1. Color monitoring in the furniture industry

During the manufacturing process of doors the color must be controlled and monitored. At this the color will be sprayed with spray nozzles, which are mounted on a robot, onto the doors. Just after this process but before the drying process the color will be controlled with a color sensor type **SPECTRO-3-30-POL**. This sensor comes with a polarization filter, which helps to suppress the direct reflection from the wet color, only the diffuse light can pass the polarization filter. With the monitoring software **SPECTRO3-Monitoring V1.0** an average color value from each door will be stored into a file together with parameters like customer name, order number, product number, operator name, machine number, line number, date and time. Furthermore the operator can observe the data and the trend of the color in a graphic form. In the

following there are shown 5 samples, in which sample N°2 shows a drift into the yellow range.