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| **Referencia:** 1963/0/0  **Denominación:** Tarro 50ml Bajo T107 | **Fecha plano :** 04/08/2016  **Cavidades:** 2/2 | **Material :** SMMA **Máquina :** 40  **Color:** INCOLORO |

***INFORME INYECCIÓN***

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| **Motivo informe** : |

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| **Observaciones :** |

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| **Conclusiones :** |

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| **Responsable Inyección :** Joan Fíguls  **Fecha :** |

***INFORME CALIDAD HOMOLOGACIÓN***

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| ***INFORME DIMENSIONAL***   |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | | **Nº Cota** | **Nominal (mm)** | **Tolerancia** | **1934/0/0** | **Fig. 1** | **Fig. 2** | **Resultado** | | **1** | **Ø73,5** | **-0.2 / 0** | **Ø73,5** | Ø73,5 | Ø73,5 | Ok | | **2** | **Ø66,28** | **-0.2 / 0** | **Ø66,0** | Ø65,7 | Ø65,9 | **No ok** | | **3** | **Ø64,0** | **-0.2 / 0** | **Ø64,1** | Ø63,8 | Ø63,6 | **No ok** | | **4** | **Ø62,2** | **-0.2 / 0** | **Ø62,6** | Ø62,4 | Ø62,4 | Ok | | **5** | **Ø61,4** | **-0.2 / 0** | **Ø61,5** | Ø62,0 | Ø61,9 | Aceptado | | **6** | **Ø60,0** | **0 / +0,2** | **Ø60,0** | Ø60,0 | Ø60,0 | Ok | | **7** | **9,0** | **-0,1 / 0** | **8,8** | 9,0 | 9,0 | Ok | | **8** | **36,6** | **-0.2 / 0** | **36,3** | 36,6 | 36,6 | Ok | | **9** | **Ø72** | **+/- 0,2** | **Ø71,8** | Ø72,1 | Ø72,1 | Ok | | **10** | **2,0** | **0 / +0,2** | **2,3** | 3,3 | 3,3 | Aceptado | | **11** | **31,3** | **0 / +0,2** | **30,7** | 30,0 | 29,9 | Aceptado | | **12** | **Rosca 2 entradas** | **------** | **oK** | **\*1** | **\*1** | **No ok** | | **13** | **2,0** | **0 / +0,2** | **2,0** | 2,1 | 2,1 | Ok | | **14** | **0,5** | **+/- 0,2** | **1,0** | 1,0 | 0,9 | Ok | | **Rebabas** | **Ok/ NoK** | **------** | **OK** | OK | OK | OK | | **Montaje Cubilete** | **Ok/ NoK** | **------** | **OK** | **\*2** | **\*2** | Ok | | **Roscado tapa** | **Ok/ NoK** | **------** | **OK** | **\*3** | **\*3** | **No ok** |   La cota nº 5 no se puede coger la medida con una exactitud del 100% ya que no se tienen los medios adecuados ( es una medida aproximada). |

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| **Observaciones :**  **\*1** La figura 1 la entrada de rosca es progresiva y la figura 2 la entrada está cortada.  **\*2** Montaje cubiletes en máquina nº 30 :  - 25 Tarros + Cubilete Fig. 2 a 4bares **( se han montado todos).**  - 25 Tarros + Cubilete Fig. 1 a 5bares se han montado 24 + 1 Cubilete a 6bares.  EN LA MAQUINA **Nº30** TRABAJANDO A **6 BARES** SE MONTARAN TODOS LOS CUBILETES.  **\*3** Las tapas roscan bién pero tienen juego ( una vez roscada hasta final no tiene juego). |

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| **Conclusiones :**   1. Ajustar cota nº 2 y nº 3 para que la tapa tenga menos juego y no se monte a presión. 2. Hacer el inicio y final de rosca en los 2 tarros igual ( como fig. 1). 3. Marcar nº de figura en los 2 tarro. |

***INFORME REALIZADO***

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| **Responsable Calidad :** Quicu Estebanell  **Fecha :** 20/02/2017 |

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