

**ISTRUZIONE SGQ****Euromakeup S.r.l.**

Titolo: Vacuum sealing test

Cod. Doc.: ICP 002\_1

Rev. 6

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Data: 25/03/2023**1. Purpose**

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

**2. References**

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

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

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

**3.2. Equipment**

- Vacuum bell

**3.3. Control method**

Euromakeup will provide a set of items (containers and their fittings) to perform the tests.

According to ISO 2859, after making the batch picking, the pieces/products are tested, ideally, by closing them with their own capsules.

*The closing must be performed with the torsion forces indicated in the ICP004 procedure – “Tightening tests”.*

Consider that:

- For bottles and jars, the filling is up to the shoulder.
- For mascara and lip gloss, the filling must be  $\frac{3}{4}$  of the container.
- For bottles, mascara, and lip glosses, a colored liquid is used for filling.
- For jars, airless, bottles with total wood pump and refill closures, the “Nivea Body Cream” or similar is used for filling or a cream with equal viscosity ~ cP 1000.

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Viscosity determination data:

- Speed: 10 r.p.m.
- Spindle: RV2
- Analysis time: 60sec
- Analysis temperature: 25°C

You can perform 2 different tests:

- A. The pieces are placed inside the bell, on a sheet of absorbent paper in a horizontal position:
- Bottles, mascara, lip gloss and bottles with total wood pump are brought to -40 cmHg (-0,53 Atm) for a 15-minute period.
  - Jars, airless, and refill closures are brought to -20 cmHg (-0,26 Atm) for a 5-minute period.
- B. If you don't have a vacuum bell, you can initially run the tests by inverting the pieces, making them lean on their proper fitting on a sheet of absorbent paper for a 24-hours period.

At the end of the test the result will be checked.

### **3.4. Final results**

#### **3.4.1 Interpretation of results**

From the checks carried out it result that:

1. If it verifies that the sheet of paper is wet, for a number exceeding the limits established by the AQL: rejected batch;
2. If, after the test, removing the capsule the bottle neck is wet: batch is approved with reserve;
3. It, after the test, removing the capsule, the neck of the bottles is dry or there are some droplets on the thread: batch is approved

#### **3.4.2 Test report**

At the end of the tests the "test report" is completed, on which the results of the tests carried out are reported.

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.

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