone 630 C |
| 333 | Material | ABS | Green | | Pantone 7481 C |
| 334 | Material | ABS | Yellow | | Pantone 1235 C |

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4.1 Finishing/Material codes continued

| Code | Type | Sub Type | Color/Plate | Paint Texture/Other | Manufacturer |
|------|----------|--------------------------------|-----------------|-------------------------------|---|
| 335 | Material | Nylon | White | 13% Glass Filled | Pantone 11-0601 TPX |
| 336 | Material | Polycarbonate | Bright White | Makrolon 6487 PC | Pantone 11-0601TPX |
| 337 | Material | Liquid Silicone Rubber (LSR) | Black | Silicone-KEG-2000-60 A/B + UV | Shin Etsu |
| 338 | Material | Liquid Silicone Rubber (LSR) | White | Silicone-KEG-2000-60 A/B + UV | Shin Etsu |
| 339 | Material | Liquid Silicone Rubber (LSR) | Blue | Silicone-KEG-2000-60 A/B + UV | Shin Etsu |
| 340 | Material | Liquid Silicone Rubber (LSR) | Magenta | Silicone-KEG-2000-60 A/B + UV | Shin Etsu |
| 341 | Material | Liquid Silicone Rubber (LSR) | Green | Silicone-KEG-2000-60 A/B + UV | Shin Etsu |
| 342 | Material | ABS UV Stabilized | Dot Gen 1 Black | RTP 0600 UV, Precolor | RTP |
| 343 | Material | ABS UV Stabilized | Dot Gen 1 White | RTP 0600 UV, Precolor | RTP |
| 344 | Material | TPE (Thermo Plastic Elastomer) | Dot Gen 1 Black | RTP6042-70A UV Natural | RTP |
| 345 | Material | TPE (Thermo Plastic Elastomer) | Dot Gen 1 White | RTP6042-70A UV Natural | RTP |
| 346 | Material | Polycarbonate + ABS | Black | | Bayblend FR3010 HF |
| 347 | Material | Polycarbonate + ABS | White | | Bayblend FR3010 HF |
| 348 | Material | ABS | PLAY5 White | UV Stable | CHI MEI CORPORATION: PA-717C (+) |
| 349 | Material | NYLON GF | PLAY5 Silver | 13% Glass Filled | EI DUPONT DE NEMOURS & CO: 70G13HS1L |
| 350 | Material | Silicone Rubber (TPR) | PLAY5 White | | JIAXIN NANHU ANDA PLASTIC LTD: TPR/NS-16750 |
| 351 | Material | Silicone Rubber (TPR) | PLAY5 Black | | JIAXIN NANHU ANDA PLASTIC LTD: TPR/NS-16750 |
| 352 | Material | Nylon GF | Natural | 30% Glass Filled | EI DUPONT DE NEMOURS & CO: 70G30HS1L |
| 353 | Material | Nylon GF | PLAY5 Gray | 13% Glass Filled | EI DUPONT DE NEMOURS & CO: 70G13HS1L |
| 354 | Material | Nylon GF | PLAYS Silver | 30% Glass Filled | |
| 355 | Material | Nylon GF | PLAYS Gray | 30% Glass Filled | |
| 356 | Material | Silicone Rubber | PLAY5 Silver | | JIAXIN NANHU ANDA PLASTIC LTD: TPR/NS-16750 |
| 357 | Material | TPU (Friction Gel) | Transparent | | |
| 358 | Material | Silicone Rubber | PLAYS Grey | | JIAXIN NANHU ANDA PLASTIC LTD: TPR/NS-16750 |
| 359 | Material | PC+ABS 50/50 | Black | | Formosa Chemicals AC2000 |
| 360 | Material | PC+ABS 50/50 | Charcoal | Pantone DS327-5U | Formosa Chemicals AC2000 |

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4.2 Certificates of Conformance (CoCs)

4.2.1 Certificates of conformance for any custom part we buy must be available upon request.

4.2.2 Certificates of conformance must be written in English. Additional languages on the certificate must only be direct translations of the items written in English.

4.2.3 Certificates must be sent in electronic format to the Milestone buyer prior to delivery of parts when a certificate of conformance requirement has been noted on the Milestone drawing.

4.2.4 Certificates of Conformance must contain the following information:

4.2.4.1 Supplier Name

4.2.4.2 Milestone Part Number

4.2.4.3 Milestone Purchase Order Number

4.2.4.4 Milestone Purchase Order Line #

4.2.4.5 Name of material manufacturer

4.2.4.6 Material name

4.2.4.7 Material manufacturer's lot number(s)

4.2.4.8 Statement of the requirements being certified.

For example:

| Milestone Requirement | CoC statement |
|---|--|
| Material block on Milestone drawing states: "ASTM A 1008 C.R.S. CS Type B 12 Gauge (0.1046" Thickness)" | "The items indicated on this CoC meet the requirements of ASTM A 1008 C.R.S. CS Type B 12 Gauge (0.1046" Thickness)" |
| Notes on Milestone drawing state: "Material must be UL listed to UL94 HB or greater" | "The items indicated on this CoC are listed with UL for UL94 with an HB rating. See file number E985521" |

Note: The UL file number is required when UL listing is specified on the drawing.

4.2.4.9 The name of the individual in the organization that is certifying the material. An additional written signature of the individual is preferred.

4.2.5 The method of determining conformance and/or data supporting the conformance is recommended on the CoC, but not required.

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4.3 Appearance Requirements

4.3.1 Appearance requirements for parts vary depending on the type of finish and may differ from surface to surface on the same part. The appearance criteria for common finishes utilized by Milestone are outlined in the sections below according to finish and separated by surface class.

4.3.2 Surface classification shall be noted on the part drawings when utilized.

4.3.3 Surface classification and appearance requirements apply only to aesthetic properties of finishes, not to general workmanship (e.g. burrs, sharp edges) or to surface finishes of the part prior to finishing as specified in the Milestone Purchasing Specification 8900-000001.

4.3.4 Visual inspections to determine acceptance to appearance requirements shall be conducted in a well-lit area, at a viewing distance of 61.0 to 76.2 cm. (24 to 30 in.), at an angle of 45 to 90 degrees (with non-reflecting light), for a period of 5 to 10 seconds.

4.3.5 Milestone Appearance Acceptance Criteria Size Template - Figure 1, is a template designed as a visual guide that can be printed on a clear plastic sheet (transparency) and used for inspection. The template illustrates the maximum size and number of imperfections allowed.

4.4 Paint and E-cote

4.4.1 Coating Thickness

The minimum coating thickness shall be as specified by the manufacturer of the coating. Maximum coating thickness shall be as specified in the following table:

| Type | Maximum Coating Thickness |
|-------------------|---------------------------|
| Liquid paint | 0.004" |
| Powder coat paint | 0.006" |
| E-Cote | 0.001" |

4.4.2 For painted parts, unless otherwise specified on the drawing, the entire surface of the part shall be painted with the exception of threaded fasteners and tapped holes.

4.4.3 For e-coted parts, unless otherwise specified on the drawing, the entire surface including threads of the part may be e-coted. E-coted parts must pass the thread gauge after coating.

4.4.4 Adhesion

Coating adhesion shall have a classification of 4 or greater using test method B (Cross-cut tape test) of ASTM D3359.

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4.4.5 Solvent resistance

Solvent resistance shall have a rating of 3 or better when rubbed with moderate pressure a total of 50 times (back and forth is considered one rub) with a cotton-tipped applicator soaked in Methyl Ethyl Ketone (MEK).

| <i>Rating</i> | <i>Rub-off</i> | <i>Softening</i> | <i>Dulling</i> |
|---------------|----------------|------------------|----------------|
| 5 | None | None | None |
| 4 | Slight | Slight | Slight |
| 3 | Moderate | Moderate | Moderate |
| 2 | Heavy | Heavy | Heavy |
| 1 | Extreme | Extreme | Extreme |

4.4.6 Appearance

4.4.6.1 The color, finish, and gloss shall be uniform and shall meet the specifications outlined by the manufacturer of the coating.

4.4.6.2 Class B: Surfaces marked as class B shall have no more than three visible sags, drips, orange peel, blistering, gouges, scratches, nicks, bubbles, voids, foreign particles, or other surface defects within any 15.2 by 15.2 centimeters (6" x 6") area of one surface. There shall be no such defects larger than 0.3 centimeters (0.10") in diameter or .01 centimeters wide (0.02") by 1.3 centimeters long (0.5") for scratches.

4.4.6.3 Class A: Surfaces marked as class A shall have no visible sags, drips, orange peel, blistering, scratches, gouges, nicks, bubbles, voids, foreign particles, or other surface defects.

4.4.6.4 Colors shall match the color samples provided or the product approved during the first article process if color samples are not available.

4.5 Plating

4.5.1 Plating Thickness is below unless otherwise specified on the drawing or the suffix code is 088.

| Subtype | Coating Thickness Specification |
|---------|---------------------------------|
| Normal | 0.0002" to 0.0005" |
| Flash | ~0.0001" |

4.5.2 Unless otherwise specified on the drawing, the entire surface of the part shall be plated. Plated parts must pass the thread gauge after coating.

4.5.3 Appearance

Plating shall be uniform in appearance.

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4.6 Plastics

4.6.1 Appearance

4.6.1.1 The surface of molded-in texture shall be uniform in appearance.

4.6.1.2 Class A: Surfaces marked as class A shall have no visible blemishes, nicks, splay, scratches, gate marks, gate blush, flash, sink marks or other surface irregularities including short shots, burned material and excessive knit lines.

4.7 Glass

4.7.1 Characteristics

All glass used in assemblies shall be tempered glass and shall meet the requirements of BS6206:1981 Appendix B, UL1678:2003 Section 20 and UL2442:2011 Section 61.3.

4.7.2 Appearance

Painted or textured glass products (e.g. frosted, etched, painted) shall be uniform in appearance.

4.8 Wood or Composite Panels

4.8.1 Characteristics

4.8.1.1 Medium density fiberboard (MDF) used in assemblies shall meet ANSI A208.2 requirements.

4.8.1.2 Particle board used in assemblies shall meet ANSI A208.1 requirements.

4.8.1.3 Composite wood shall meet CARB Phase 2 requirements. A certificate issued by a CARB approved third party certification testing agency shall be provided upon request

4.8.2 Appearance

4.8.2.1 The finished assembly shall be uniform in appearance with respect to grain and finish (stain, paint, etc.) with minimal veneer lamination lines. Special requirements such as number of laminations, which plane the laminations are allowed and color consistency will be specified on the drawing.

4.8.2.2 Class AA, A, B, or C surfaces will be noted on the part drawings or the purchase order.

4.8.2.3 Glue or stain seeping or dripping is not acceptable on surfaces classified as AA, A, B or C.

4.8.2.4 With the exception of knots, natural variation of the surface veneer such as whorls, burls, grain changes, swirls, etc. are allowed unless otherwise noted on part drawings.

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4.8.2.5 Defects are defined as but not limited to, veneer patching, large knots, pitch pockets, scratches, holes, scrapes, dents, dirt or dust spots, fisheyes, gum, sap, pith, checks, splits, worm holes, gouges, discoloration and wood filler marks. Milestone's Appearance Acceptance Criteria Size Template is available as a visual guide for inspection and disposition of appearance imperfections. See Figure 1 at the end of the specification.

4.8.2.6 Stain and paint colors shall match the color samples provided or the product approved during the first article process if color samples are not available.

4.9 Die Castings

4.9.1 Prior to die construction, any questions regarding how the casting is going to be used, i.e. places of high stress, stress concentration points, purely decorative castings, etc. will be the vendor's responsibility to ask the appropriate Milestone design and/or manufacturing engineer prior to building the die.

4.9.2 The supplier is responsible for the performance of all inspection and test requirements specified in referenced standards (Ex ASTM B 85) and Milestone drawings and specifications.

4.9.3 Milestone drawings for die cast components shall indicate location of markings and marking requirements. Unless specified on the drawing, castings shall not be marked.

4.9.4 The specification for the chemical composition of Magnesium (Mg) in A380 shall be 0.30 instead of 0.10 as called out in the Chemical Requirements table of ASTM B85 Standard Specification for Aluminum Alloy Die Castings.

Reference NADCA A-3-1-09: Product Specification Standards for Die Castings/2009 – Aluminum Alloys, Chemical Compositions.

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4.9.5 Internal Soundness

4.9.5.1 The internal soundness of aluminum or magnesium die castings shall be evaluated using the test methods and reference radiographs specified in ASTM E155.

4.9.5.2 The table below is an initial guideline for maximum discontinuity levels during die construction.

| Discontinuity Specifications as per ASTM E155 | | |
|---|-----------------------------|-----------------------------|
| Discontinuity | Casting Thickness < 1/2" | Casting Thickness ≥ 1/2" |
| Gas Holes | 3 | 6 |
| Gas Porosity (Round) | 3 | 6 |
| Gas Porosity (Elongated) | 3 | 6 |
| Shrinkage Cavity | 3 | 5 |
| Shrinkage (Sponge) | 3 | 5 |
| Foreign Material (Less dense) | 2 | 3 |
| Foreign Material (More dense) | 2 | 3 |

4.9.5.3 The specific maximum levels of discontinuity for each part and/or sections of a part will be determined upon completion of testing and validation. These values shall be specified on part drawings.

4.9.5.4 Unless otherwise specified on part drawings, maximum grade levels apply to the entire part.

4.9.5.5 Certificates of Analysis (CoA) for internal soundness of castings shall be available upon request and shall include the evaluation method, grade for each discontinuity type per sample, and digital images of each sample.

4.10 Cold-Rolled Steel – Hot-Rolled Steel

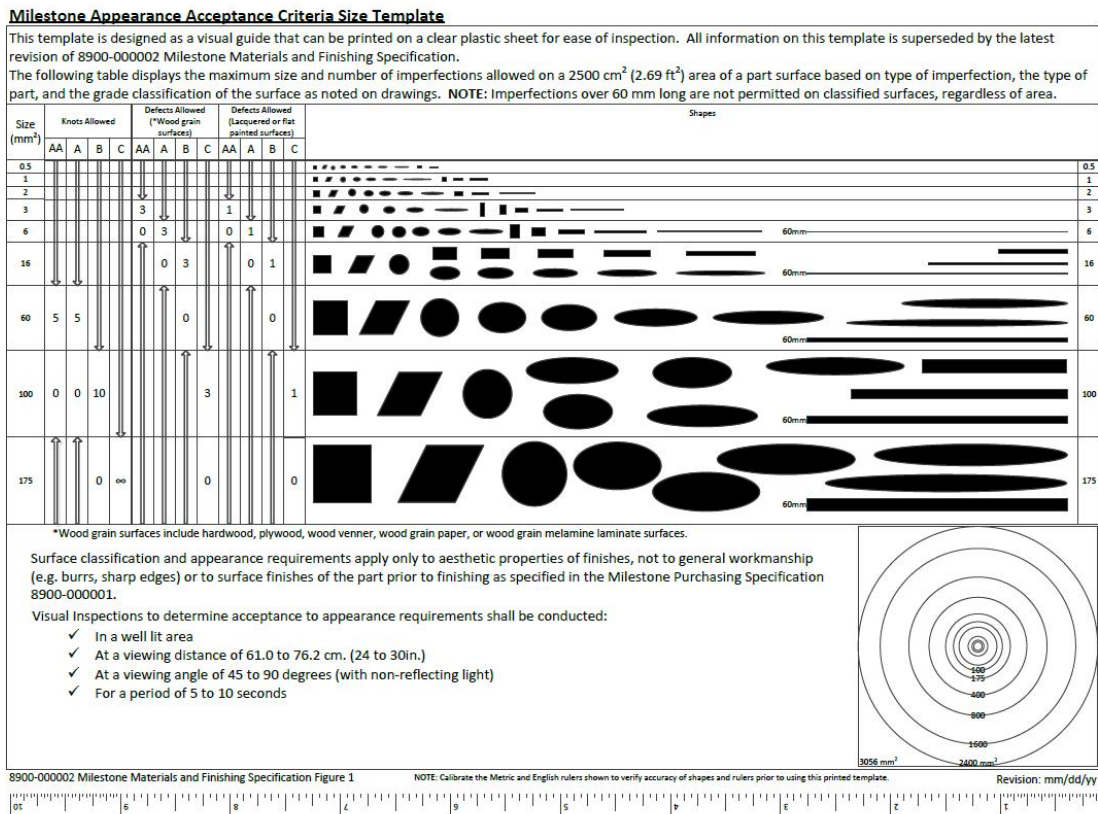
4.10.1 Any component and/or sub-assembly with a country of origin of People’s Republic of China, Brazil, India, Japan, Russia or the United Kingdom where the Milestone drawing specifies the material to be used as either Cold-Rolled or Hot-Rolled Steel, Hot-Rolled steel must be used.

4.10.2 The supplier must notify Milestone if Hot-Rolled steel is not readily available in the specified thickness.

4.10.3 Any country of origin that is not mentioned above, the manufacturer has the option to use either Cold-Rolled or Hot-Rolled steel.

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Figure 1: Milestone Appearance Acceptance Criteria Size Template



NOTE: Figure 1 template shown above is not the actual size. The template must be printed from Visio or pdf version.

NOTE: Calibrate the Metric and English rulers shown on the template to verify accuracy of shapes and rulers prior to using the printed template.