

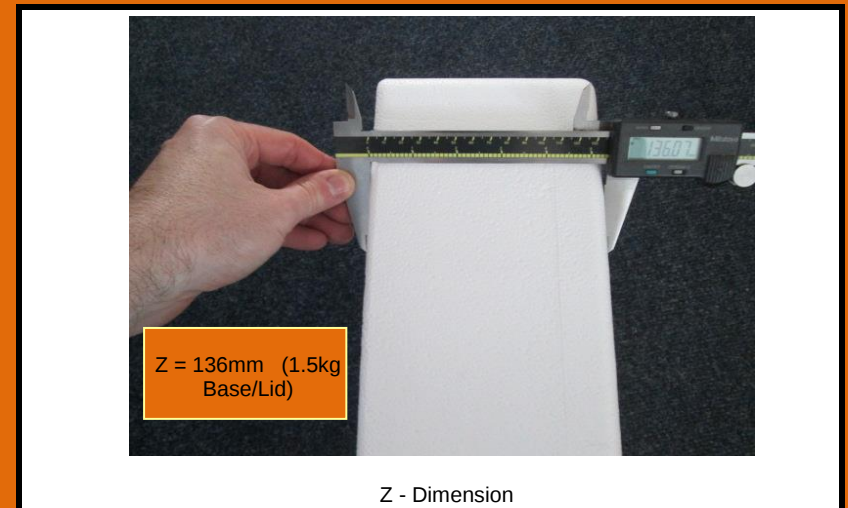
CQS 101

CRITICAL TO QUALITY SPECIFICATION

Company Ref :	114180
Customer :	House Tool
Part Name / Number :	1.5 KG Fish box and Lid (With and Without Holes)
Part Purpose :	Fish Box and Lid

General Specification		Quality Criteria
Press / Tool Size:	K813	☒ Parts are contamination free
Pieces on tool / Cavities:	8 (4 bases and 4 Lids)	☒ Ensure part is well fused
Material :	EPS	☒ Ensure no post expansion
Material Grade :	STD EPS (Non FRA Med)	☒ No protruding fill gun markings
Bead colour :	White	☒ All area's to be free of flash
Pre-foam Material:	18g/l	☒ No intruding fill gun markings
Target cycle time :	60s	☒ No broken or damaged parts
Moulded density - min :	18g/l	☒ No damaged or proud core vents
Moulded density - target :	20g/l	☒ Remove surface water
Moulded density - max :	22g/l	

Description					
Characteristic		Base	Lid	Combined	
	Tolerance				
Wet weight	Min	59g	20g	79g	
	Target	65g	22g	87g	
	Max	72g	24g	96g	
Dry weight	Min	52g	18g	70g	
	Target	58g	20g	78g	
	Max	64g	22g	86g	
Fusion	Min	50%	50%	50%	
	Target	70%	70%	70%	
	Max	100%	100%	100%	
Critical dim. 1 (X-dimension)	Min	338mm	338mm	338mm	
	Target	340mm	340mm	340mm	
	Max	342mm	342mm	342mm	
Critical dim. 2 (Y-dimension)	Min	198mm	198mm	198mm	
	Target	200mm	200mm	200mm	
	Max	202mm	202mm	202mm	
Critical dim. 3 (Z-dimension)	Min	119.5mm	28.5mm	134.5mm	
	Target	121mm	30mm	136mm	
	Max	122.5mm	31.5mm	137.5mm	
Volume	Actual	2.912 L	0.981 L	3.893 L	



1.5 outer = CHOUT 1.5kg box 343mm x 203mm x 138mm, weight 130grms