



Titolo: Traction test scraper / bottle

Cod. Doc.: ICP 019_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

3.2. **Metodo di controllo**

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) 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 the stand with a speed of 200 mm/min (0,8 in/min)

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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.

3.4. Final result

3.4.1. Interpretation of the results

From the checks carried out it results that:

1. With the use of motorized stand:

- a) The force of deteachment is $\geq 2,2\text{Kgf}$: Accepted Batch;
- b) The force of deteachment is $< 2,2\text{Kgf}$: Rejected Batch.

2. In modalità manuale:

- a) Lifting the bottle, the weight rises from the floor and the scraper remain into the neck of the bottle. Accepted batch;
- a) Lifting the bottle, the weight remain on the floor and the scaper 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 what we will get the batch will be: "approved" or "rejected".