



Titolo: Traction test dipstick/capsule

Cod. Doc.: ICP 018_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. **Field of application**

Components assembled independently of assembly tipology or apply technology

3.2. **Equipment**

- Motorized column stand. Scale 1000N;
- Manual stand . Scale 200N

3.3. **Control method**

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

1. With the use of Motorized stand:
 - a) Fix the applicator to the base of stand with a clamp that increase the socket under traction. The capsule must be facing up.
 - b) Fix the capsule with an adapter to ensure perfect axially.
 - c) Start the stand with a speed of 200 mm/min (0,8 in/min).

Written by: CQ
S. Gulli

Verify by:

Approved by: GQ
P. Foiani

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2. With the use of manual stand:
 - a) Insert the threaded hook in the scraper and screw the nut,
 - b) Insert the scraper comprehensive of hook in the bottle. Verify that the bottle's neck doesn't show any fracture or breakage.
 - c) Fix the bottle on the base of stand;
 - d) Connect the bottle hook with the supportive hook, ensuring perfect axiality.
 - e) Start traction by lowering the lever.

until one of the following conditions occurs:

- Detachment of the components;
- The instrument indicates the minimum value of traction. (indicates in Tab 1)

3.4. Final result

3.4.1. Interpretazione dei risultati

From the checks carried out it results that::

1. With the use of Motorized stand:
 - a) The force of detachment is \geq of indicated value in Tab. 1: Acceptend batch;
 - b) The force of detachment is $<$ of indicated value in Tab. 1: Rejected batch.
2. Manuale:
 - a) Lifting the capsule, the weight rises from the floor and the applicator remain attached to the dipstick. Accepted batch;
 - b) Lifting the capsule, the weight remains on the floor and the applicator comes off: Rejected batch.

3.4.2. Finish product control card

At the end of the check the "finished product control card" is made out, on which the results obtained are shown.

The "finish 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 obligation to fill in/issue a declaration of conformity.

Based on what5 we will get the batch will be: "approved" or "rejected".

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Tab. 1 Forces of detachment

<i>Tipologia</i>	<i>U.M.</i>	<i>Valore</i>
Dipstick / capsule	Kgf	≥ 2,7
Dipstick / lacquered capsule	Kgf	≥ 1,5
Dipstick / metallic capsule	Kgf	≥ 2,7