

Standard Call Out Sheet Exterior Component Appearance Standard	Standards Number		
	250		
	Effective Date:		7/20/10
Page		1 of 11	
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

EXTERIOR TRIM COMPONENT SYSTEMS
APPEARANCE SPECIFICATION

- 1.0 PURPOSE.** The purpose of this standard is to describe the minimum acceptance criteria for exterior components such as grilles, bumper trims, trunk lid finishers, license plate housings, etc. produced by Lacks Trim Systems, and the methodology to determine if the criterion has been met. This standard is not intended to inhibit appearance enhancements over time. Lacks Trim understands that continuous improvement is an expectation of our Customers and will therefore strive to further minimize or eliminate surface concerns.
- 2.0 SCOPE.** This standard describes the surface appearance and quality requirements for exterior components. These requirements, with regard to appearance attributes and surface concerns, are outlined by appearance zones. This standard shall apply to all Lacks Trim Systems molded / plated (bright and platinum) / painted components supplied to our Customers unless otherwise designated by the control plan or approved drawing.
- 3.0** Exterior components are divided into different appearance zones as determined at Feasibility design review, to set the quality requirements of each zone separately. (See Table 1) For detailed appearance zone definition, see part print definition. Below are guidelines for establishing these zones "in vehicle position".

TABLE 1 - APPEARANCE ZONE DEFINED

ZONES		TYPICAL DESCRIPTION
1(A)	Very High Visibility	The surface that is most important to the observer or that is most obvious to the direct line of vision. Horizontal
2(B)	High Visibility	The surface usually adjacent to surface "A". Surface is visible but is not as obvious to the direct line of vision. Such as parts that are partially covered by the hood or trunk.
3(C)	Moderate, Low or No Visibility	Recessed surfaces, indented surfaces, non-topcoat surfaces or vertical surfaces hidden in the installed position. Horizontal hidden or covered surfaces.

NOTIFY YOUR QUALITY AUDITOR WITH QUESTIONS ON THIS STANDARD!

Standard Call Out Sheet Exterior Component Appearance Standard	Standards Number		
	250		
	Effective Date:		7/20/10
Page		2 of	11
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

4.0 SURFACE CONCERNS. When combinations of different types of the concerns are present, each shall be treated as being of the type which has the most severe requirements and must be within the acceptance specifications for that type.

4.1 EVALUATION OF APPEARANCE ATTRIBUTES

4.1.1 Visual inspection (prevailing) and/or the use of a template (for reference only) as a visual aid to determine whether or not appearance attributes meet the established criteria. If verification of a concern is necessary, a calibrated/certified measuring instrument must be used.

4.1.2 Boundary Samples (if required): In the areas that designate “boundary samples”, there may be signed off samples if the appearance concern is relevant based on part product history, design, or process limitations.

4.1.3 The lighting for inspection areas should be standard fluorescent or a MacBeth light booth. The evaluation method should be for no more than 30 seconds at arms length (18”-20”) and viewed in an assembled or vehicle position. All surfaces are to be evaluated, including top, bottom, front, back, and side views.

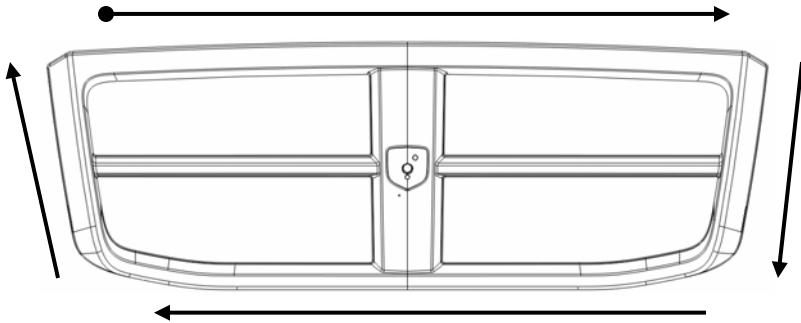
4.1.4 Evaluation for appearance attributes shall be visual. Requirements for surface concerns are shown in the following tables:

Molded Parts	Table #2
Chrome plated parts	Table #3
Body color / Spinelle™ painted parts	Table #4
Mask or Accent Paint	Table #5
*Platinum Chrome parts	Table #6

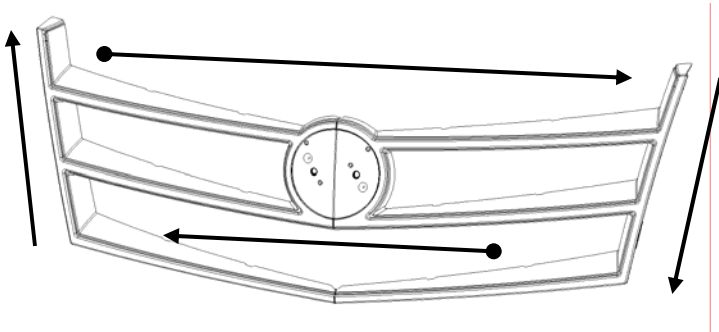
Platinum is only one version / standard identified for clarification to differentiate from Bright Chrome. For the purpose of this specification, it is assumed to be inclusive of other standards similar in appearance such as Pearl Bright, Satin, etc

Standard Call Out Sheet Exterior Component Appearance Standard		Standards Number 250	
		Effective Date: 7/20/10	
Page	3	of	11
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

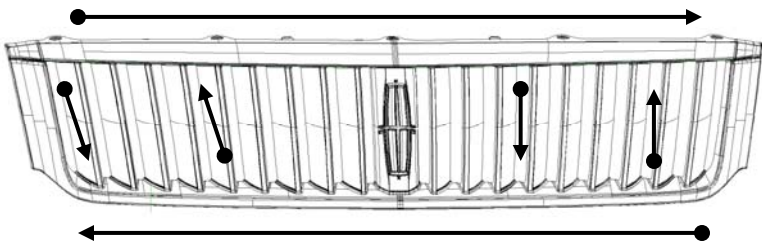
4.1.5 Standard inspection method for appearance attributes are to be performed using the following methods unless otherwise specified by individual part or plant instructions. Parts to be viewed at arms length in vehicle position. See critical quality sheets for surface class designations.



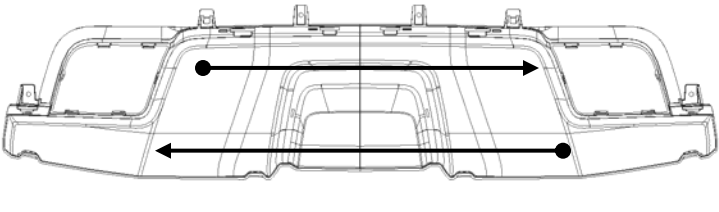
Outer surface (A and B) – Begin inspection at the top L/H (Left Hand) area of the part; continue in a clockwise direction around entire part.



Horizontal surfaces (A and B) – Begin at the top L/H area of the part and follow the horizontal rows left to right. Follow the same method for front surface.



Vertical surfaces (A and B) – Begin at the top L/H area of the part view the vertical ribs from left to right and up to down as needed for inspection. Follow the same method for front surface.



Inspect C areas in similar fashion, left to right, up to down.

Standard Call Out Sheet Exterior Component Appearance Standard	Standards Number		
	250		
	Effective Date:		7/20/10
Page		4 of	11
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

4.2 PAINT INSPECTION PROCEDURE. Approved visual orange peel standards can be acquired from ACT laboratories, Hillsdale, MI. 49242.

4.2.1 Lighting requirements for color match: Macbeth light or comparable unit shall be used when evaluating color. The color match should be conducted with no light influence within a 100 feet range. The use of colorimeter equipment is preferred if the part orientation will accept the equipment.

As an alternative, color may be evaluated in natural daylight or as directed by the color harmony team.

ORANGE PEEL TABLE

COLOR FAMILY	VERY HIGH VISIBILITY	HIGH VISIBILITY	MODERATE TO LOW VISIBILITY	NO VISIBILITY
Visual Scale Horizontal	7	6	5	No Requirement
Visual Scale Vertical	6	6	5	No Requirement

Standard Call Out Sheet Exterior Component Appearance Standard		Standards Number 250	
		Effective Date: 7/20/10	
		Page	5 of 11
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

Molded Parts Table # 2

CONCERNS	DESCRIPTION	ZONE 1 (Class A) (Very High Visibility)	ZONE 2 (Class B) (High Visibility)	ZONE 3 (Class C) (Moderate, Low or No Visibility)
Sinks	Depressions in the plastic substrate	Boundary sample required	Boundary sample required	Allowed but must not be visible to the consumer. The surface may not be visible to the observer under conditions of normal use. The above Statement is the Standard Disclaimer
Polish Marks	Light scratches on molded surface due to cleaning or repair.	Must not take away from consistent finish. Boundary sample may be required	Must not take away from consistent finish. Boundary sample may be required	Standard Disclaimer
Flowlines / Knit lines	Light weld line in substrate that shows through plating.	Boundary sample may be required	Boundary sample may be required	Standard Disclaimer
Blush	Dull halo or grainy appearance that usually occurs at the gate area	Must not take away from consistent finish. Boundary sample may be required	Must not take away from consistent finish. Boundary sample may be required	Standard Disclaimer
Mold Flash	Excessive plastic at parting line or edges of part.	Boundary sample may be required	Boundary sample may be required	Standard Disclaimer
Splay / Mold Blister	Mold Blister is a hard spot(s) in substrate reflected by chrome. No loss of adhesion. Splay is the appearance of silvery streaks or blisters on surface	1.0 mm in diameter or less is acceptable. No more than 2 concerns allowed within 30 mm. Similar occurrences are acceptable if greater than 300 mm apart.	1.0mm in diameter or less is acceptable. No more than 2 concerns allowed within 30 mm. Similar occurrences are acceptable if greater than 200 mm apart.	Standard Disclaimer
Short Shots	Area in part that does not fill out	Short Shot is not acceptable on the front of the parts or any attachment features that would affect fit and/or function	Short Shot is not acceptable on the front of the parts or any attachment features that would affect fit and/or function	Short Shot is not acceptable on the front of the parts or any attachment features that would affect fit and/or function
Stringers	Fine hair like string of flash from sprue that is molded into the surface of the part	Unacceptable	Unacceptable	Standard Disclaimer
Mold Burns/Build Up	Discoloration (yellow, brown, black), charred or gritty texture on the raw surface	Boundary Sample Required	Boundary Sample Required	Standard Disclaimer
Gate Trim	Injection molding runner/gate which is removed during ejection or trimmed by an operator or machine	Flush even appearance with no visible gouging or burrs acceptable	Flush even appearance with no visible gouging or burrs acceptable	Standard Disclaimer
Trim Marks	Flash trimmed beyond flush onto part surface	Unacceptable	Unacceptable	Standard Disclaimer
Cold Slugs, Pits, Dents, and Nicks	Small pits, nicks, or dents in the surface. Must not penetrate into the substrate.	0.75 mm in diameter or less is acceptable. You may have (2) concerns within a 50mm distance. Similar occurrences are acceptable if greater than 400 mm apart.	1.0mm in diameter or less is acceptable. You may have (2) concerns within a 50mm distance. Similar occurrences are acceptable if greater than 200 mm apart	Standard Disclaimer

Standard Call Out Sheet Exterior Component Appearance Standard		Standards Number 250	
		Effective Date: 7/20/10	
		Page	6 of 11
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

Bright Chrome Plated Parts Table #3

CONCERNS	DESCRIPTION	ZONE 1 (Class A) (Very High Visibility)	ZONE 2 (Class B) (High Visibility)	ZONE 3 (Class C) (Moderate, Low or No Visibility)
Excess Plate / Build-up (treeing)	Plating nodules at edges or corners of part.	Unacceptable	Unacceptable	Standard Disclaimer
Plate Blisters	Loss of adhesion between metal layers and / or substrate.	Unacceptable	Unacceptable	None Allowed
Dullness	Milky surface appearance / lacks normal reflectivity	Boundary sample may be required	Boundary may be sample required	Standard Disclaimer
Brown Stain	Brown spots on chrome surface, which may be cleaned	.25-1.0mm max diameter no closer than 200 mm apart.	.25-2.0mm max diameter no closer than 100 mm apart.	Standard Disclaimer
Skip Plate / Pin Skip	Voids or holes in plated surface	0.5mm in diameter or less no closer than 100mm apart	0.75mm in diameter or less no closer than 100mm apart	Standard Disclaimer
Chrome Burn	Dull/grey non-reflective condition which appears at edges and corners.	Unacceptable	Boundary Sample may be required	Standard Disclaimer
Scuff	Light scuff on the chrome surface	Must not take away from consistent finish. Boundary sample may be required	Must not take away from consistent finish. Boundary sample may be required	Standard Disclaimer
Nickel Show	Lack of chrome coverage. (yellow plate appearance)	Unacceptable	Unacceptable	Standard Disclaimer
White Stain	Light Discoloration of chrome surface	Must not be easily seen. Boundary sample may be required	Must not be easily seen. Boundary sample may be required	Standard Disclaimer
Stringers	Fine hair like string of flash from sprue that is molded into the surface of the part	Unacceptable	Unacceptable	Standard Disclaimer
Stardust	A group of sub surface speckles that appear in clusters.	Acceptable for one faint cluster. Maximum 25 speckles per square inch. Max. Width of 50mm. Speckles must be less than 0.2 mm in diameter.	Acceptable for faint clusters maximum 25 speckles per square inch. Max. Width of 100mm. Speckles must be less than 0.2mm in diameter. Similar occurrences are acceptable if greater than 400 mm apart.	Standard Disclaimer
Scratch	Scratch on surface before or after chrome	20mm or less in length is acceptable. The scratch itself must not be easily seen. Similar occurrences are acceptable if greater than 200 mm apart. Substrate must not be exposed. No more than 3 concerns allowed. Width – hairline – maximum	30mm or less in length is acceptable. Must not be easily seen. Similar occurrences are acceptable if greater than 100 mm apart. Substrate must not be exposed. No more than 5 concerns allowed. Width – light – maximum	Standard Disclaimer
Roughness	Gritty feel to touch on the surface of the part.	Must not retain fibers from a cotton cloth when wiped.	Acceptable	Standard Disclaimer
Dry On	Blotchy Appearance	Must not take away from consistent finish. Boundary sample may be required	Must not take away from consistent finish. Boundary sample may be required	Standard Disclaimer
Cold Slugs, Pits, Dents, and Nicks	Small pits, nicks, or dents in the surface. Must not penetrate into the substrate.	0.75 mm in diameter or less is acceptable. You may have (2) concerns within a 50mm distance. Similar occurrences are acceptable if greater than 400 mm apart.	1.0mm in diameter or less is acceptable. You may have (2) concerns within a 50mm distance. Similar occurrences are acceptable if greater than 200 mm apart	Standard Disclaimer

Standard Call Out Sheet Exterior Component Appearance Standard		Standards Number 250	
		Effective Date: 7/20/10	
		Page	7 of 11
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

Body Color / Spinelle™ Painted Parts Table 4

CONCERNS	DESCRIPTION	ZONE 1 (Class A) (Very High Visibility)	ZONE 2 (Class B) (High Visibility)	ZONE 3 (Class C) (Moderate, Low or No Visibility)
Dirt	Foreign particle (s) in, on, or under the painted surface	0.75 mm in diameter acceptable. Must be at least 200 mm apart. Particles less than or equal to .25mm are not a concern. <hr/> Contrasting color – None allowed except on approved boundary samples	Acceptable if less than 1.00mm in diameter (2) concerns allowed within 30mm square. Similar occurrences are acceptable if greater than 200mm apart <hr/> Acceptable if less than 0.50mm in diameter (5) concerns allowed within 15mm square. Similar occurrences are acceptable if greater than 200mm apart <hr/> Contrasting color – 0.50mm is acceptable. Particles must be at least 200mm apart.	Standard disclaimer
Discoloration	Pigment or contaminant from base coat or primer diffuses into topcoat	Unacceptable	Boundary Sample may be required	Standard disclaimer
Dry Spray	Textured or seedy appearance of paint film with low gloss.	Unacceptable	Boundary Sample may be required (based on part design)	Standard disclaimer
Overspray	Paint deposited from a different target area	Boundary samples may be required	Boundary samples may be required	Standard disclaimer
Spitting	Drops of paint deposited on the finished surface	Unacceptable	Unacceptable	Standard disclaimer
Picture Framing / Build Up	Paint build-up at edges	Boundary sample may be required	Boundary sample may be required	Standard disclaimer
Sags ----- Runs/Drips	Sagging paint (curtain effect)	Unacceptable Unacceptable	Boundary samples may be required Boundary samples may be required	Standard Disclaimer ----- Standard Disclaimer
Craters and Fisheyes	Small round depressions in paint:	.75mm or less acceptable (3) concerns allowed must be a minimum of 300 mm apart. Must be same color. <hr/>	1.0mm or less acceptable (4) concerns allowed must be a minimum of 300 mm apart. Must be same color <hr/>	Standard disclaimer

Standard Call Out Sheet Exterior Component Appearance Standard		Standards Number 250	
		Effective Date: 7/20/10	
		Page	8 of 11
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

Body Color / Spinelle™ Painted Parts Table 4 Continued

CONCERNS	DESCRIPTION	ZONE 1 (Class A) (Very High Visibility)	ZONE 2 (Class B) (High Visibility)	ZONE 3 (Class C) (Moderate, Low or No Visibility)
Superficial Scuffs	Light scuffs on the surface.	10mm wide x 20mm long max. No more than (3) concerns allowed minimum of 200mm apart from each other. Must not be easily seen.	15mm wide x 30mm long max. No more than (3) concerns allowed minimum of 200mm apart from each other. Must not be easily seen.	Standard Disclaimer
Water Spots	Irregular rings telegraphing through the paint surface	Boundary sample may be required	Boundary sample may be required	Standard Disclaimer
Scratches after Paint	Handling scratches	20mm or less in length is acceptable. Must not be easily seen. Similar occurrences are acceptable if > 200mm apart. Substrate must not be exposed. No more than 3 concerns allowed. Width – hairline – maximum	30mm or less in length is acceptable. Must not be easily seen. Similar occurrences are acceptable if > 100mm apart. Substrate must not be exposed. No more than 5 concerns allowed. Width – light – maximum	Standard Disclaimer
Chips	Separation of paint from previous coating	Unacceptable	1.0mm max. Diameter acceptable. No more than (1) concern allowed. Reject if there is a color change or bare substrate is exposed	Standard Disclaimer
Blush	Milky or dull appearance in coating	Unacceptable	Unacceptable	Standard Disclaimer
Bare Substrate	Voids in the paint film exposing substrate	Unacceptable	Unacceptable	Standard Disclaimer
Mottle	Uneven, blotchy appearance	Unacceptable	Unacceptable	Standard Disclaimer

Standard Call Out Sheet Exterior Component Appearance Standard		Standards Number 250	
		Effective Date: 7/20/10	
		Page 9 of 11	
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

"Mask / Accent Paint Table 5

CONCERNS	DESCRIPTION	ZONE 1 (Class A) (Very High Visibility)	ZONE 2 (Class B) (High Visibility)	ZONE 3 (Class C) (Moderate, Low or No Visibility)
Dirt	Foreign Particle under the Painted Surface	0.75 mm or less in diameter acceptable (2) concerns allowed within 100 mm square. Similar occurrences are acceptable if greater than 200 mm apart.	1.00 mm or less in diameter acceptable (2) concerns allowed within 30 mm square. Similar occurrences are acceptable if greater than 200 mm apart. Acceptable if less than 0.50 in diameter (5) occurrences allowed within 15 mm square. Similar occurrences are acceptable if greater than 100 mm apart.	Standard Disclaimer
Paint Stringer	Hair like line of paint deposited on the chrome plated or painted "A" surface	Unacceptable	10.0 mm in length is acceptable. Similar occurrences are acceptable if greater than 100mm apart.	Standard Disclaimer
Paint Spit	Drops of paint deposited on the finished surface	Unacceptable	1.00 mm in diameter is acceptable. Similar occurrences are acceptable if greater than 100 mm apart.	Standard Disclaimer
Mask Dig	Scuffs or gouge on the part surface where the mask contacts the part	No discoloration. May not penetrate to substrate. Light in width. Maximum 3.0 mm in length acceptable	No discoloration. May not penetrate to substrate. Medium in width. Maximum 5.0 mm in length acceptable	Standard Disclaimer
Sags / Runs	Excessive paint flow appears as a drip or run in the paint.	Unacceptable	No discoloration or loss of gloss. 7.0 mm in length 2 mm in width acceptable.	Standard Disclaimer
Craters / Fish Eyes	Small round depressions appear as oil or water spots on the painted surface.	Less than 1.0-mm (3) concerns allowed must be a minimum of 300 mm apart. Must be same color.	Less than 1.5-mm (4) concerns allowed must be a minimum of 300 mm apart. Must be same color	Standard Disclaimer
Solvent Pop	Small clusters of bubbles raised but unbroken in the painted surface.	Must not be rough or sharp to touch. 0.50 mm in diameter acceptable. No more than 5 within 20.0 mm. Similar occurrences are acceptable if greater than 100 mm apart.	Must not be rough or sharp to touch. 0.75 mm in diameter acceptable. No more than 5 within 20.0 mm. Similar occurrences are acceptable if greater than 50 mm apart.	Standard Disclaimer
Scratch	Scratch on surface before or after paint	20mm or less in length is acceptable. Must not be easily seen. Similar occurrences are acceptable if greater than 200mm apart. Substrate must not be exposed. No more than 3 concerns allowed. Width – hairline – maximum	30mm or less in length is acceptable. Must not be easily seen. Similar occurrences are acceptable if greater than 100mm apart. Substrate must not be exposed. No more than 5 concerns allowed. Width – light – maximum	Standard Disclaimer

Standard Call Out Sheet Exterior Component Appearance Standard		Standards Number 250	
		Effective Date: 7/20/10	
		Page	10 of 11
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

Table #6: Platinum Chrome Parts

CONCERNS	DESCRIPTION	ZONE 1 (Class A) (Very High Visibility)	ZONE 2 (Class B) (High Visibility)	ZONE 3 (Class C) (Moderate, Low or No Visibility)
Excess Plate / Build-up (treeing)	Plating nodules at edges or corners of part.	Unacceptable	Unacceptable	Allowed but must not be visible to the final consumer. The surface may not be visible to the observer under conditions of normal use The above statement is the Standard Disclaimer
Plate Blisters	Loss of adhesion between metal layers and / or substrate.	Unacceptable	Unacceptable	Allowed on hidden surfaces only if the blister will not creep onto a visible surface. Standard Disclaimer
Gloss Level	Low or high gloss level	Boundary sample may be required	Boundary may be sample required	Standard Disclaimer
Brown Stain	Brown spots on chrome surface.	.25 - 1.0mm Max diameter no closer than 200 mm apart.	.25 - 2.0mm diameter no closer than 100 mm apart.	Standard Disclaimer
Skip Plate / Pin Skip	Voids or holes in plated surface	0.5mm in diameter or less no closer than 100mm apart	0.75mm in diameter or less no closer than 100mm apart	Standard Disclaimer
Chrome Burn	Dull/grey non-reflective condition which appears at edges and corners.	Unacceptable	Boundary Sample may be required	Standard Disclaimer
Scuff	Light scuff on the chrome surface	Must not take away from consistent finish. Boundary sample may be required	Must not take away from consistent finish. Boundary sample may be required	Standard Disclaimer
Nickel Show	Lack of chrome coverage (yellow plate appearance)	Unacceptable	Unacceptable	Standard Disclaimer
White Stain	Light Discoloration of chrome surface	Must not be easily seen. Boundary sample may be required	Must not be easily seen. Boundary sample may be required	Standard Disclaimer
Stringers	Fine hair like string of flash from sprue that is molded into the surface of the part	Unacceptable	Unacceptable	Standard Disclaimer
Scratch	Scratch on surface before or after chrome	Must not be easily seen. Boundary sample may be required	Must not be easily seen. Boundary sample may be required	Standard Disclaimer
Roughness	Gritty feel to touch on the surface of the part.	Must not retain fibers from a cotton cloth when wiped.	Acceptable	Standard Disclaimer
Dry On	Blotchy Appearance	Must not take away from consistent finish. Boundary sample may be required	Must not take away from consistent finish. Boundary sample may be required	Standard Disclaimer
Fingerprints / Smudges	Fingerprints after plating process	Acceptable after plating	Acceptable after plating	Standard Disclaimer
Platinum Streaks	Slight elongated gloss variation	Must not take away from overall finish appearance. Boundary sample may be required. Standard varies with part design.	Must not take away from overall finish appearance. Boundary sample may be required. Standard varies with part design	Standard Disclaimer
Platinum Pits	Bright or dark spot within platinum nickel surface	0.75mm diameter. Or less; no closer than 100mm apart	1.0mm diameter or less; no closer than 50mm apart	Standard Disclaimer

Standard Call Out Sheet Exterior Component Appearance Standard	Standards Number		
	250		
	Effective Date:		7/20/10
Page		11 of 11	
Approved By: Kim Zoerman / Bill Nieboer		Approved Date 7/19/10	

Date	Revised By:	Revision Description
05-04-2000	Dorothy Putman	Initial Document
02-08-01	Dorothy Putman	Added 30 – 40 seconds to section 4.1.2.
09-17-01	Dorothy Putman	Added Table #4 Mask / Accent Paint. Revised wording and format.
09-25-01	Dorothy Putman	Added scratch to table #4. Updated dirt callout on table #3&4. Corrected spelling errors.
03-12-02	Dorothy Putman	Added wording standard call out to Title. To correlate with all quality documents already issued.
03-29-02	Amy Batey	Changed to the Standard Callout Template. Issued the Document a callout number.
09-18-02	Amy Batey	Updated to Lacks Trim Logo. Updated for corrections.
01-10-05	Bob Phillips	Added section 4.1.5
06-03-05	Amy Batey	Updated picture for Class B Surface, section 4.1.5
01-04-06	QA/QE Team	Updated various items
04-17-06	Amy Batey	Updated brown stain, added pits, dents and dings to the plate table, placed bare substrate in body color table
11-9-06	Amy Batey	Updated dirt callout for body color. Updated evaluation method on page two to read 18-20". Revised chrome stains callout in chrome table.
02-07-07	Amy Batey	Added platinum chrome table
10/2/09	Amy Batey	Added Spinelle™ to body color table; changed "none allowed" and "not allowed" to "read unacceptable" throughout document. Changed water spots (at paint) to "Boundary sample may be required". Removed sand marks, polish marks and splurges from body color table.
2/3/10	Amy Batey	Changed page 3 inspection method; added color codes to top of headers to signify surface class.
7/15/10	Amy Batey	Added mottle to body color / Spinelle table