


QUALITY CONTROL DOCUMENT

ASEPT

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| Article Name: Pouch Clip UNI White |  | Tool ID#: V-670 | Material [Name / Grade] Akulon F223-D Material Specification |
| Article No.: 7857 | | Insert/s: - | Masterbatch [Name / Grade] Unicolor 60230-1 MB Specification |
| Product family | | Date symbol NO | Logo NO |
| | | Release date 2022-05-04 | Cavities - |
| Document approval by: DC | Document Rev. 0 | Article Drawing #: 7857 | Drawing rev. P3 |
| Related documents: IM setting protocol | | | |

| POS | ITEM OF INSPECTION | FREQ | METHOD | REQUIREMENT | ACTION |
|-----|---------------------|---|---------|---|--|
| 1 | Part weight | 1) 5 pcs at start up 2) 5 pcs every 6h | Scale | 3.5 ± 0.25 [gr] | Reject parts Review process settings |
| 2 | Completely filled | 1) 5 pcs at start up 2) 5 pcs every 6h | Visual | Part 100% filled | Reject unfilled part |
| 3 | Color | 1) 5 pcs at start up 2) 5 pcs every 6h | Visual | Compare to reference part | Reject parts Rework permitted Check tool and process |
| 4 | Flash | 1) 5 pcs at start up 2) 5 pcs every 6h | Visual | No burr in parting lines. Compare to reference part Max 300µm | Reject part. Check and review process parameters |
| 5 | Dimension (CR1) | 1) 5 pcs at start up 2) 5 pcs every 6h | Caliper | See Drawing | Reject part. Check and review process parameters |
| 6 | Sink-marks | 1) 5 pcs at start up 2) 5 pcs every 6h | Visual | No visual sink marks. Compare to reference part | Reject part. Check and review process parameters |
| 7 | Demoulding marks | 1) 5 pcs at start up 2) 5 pcs every 6h | Visual | <1mm | Reject part |
| 8 | Spike at inj. point | 1) 5 pcs at start up 2) 5 pcs every 6h | Visual | <800µm | Reject part Adjust gate or nozzle |