



Titolo: Traction test with assembled components

Cod. Doc.: ICP 033_1

Rev. 1

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Data: 12/06/2018

1. **Purpose**

Verify that the controlled batch, according to ISO 2859 (ex MIL STD 105 E), complies with the required requisites.

2 **References**

- CQA 01, GQA 04 procedures
- Single Sampling, special testing level S-3

3. **Mode**

3.1. **Field of application**

Assembled components independently of assembly tipology o applied technology.

3.2. **Equipment**

- Motorized column stand. Scale 1000N.
- Hook for apply weight
- 10 kg weight

3.2. **Control method**

After making the batch picking, according to iso 2859, the pieces/products are tested according the follow procedure:

1. With the use of Motorized stand
 - a) Fix reference bottle (with relative accessories) to the base of stand.
 - b) Fix component to the upper part of stand with an adapter to ensure a perfect axially.
 - c) Start the stand, in traction, I with a speed of 200 mm/min (0,8 in/min).

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2. Manual mode:

- a) Prepare reference bottle with relative accessories.
- b) Hook the weight to reference bottle.
- c) Grab the component, keeping the weight down and lifting it in vertical direction.

Proceed until one of the follow condition is verified:

- Detachment of components;
- Instrument indicates lower limit of pull tension

3.3. Final result

3.4.1. Interpretation of result

From the checks carried out it results that:

1. With the use of motorized stand:

- a) Force of detachment is ≥ 10 kg: Accepted Batch;
- b) Force of detachment is < 10 kg: Rejected Batch.

2. Manual mode:

- a) Lifting the component with the bottle, the weight is lifting up from the floor.: Accepted Batch
- b) Lifting the component with the bottle, the weight remain on the plan.: Rejected Batch

3.4.2. Finish product control card

At the end of the check the “finished product control card” is made out, on which the results obtained are shown.

The “finish product control card” is used c/o Euromakeup for incoming checks while to suppliers are given and recommended for use, considering that the supplier has the obligation to fill in/issue a declaration of conformity.

Based on what we will get the batch will be: “approved” or “rejected”.