

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

Titolo: Screwing test

Cod. Doc.: ICP 004_1

Rev. 6

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Data: 10/06/2018**1. Purpose**

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

2. References

- CQA 01, GQA 04 procedures_
- Single sampling, Special testing S3 level

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

All the articles that must be matched with a capsule/cover independently of tipe of production.

3.2. Equipment

- Torque meter 100Kgf.cm (10N.m)

3.3. Control method

After making the batch picking, according with ISO 2859:

- The covers are fixed at the base of the torque meter, with a hand keep the instrument and with the other rotate the capsule/cover with a constant and continuos movement.
- Screw the capsule/cover at the bottle/vase, fix the instrument at the capsule/cover, with a hand keep the bottle/vase and with the other turn all up, after having hooked the weight to the instrument.

Until is not occurs:

- Detachment of the component;
- The measure exceeds the value in Tab.1

The value of the torsion force is acceptable Il valore della forza di torsione accettabile a cui un prodotto deve resistere è funzionale al diametro della filettatura ed è elencato in Tab.1.

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3.4. Final result

3.4.1. Interpretation of the results

From the checks carried out it results that:

1. Applying the standard value indicated in Tab. 1 : approved batch.
2. Applying the maximum value corresponding at "Applicable torsion" indicated in Tab 1 the capsule jump: Batch approved with reserve.
3. Applying the Standard value indicated in Tab1 the capsule jump. Rejected batch.

3.4.2. Report test

At the end of the check, the "report test", on which the results of the checks carried out are reported, is filled 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 bound to fill in/issue a declaration of conformity.

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

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Tab.1: Torsion force applicable, in base of diameter

Neck diameter		Applicable torsion force (pound/inches)	Applicable torsion force (Kgf.cm)	Applicable torsion force for removal (pound/inches)	Applicable torsion force for removal (Kgf.cm)
mm	inches				
8	0.3	3 ÷ 7	3.5 ÷ 8.1	2 ÷ 4	2.3 ÷ 4.6
10	0.4	4 ÷ 8	4.6 ÷ 9.2	2 ÷ 4	2.3 ÷ 4.6
13	0.5	5 ÷ 9	5.8 ÷ 10.4	3 ÷ 5	3.5 ÷ 5.8
15	0.6	5 ÷ 9	5.8 ÷ 10.4	3 ÷ 5	3.5 ÷ 5.8
18	0.7	7 ÷ 10	8.1 ÷ 11.5	3 ÷ 5	3.5 ÷ 5.8
20	0.8	8 ÷ 12	9.2 ÷ 13.8	4 ÷ 6	4.6 ÷ 6.9
22	0.88	9 ÷ 14	10.4 ÷ 16.1	4 ÷ 6	4.6 ÷ 6.9
24	0.95	10 ÷ 18	11.5 ÷ 20.7	4 ÷ 11	4.6 ÷ 12.7
28	1.1	12 ÷ 21	13.8 ÷ 24.2	5 ÷ 12	5.8 ÷ 13.8
30	1.2	13 ÷ 23	15 ÷ 26.5	6 ÷ 14	6.9 ÷ 16.1
33	1.3	15 ÷ 25	17.3 ÷ 28.8	6 ÷ 15	6.9 ÷ 17.3
38	1.5	17 ÷ 26	19.6 ÷ 30	7 ÷ 16	8.1 ÷ 18.4
43	1.7	17 ÷ 27	19.6 ÷ 31.1	7 ÷ 20	8.1 ÷ 23
48	1.9	19 ÷ 30	21.9 ÷ 34.6	8 ÷ 18	9.2 ÷ 20.7
53	2.1	21 ÷ 36	24.2 ÷ 41.5	9 ÷ 22	10.4 ÷ 25.3
58	2.3	23 ÷ 40	26.5 ÷ 46.1	10 ÷ 24	11.5 ÷ 27.6
63	2.52	25 ÷ 43	28.8 ÷ 49.5	10 ÷ 26	11.5 ÷ 30
66	2.64	26 ÷ 45	30 ÷ 51.8	11 ÷ 27	12.7 ÷ 31.1
70	2.8	28 ÷ 50	32.3 ÷ 57.6	12 ÷ 30	13.8 ÷ 34.6
83	3.3	32 ÷ 60	36.9 ÷ 69.1	16 ÷ 36	18.4 ÷ 41.5
86	3.44	40 ÷ 65	46.1 ÷ 74.9	16 ÷ 39	18.4 ÷ 44.9
89	3.56	40 ÷ 70	46.1 ÷ 80.6	18 ÷ 42	20.7 ÷ 48.4
100	4	45 ÷ 70	51.8 ÷ 80.6	18 ÷ 44	20.7 ÷ 50.7
110	4.4	45 ÷ 70	51.8 ÷ 80.6	19 ÷ 49	21.9 ÷ 56.5