



Titolo: Sealing test with the scotch tape

Cod. Doc.: ICP 010

Rev. 2

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Data: 30/10/2017

1. **Purpose**

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

2. **Riferimenti**

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

3. **Mode**

3.1. **Feild of application**

All the articles decorated with follows technologies:

- Serigrafy;
- Painting;
- Hot printing H/S;
- Metallization;
- Other technologies for surface treatments for decorative purposes.

3.2. **Equipment**

- Scotch tape with a force adesion between 350 and 450 cN/cm² (for example rif 616 M of 3M)
- Cutter

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3.3. Control method

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

- Cut a reticulate on the tested surface of 6x6 little squares spaced between them 1 mm, for create squares of 1mm².
- Apply the scotch tape on the tested surface
- Stick the scotch well taking care to eliminate eventual air bubbles
- Leave it to stick at least 60 seconds (1 minute)
- Tear off with a snap exercising the effort with an inclination between 45°÷ 90°
- Check both the surface and the scotch tape.

3.4. Final results

3.4.1. Interpretation of results

If ,from the checks performed ,the squares are detached from the grid.:

- a) 10% ÷ 14% (> 3 ÷ ≤ 5 squares - ≤ 5mm²): approved batch;
- b) >14% ÷ 18% (> 5 ÷ ≤ 7 squares - ≤ 7mm²): batch approved withy reserve;
- c) > 18% (≥ 7 quadratini - ≥ 7mm²): 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 t o fill in/issue a declarationj of conformity.

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