

QUALITY CONTROL ON THE RAW MATERIALS

- References:
 - o Control Quality plan
 - o Instruction for quality controls on raw material
- Management of the parameters:
 - o area weight
 - o thickness
 - o width
 - o mechanical characteristics
 - o melt flow index

SETTING MACHINE

- References:
 - o "Parameters machine tab for Prodeso Heat"
 - o "Preparation machine for Prodeso Heat production"
 - o "Start machine tab"
- Management of the parameters:
 - o process temperatures
 - o preparation machine
 - o extrusion parameters
 - o tension of the non woven and of the finished product

PRODUCT PARAMETERS

- References:
 - o "Packing list raw materials"
 - o "Instruction of Production and Control"
 - o weekly production plan
- Management of the parameters:
 - o raw materials
 - o packaging
 - o pallet preparation
 - o labeling
 - o characteristics of the product (area weight, thickness, length, width, winding roll , weight roll)

QUALITY CONTROL ON THE FINISHED PRODUCT

- References:
 - o "Instruction of Production and Control"
 - o "Quality Control Tab for Prodeso Heat "
- Management of the parameters:
 - o frequency and controls
 - width – area weight – roll weight - thickness: 1 roll for the first pallet, repeat every 5 pallets
 - roll length: 1 roll for the first pallet, repeat every production shift
 - adhesion of the non woven and wire placement: 1 roll for the first pallet, repeat every 5 pallets
 - Compression test: 1 roll for the first pallet, repeat every production shift
 - No visible defects

TEST					
Type of Test	Test Spec.		Frequency	Measures	Documentations
area weight	840 g/m²	+/-10%	1 roll of the first pallet, repeated every 5 pallets	All the test are managed according to the internal quality IQA 172 "Quality Control and Conformity procedures for Prodeso Heat"	All test results are to be recorded in the production test documents
width	99 cm	+/-0,5 cm			
thickness	6 mm	+/-0,5 mm			
roll length	15,15 m	+1/- 0%	1 roll of the first pallet, repeated every production shift		
	5,05 m	+1/- 0%			
Visible defects	Visual inspection		ongoing		