

**APPENDIX:
QUALITY REQUIREMENTS FOR 2ND GRADE TILE**

Defect type	Defect specification	GRADE II
Difference of shades	Slight differences in color intensity on the tile surface	Acceptable
Holes	Minor holes in the glazing surface	Acceptable
Scorches	Minor concentrated blisters on the glazing surface, closed or open, may be squashed under pressure	Dispersed acceptable
Punctures	Point, small indentations violating the evenness of the glazing surface	Acceptable
Pits	Point indentations in the glazing	Acceptable
Insufficient glazing	Places on the glazed surface not covered with glazing, glaze falling off of the edges	Acceptable dispersed with total surface of no more than 100 mm ²
Glazing thickening and waviness	Glazing unevenness in the form of waves or thickening, dripping on the tile edges	Acceptable
Foreign grains	Foreign grains settled and partially embedded in the glazing layer	Acceptable up to 3 pcs. dispersed with diameter up to 1 mm and height of 0,5 mm
Corner splintering on the front side	Damages / bluntness to gres corners	Acceptable 2 pcs. with depth up to 1/3 of tile thickness, with surface up to 5 mm ²
Chips	Deficiencies on tile edges	Acceptable 2 pcs. with width up to 1 mm
Cracks	Cracks passing through part or the whole thickness of the tile	Not striking, max. 5 mm length acceptable
Cracks – type crow's feet	Cracks in the surface of glaze, moving radially from edges of tiles	Acceptable 1 pcs. with length up to 5 mm
Hole-cracks	Cracks in hollow of glaze, up to biscuit	Acceptable 1 pcs. with length up to 5 mm
Exfoliations/ Delaminations	Layer exfoliation of the surface part of the tile from the base caused by faulty pressing of the tile or layer exfoliation of the glaze from the base	Unacceptable
Pattern defects	Deviations from the adopted pattern, interruption of the patterns continuity, shifts of the overprint and margins, lack of overprint, smudges, margins, lines from digital printer etc.	Acceptable
Dots; stains	Small, stained specks/areas which are an unintended effect of a pattern	Acceptable
Edge sharpness	Sharp tabs on the side of the tile or no bluntness in the rectified tile	Acceptable on two edges
Scratches	Scratches of the tile face surface	Acceptable
Creases of glaze	Unintentional patchiness surface of glaze (f.e. orange peel)	Acceptable
Surface matt	Non-uniform shiny spots of the gres surface	Acceptable
Foreign mass inclusion	Foreign grains of a different color melted into the surface layer of gres	Acceptable
Unevenness of the phase on the edge of a rectified tile	Unevenness, shift of the beveled edge, phase non-uniformity	Acceptable on two edges
Chipping of the corners and edges from the installation side	Mechanical damage to tile corners and edges	Acceptable up to 3/4 of the tiles thickness
Insufficient polishing	Unpolished areas on the tile surface	Not striking acceptable
Excessive polishing	surface fragments polished too deeply (wiped out print or exposed body)	Not striking acceptable
Acceptable number of defects per single tile [pcs.]		Maximum 3 types defects, but no more than 5

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