

**ISTRUZIONE SGQ****Euromakeup S.r.l.****Titolo: Dimensional control****Cod. Doc.: ICP 003_1****Rev. 2****Pag. 1 di 3****Data: 12/06/2018****1. Purpose**

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

2. References

- Procedure CQ 01, GQ 04
- Drawings
- Single sampling, current testing level II

3. Mode**3.1. Field of application**

All the matching articles that must guarantee the seal between them regardless of the type of production.

3.2. Equipment

- Caliber
- Depth caliber

3.3. Control method

After having done the picking of the batch, according to ISO 2859, the pieces / products are brought on a desk where they will be checked as follows :

- Diameters are measured with the caliber in two points:
 1. As close as possible to the conjunction of the mold without touching it;
 2. 90° from the previous measure.

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As for the inside diameter of the mouth, the measurement must be made between the plain of the mouth and 2-3mm inside of the mouth.

If the product isn't round the two dimensions must be measured: width and depth.

For external diameters the measurements must be done on 3 points:

1. To the shoulder;
2. In the center;
3. On the bottom.

- The height of the neck is measured with the caliber in 4 points:
 1. 2 measurements as close as possible to the mold conjunction, without touching it;
 2. 2 measurements at 90° from the previous measurements one on each side.
- The total height of the product is measured with the caliber in 2 points:
 1. As close as possible to the conjunction of the mold, without touching it;
 2. 90° from the previous measurement.
- The internal height of a product / jars is measured with the depth calibre in 2 places:
 1. As close as possible to the conjunction on the mold, without touching it;
 2. 90° from previous measurement.

The dimension to be considered is the arithmetic average between the measured

3.4. Final results

3.4.1 Interpretation of results

From the checks carried out it results that:

- a) If the dimensions fall within the tolerance indicated in the specification for the number of samples indicated in the AQL: the batch is accepted;
- b) If the dimensions don't fall within the tolerances indicated in the specification for a number of samples greater than 1 with respect to the limits set by AQL (refers to the major defects): the batch is accepted with reserve;
- c) If the dimensions don't fall within the tolerances for a number of samples greater than 2 compared to the limits imposed by AQL (refer to major defects). The batch is rejected;

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3.4.2 Test report

At the end of the checks, the “test report” is completed, which shows the average value of the quotas found.

The test report is used c/o Euromakeup for incoming checks while to suppliers are given and recommended for use, considering that the supplier is in any case obliged to fill out / issue a declaration of conformity.

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