



Titolo: Verification tests of lubrication signs

Cod. Doc.: ICP 023_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:

3.1. Campo di applicazione

Every glass articles.

3.2. Equipment:

- Caliber

3.3. Control method

After making the batch picking, according to iso 2859, i pezzi/prodotti are taken in bright rooms, taken in hand and checked at 90 cm distance.

The article must be observed perpendicularly at the visual so that the light cannot be mirrored. The article must be observed backlight. The distance at which they must be verified is 90 cm. La distanza a cui devono essere verificati i difetti è di 90 cm whether they are held in the hand or placed on a shelf.

If lubrication signs are found, they must be misured with the caliber and compared with the tables Tab.1 and Tab 2.

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3.4. Final result

3.4.1. Interpretation of results

From the checks carried out it results that:

- a) The amount of defeates is between established limits (Tab-Tab 2.) Approved Batch;
- b) The amount of defeates is over the limits. Rejected Batch.

3.4.1. Finished 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 finished 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 bound t o fill in/issue a declarationj of conformity.

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

Tab. 1 Dimensionamento segni di lubrificazione con AQL 1.5

Format (ml)	U.M.	Value
≤ 30	mm ²	7 x 7
30 ÷ 50	mm ²	15 x 15
50 ÷ 100	mm ²	22 x 22
> 100	mm ²	30 x 30

Tab. 2 Dimensionamento segni di lubrificazione con AQL 4.0

Format (ml)	U.M.	Value
≤ 30	mm ²	6 x 6
30 ÷ 50	mm ²	10 x 10
50 ÷ 100	mm ²	15 x 15
> 100	mm ²	22 x 22