



Titolo: CONTROL OF THE DISTRIBUTION OF THE MATERIAL

Cod. Doc.: ICP 008_1**Rev. 2****Pag. 1 di 2****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. Reference

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

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

All the articles that are produced with blow moulding / injection – blow moulding / injection

3.2. Equipment

- Cutter
- Caliber

3.3. Control method

After making the batch picking, according to ISO 2859, the pieces / products are taken and cut along the circumference / perimeter in three points:

1. Under the shoulder;
2. Half-body;
3. Above the bottom.

After that, for cylindrical products, are made two further measurements:

1. Two measurements as close as possible to the conjunction of the mold, without touching it;
2. Two measurements at 90° compared to previous ones.

For products of other shapes, are made four measurement in specular and opposite point.

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3.4. Final results

3.4.1. Interpretation of the results

From the checks carried out it results that:

- a) If the difference in thickness is $\leq 0,3\text{mm}$: approved batch;
- b) If the difference in thickness is between $0,3\div 0,5\text{mm}$: batch approved with reserve;
- c) If the difference in thickness is $\geq 0,5\text{mm}$: rejected batch;

3.4.2. Final results

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

The finished 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”.