|  |  |  |
| --- | --- | --- |
| **Referencia:** 2013  **Denominación:**  CUBILETE 15 ML (6 CAV.) | **Fecha plano : ¿???**  **Cavidades:** 6/6 | **Material :** PP  **Color:** BLANC |

***INFORME***

|  |
| --- |
| **Motivo informe** :  Comprobación de medidas y montaje después del ajuste de la forma del clip. |

***INFORME CALIDAD***

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Se realiza una primera prueba montando los cubiletes manualmente en varios tarros de 30ml y 15ml  Dando como resultado:   * los cubiletes no giran * el anclaje correcto, salvo en la figura nº 4 que se parte   Hacemos pruebas de montaje en la maquina automática variando las presión :  0,1 kg se rompe la figura nº 4 aunque con esta fuerza los demás cubiletes no acaban de montarse  0,25 kg se rompe la figura nº 4 los cubiletes montan bien.  0,45 kg se rompe la figura nº 4 los cubiletes montan bien.es la presión normal de montaje.  Se toman medidas para verificar que son correctas   |  |  |  |  |  |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | | **Figura** | **Maquina** | | **EXTERIOR** | | **INTERIOR** | | **PROFUNDITAT** | | **ALÇADA TOTAL** | | **Pes** | | | **47,30** | | **40,50** | | **18,20** | | **18,50** | | | **+ / -** | | **+ / -** | | **+ / -** | | **+ / -** | | | **0,20mm.** | | **0,20mm.** | | **0,20mm.** | | **0,20mm.** | | | Fig. 1 | | 19 | | 47,26 | | **40,72** | | **17,88** | | **19,01** | | 1,93 | | | Fig. 2 | | 19 | | 47,23 | | 40,67 | | **17,87** | | **18,98** | | 1,97 | | | Fig. 3 | | 19 | | 47,27 | | 40,68 | | **17,84** | | **18,98** | | 1,95 | | | Fig. 4 | | 19 | | 47,21 | | **40,72** | | **17,78** | | **19,04** | | 1,94 | | | Fig. 5 | | 19 | | 47,28 | | **40,72** | | **17,84** | | **19,03** | | 1,98 | | | Fig. 6 | | 19 | | 47,25 | | 40,64 | | **17,84** | | **19,07** | | 1,09 | |   Se hacen comprobación de aspecto:  La fig nº 6 tiene rebabas en el partage  La fig nº tiene marcas de entalladura y varios arañazos en la parte superior justo en la zona donde se rompe el cubilete  Se hace una verificación de los gruesos de paredes  Fig 1  Fig 2  Fig 3  Fig 4  Fig 5  Fig 6  El molde 1837 también tiene marcados los cubiletes como 1, 2 , 3 y 4. |

***INFORME REALIZADO***

|  |
| --- |
| **Calidad :** Neus Gibert  **Fecha : 23/04/2020** |