



Titolo: Fall test

Cod. Doc.: ICP 020_1

Rev. 1

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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 **References**

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

3. **Mode**

3.1. **Fiel of application**

Finished products completely independent by tipology of production.

3.2. **Equipment**

- Tubo Ø 25,0mm e Ø 150,0mm di altezza h 100,00cm fissato verticalmente su un supporto con piano a superficie rigida (alluminio). La distanza tra il bordo inferiore del tubo ed il piano inferiore rigido dovrà essere di 40,0cm;
- Superficie rigida inclinata a 45° fissata a 100,00 cm;
- Forno: 45°C;
- Congelatore: 0°C ($\pm 1^\circ\text{C}$).

3.3. **Metodo di controllo**

After making the batch picking, according to iso 2859, the pieces/products are tested by closing them , possibly, with original packaging, considering that :

- A. Test conditions for making tests :Condizioni di prova per effettuare il test: room temperature;
- B. Thermal stress: only under customer's request:
- Put the bottles in an oven at 45°C for 24 h
 - Extract the bottles and put them in a freezer at 0°C

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The test procedure is the same for both test conditions:

- Fill the bottles for 50% of the content and close them
- Mettere il flacone nel tubo, tenendolo dalla capsula, e lasciarlo cadere liberamente;
- Repeat the operation , keep the bottle by the bottom.
- Put the bottle in horizontal position and let it fall freely. Rest the bottle on a inclined surface and let it fall freely.

The product must be fall from 100 cm on the rigid surface. Make sure that the bottle impacts, on the rigid surface, with the bottom.

3.4. Final result

3.4.1 Inerpretation of results

From the checks caried out it results that:

- a) If bottles don't undergo alterations : Approved Batch
- b) If it occurs that the bottles break, produce cracks or are pierced, for a number over the AQL estabilished limits. Rejected Batch
- c) If it occurs that bottles are crushed but not broken. Approved with reserve.

3.4.2 Test report

At the end of the tests the "test report", where the test results 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 obligation to fill in/issue a declaration of conformity.

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