

**ISTRUZIONE SGQ****Euromakeup S.r.l.**

Titolo: Thermal shock test

Cod. Doc.: ICP 035_1

Rev. 2

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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
- Supply specifications
- Single Sampling, special testing level S-3

2. Mode**3.1. Field of application**

All the articles independently the kind of production

3.2. Equipment

- Thermal shock chamber
- Water

3.3. Control method

After the batch picking, according to ISO 2859, the pieces/products that present “non-passing cuts” are tested with the help of a thermal shock chamber with the follow procedure:

- a) Set hot and cold water temperature for achieve a thermal excursion of 50°C (for example 90 °C/40°C or 70°C/20 °C)
- b) Immerse containers in water bath for 5 minutes.
- c) After 5 minutes samples are quickly extract and immerse in cold water for 30 seconds.
- d) At the end of thermal cycle the pieces are extract and verified by the operator.

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3.3. Final result

3.3.1. Interpretation of result

From the checks carried out it results that:

- a) If cuts don't propagate after test cycle , the defect is to be considered minor..
- b) If cuts propagate after test cycle , the defect is to be considered major.

3.3.1. 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 to fill in/issue a declarationj of conformity.

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