



ISTRUZIONE SGQ

Euromakeup S.r.l.

Titolo: Sealing test with scotch tape

Cod. Doc.: ICP 005_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. **Reference**

- Procedure CQA 01, GQA 04
- Single sampling, Special testing level S-3

3. **Mode**

3.1. **Field of application**

All the articles decorated with follow technologies:

- Serigrafy;
- Painting;
- Hot stamping H/S;
- Metallization;
- Other technologies for surface treatment of surfaces for decorative purposes.

3.2. **Equipment**

- Scotch tape with adesion force between 350 and 450 cN/cm² and wide of 19 mm (for example rif. 616 M di 3 M).

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2.3. Control method

After making the batch picking, according to ISO 2859, the parts / products are tested according to this procedure:

- Apply scotch tape on the tested surface Applicare lo scotch sulla superficie da testare: l'area da analizzare deve essere di dimensioni 50 x 19 mm. Solo in caso di capsule decorate con riga H/S, l'area da analizzare deve essere di 50 x 3 mm.
- Far aderire per bene lo scotch, avendo cura di eliminare eventuali bolle d'aria;
- Lasciare aderire lo scotch per almeno 60 secondi (1 minuto);
- Strappare con un colpo secco esercitando lo sforzo con un'inclinazione compresa tra i 45° e 90° rispetto alla superficie;
- Esaminare sia la superficie sia il nastro.

3.4. Final results

3.4.1. Interpretation of the results

From the checks carried out it results that:

- a) If there aren't missed parts on the decorated surface and no parts of it remain on the tape. Approved batch
- b) If there are missed parts on the decorated surface and/or part of decoration remain on the tape but the write is readable or :
 - a. Asportation is $\leq 2\%$ (4,4 mm x 4,4 mm) of tested surface
 - b. Asportation is $\leq 5\%$ (3,9 mm x 3.9 mm) of tested surface for decorated capsule with H/S line.Batch approved with reserve.
- c) If there are missed parts on the decorated surface and/or part of decoration remain on the tape and the write is unreadable or the asportation is $>$ of dimensions indicated in point b) Rejected Batch

3.4.2. Report test

At he end of the check, the "report test", on which the results of the checks carried out are reported, is fill in.

The report test 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 declaration of conformity.

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