



**ISTRUZIONE SGQ**

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Titolo: Uso del colorimetro CLM-194

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Cod. Doc.: ICP 034\_1

Rev. 2

Pag. 1 di 2

Data: 12/06/2018

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**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**

All the articles decorated with follow technologies:

- Serigrafy;
- Painting;
- Other technologies for surface treatments for decorative purposes

**3.2. Equipment**

- Little plate
- Pantone
- Color Range Board.
- Digital colorimeter CLM-194

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Pag. 2 di 2

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### 3.3. Control method

After the batch picking, according to ISO 2859, the pieces/products are taken and compared with a given reference:

- Little plate
  - Pantone
  - Color Range Board.
  - Approved samples
- a) Connect the tool to operator PC and open dedicated software:
  - b) For making the comparison, reference value is recorded, setting the colorimeter in "REFERENCE" mode (the letter R will light up on the display) push the instrument's right button until the letter R will light up.
  - c) Acquisire il valore di riferimento posando la lente dello strumento sulla superficie della placchetta/pantone/campione approvato e premendo il tasto sinistro. Il valore acquisito apparirà sul lato destro della schermata del programma.
  - d) Bring the instrument in "MEASUREMENT" mode using the right button. The mode will be confirmed by lighting of M letter on the instrument's display.
  - e) Acquire the reference value by positioning the lens of the instrument on the sample's surface and pushing the left button. On the left side of the display the acquired value will appeared.
  - f) The deviation on the space will appeared on the superior part of display.

### 3.4. Final result

#### 3.4.1. interpretation of results

If from checks carried out results that ::

- a) Deviation on the CIELAB space until 15 points respect plate/pantone.: Accepted Batch
- b) Deviation on the CIELAB space over 15 points respect plate/pantone: Rejected Batch.

#### 3.4.2. Test report

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"