

Quality Control Specifications

Version: 2 **Issued By:** S. Perrott **Date:** 24 November 2008

Distribution: QC file, Customer Service

- a. This form is the Master Template for Quality Control Specifications for all products manufactured by Perroplas One.
- b. The QC number must be matched to the correct Production Order
- c. Each Quality Control Specification is personalised to the individual products and must be read, understood, and followed implicitly by the Machine Operators.
- d. After each run, this Quality Control Specification must be returned to the file in the Supervisors Office
- e. The Supervisors are to complete the Quality Assurance Log in line with the Quality Testing guidelines below.
- f. IF IN DOUBT, ASK!

Product:	HWC TRAY MEDIUM	QSF11-02
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- 1.0 Material**
As per Production Order

- 2.0 Product Weight**
0.970kg

- 3.0 Dimensions**
535mmW x 535mmL x 55mmH

- 4.0 Colour**
As per Production Order
Consistent colour density and dispersion

- 5.0 Labelling**
Pallet label on bottom right hand corner of pallet

- 6.0 Packaging**
Pack 10 per 90cm Bag
200 per unmarked pallet

- 7.0 Presentation**
No shorts
No flash
No hole where sprue has been cut off
Maximum sprue height 1mm
No burns, dirt, oil, grease or streaks or specks
Consistent density over product
Surface must be without stress marks or patchiness or rust marks
Requires a good trimming finish without gauges or nicks.

8.0 Operation

Take moulding from machine and re-cycle machine
 Check quality
 Using a knife, trimmer and side cutter, remove sprue and any excess flash
 Attach labels and components where required
 Pack as instructed

9.0 Inspection

- Operators are to inspect products while trimming and packaging.
- Supervisors/ Leading Hands are to perform Quality Test at least twice per shift and/or when product movements are recorded.

10.0 Quality Test

- All products must comply with all factors of this Specification when being Quality Tested.
- The strength of the product must be suitable to perform its intended purpose.
- Compare with standard samples for overall strength and rigidity.
- To test strength, perform one of the following test which best imitates the products intended purpose when cooled:

ACTION		DESIRED RESULT
1)	Roll product across floor	Wheels roll with ease
		Wheels to do not come off product, or break
2)	Move swing top lids in normal fashion	Lid moves freely without restriction
3)	Sit on chairs and move from side to side, & back to front	Legs should remain strong, no breakage or excessive movement
4)	Attach lid and clip handles	Lid fits on top of base
		Handles clip firmly over lids
5)	Place weight in middle of product not exceeding 5kg	Product does not crack or bend excessively
6)	With weight in place, lift product using handle to waist height	Product does not crack or bend excessively
		Handles do not crack, bend excessively or break
		Wheels do not fall out
7)	Add pressure to product where you would normally expect, ie citrus squeezer, on top	Product does not crack or break
8)	Assemble to ensure correct fit	Parts should all fit correctly without gaps or excessive force

11.0 Amendments

No.	Date	Version	By	Customer Acceptance	Amendment