



ISTRUZIONE SGQ

Titolo: Sealing test at alcohol

Cod. Doc.: ICP 011_1
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Rev. 2
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. Riferimenti

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

3. Mode

3.1. Field 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

- Denatured alcohol 90°;
- Hydrophile cotton.

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Verificato da :

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3.3. Metodo di controllo

After the batch picking, according to ISO 2859, the pieces/products are taken after wetting the cotton swab with alcohol.

- Rub 10 times the pieces of bottles/capsule/cover that undergo decorations. (every movement is considered by moving there and back again)

3.4. Risultato finale

3.4.1. Interpretations of results

From the checks carried out it results that:

- a) The cotton swab has color residues but the decoration results unchanged or the surface isn't opaque.: approved batch;
- b) The cotton swab is dirty of color and the decoration is readable although it is removed(on sample definition) Batch approved with reserve
- c) The cotton swab is dirty and the decoration is unreadable, or the the surface is opaque. 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 declaration of conformity.

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