

# CQS 101

## CRITICAL TO QUALITY SPECIFICATION

|                      |                     |
|----------------------|---------------------|
| Company Ref :        | 11648               |
| Customer :           | House Tool          |
| Part Name / Number : | Produce box         |
| Part Purpose :       | Produce Box and Lid |

| General Specification      |                        | Quality Criteria                                                    |
|----------------------------|------------------------|---------------------------------------------------------------------|
| Press / Tool Size:         | Erlrnbach1395/87       | <input checked="" type="checkbox"/> Parts are contamination free    |
| Pieces on tool / Cavities: | 6 (3 bases and 3 Lids) | <input checked="" type="checkbox"/> Ensure part is well fused       |
| Material :                 | EPS                    | <input checked="" type="checkbox"/> Ensure no post expansion        |
| Material Grade :           | Std EPS (Non FRA)      | <input checked="" type="checkbox"/> No protruding fill gun markings |
| Bead colour :              | White                  | <input checked="" type="checkbox"/> All area's to be free of flash  |
| Pre-foam Material:         | 22g/l                  | <input checked="" type="checkbox"/> No intruding fill gun markings  |
| Target cycle time :        | 80s                    | <input checked="" type="checkbox"/> No broken or damaged parts      |
| Moulded density - min :    | 22.5g/l                | <input checked="" type="checkbox"/> No damaged or proud core vents  |
| Moulded density - target : | 25g/l                  | <input checked="" type="checkbox"/> Remove surface water            |
| Moulded density - max :    | 27.5g/l                | <input checked="" type="checkbox"/> Check for pick up markings      |

| Description                      |           |       |       |          |  |
|----------------------------------|-----------|-------|-------|----------|--|
| Characteristic                   |           | Base  | Lid   | Combined |  |
|                                  | Tolerance |       |       |          |  |
| Wet weight                       | Min       | 222   | 62    | 284      |  |
|                                  | Target    | 241   | 67.5  | 309      |  |
|                                  | Max       | 259   | 73    | 332      |  |
| Dry weight                       | Min       | 202   | 44    | 246      |  |
|                                  | Target    | 224   | 49    | 273      |  |
|                                  | Max       | 247   | 53    | 300      |  |
| Fusion                           | Min       | 50%   | 50%   | 50%      |  |
|                                  | Target    | 70%   | 70%   | 70%      |  |
|                                  | Max       | 100%  | 100%  | 100%     |  |
| Critical dim. 1<br>(X-dimension) | Min       | 398mm | 398mm | 398mm    |  |
|                                  | Target    | 400mm | 400mm | 400mm    |  |
|                                  | Max       | 402mm | 402mm | 402mm    |  |
| Critical dim. 2<br>(Y-dimension) | Min       | 298mm | 298mm | 298mm    |  |
|                                  | Target    | 300mm | 300mm | 300mm    |  |
|                                  | Max       | 302mm | 302mm | 302mm    |  |
| Critical dim. 3<br>(Z-dimension) | Min       | 257.5 | 35.5  | 293      |  |
|                                  | Target    | 260   | 37    | 282      |  |
|                                  | Max       | 262.5 | 38.5  | 301      |  |
| Volume                           | Actual    | 8.972 | 2.515 | 11.4     |  |



