stärke™

Quality Assurance Plan – Injection Moulded Fittings (PPH & PVDF)

Mfg. Standard: DIN

Sr. No.	Stage	Check Point	Method	Frequency	Acceptance Criteria	Responsibility
1	Raw material receipt	PPH resin grade, batch no., COA	Document check	Each lot	As per approved raw material specification	QA/QC
2	Masterbatch / additive	Correct colour and batch	Visual + document check	Each batch	As per approved specification	QA/QC
3	Mould setup	Correct mould and part identification	Visual + setup verification	Each setup	Correct mould fitted	Production / QC
4	Machine parameters	Temperature, pressure, cycle settings	Process check	Start of shift and after setting change	Within approved process range	Production
5	First piece inspection	Visual and dimensions	Visual + measuring instruments	Each setup / shift	As per drawing	QC
6	In-process inspection	Appearance, flash, short moulding, burn marks	Visual	At defined intervals	No visible defects beyond limit	Production / QC
7	Dimensional inspection	OD, ID, socket depth, wall thickness, angle	Vernier / gauges	As per sampling plan	Within drawing tolerance	QC
8	Final inspection	Visual finish, marking, dimensions	Visual + measurement	Lot-wise	Conforming to drawing and specification	QC
9	Hydro Test / Leak Test	Internal pressure at specified bar & time, leakage, rupture	Hydro test SOP / project spec	On customer request	No leakage, no failure during test	QC
10	Marking	Size, material, batch / traceability	Visual	100%	Clear and correct marking	QC
11	Packing	Quantity, label, damage protection	Visual	100%	Correct packing and identification	Dispatch / QC
12	Documentation	Inspection report, COA, lot traceability	Document review	Each dispatch lot	Complete records available	QA

NOTE: One lot means same size and type of fitting produced from the same raw material batch under similar production conditions.

Approved by

STARKE PLASTICS PRIVATE LIMITED AHMEDABAD