

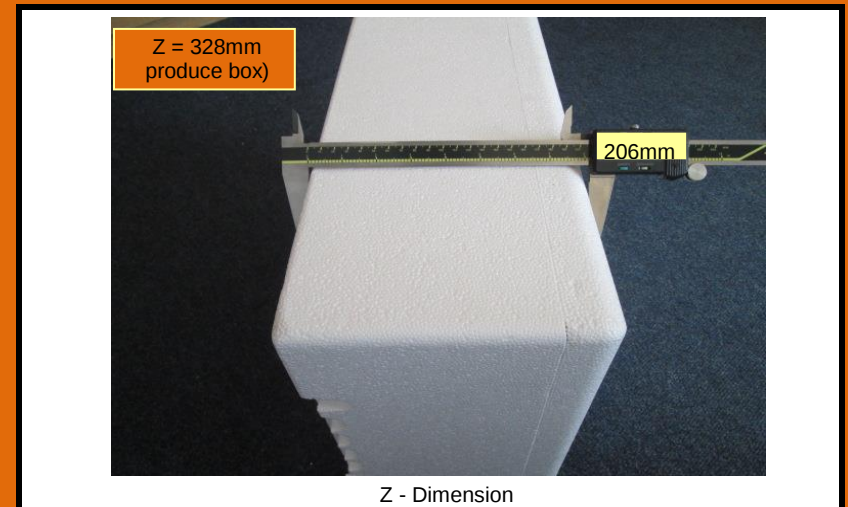
CQS 101

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	☒ Parts are contamination free
Pieces on tool / Cavities:	6 (3 bases and 3 Lids)	☒ Ensure part is well fused
Material :	EPS	☒ Ensure no post expansion
Material Grade :	Std EPS (Non FRA)	☒ No protruding fill gun markings
Bead colour :	White	☒ All area's to be free of flash
Pre-foam Material:	22g/l	☒ No intruding fill gun markings
Target cycle time :	80s	☒ No broken or damaged parts
Moulded density - min :	22.5g/l	☒ No damaged or proud core vents
Moulded density - target :	25g/l	☒ Remove surface water
Moulded density - max :	27.5g/l	☒ 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 (X-dimension)	Min	398mm	398mm	398mm	
	Target	400mm	400mm	400mm	
	Max	402mm	402mm	402mm	
Critical dim. 2 (Y-dimension)	Min	298mm	298mm	298mm	
	Target	300mm	300mm	300mm	
	Max	302mm	302mm	302mm	
Critical dim. 3 (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	



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Produce Outer box 403mm x 203mm x 283mm, weight 280grms