

TEST PROCEDURE GUIDELINES

<i>TEST METHODS:</i> WALL THICKNESS
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PURPOSE OF PROCEDURE:

To establish a standard technique for measuring the wall thickness of bottles.

DEFINITION OF TERMS:

EQUIPMENT/MATERIALS NEEDED:

Electronic wall thickness gauge that is capable of measuring in ten thousands of an inch.

Note: It is strongly recommended an electronic gauge be used because it is unsafe to cut bottles open to measure them with a micrometer. This method of measurement also has more accuracy.

TEST PROCEDURE:

Take a bottle to be measured and mark the point or points to be measured with a magic marker. Insert the steel ball into the bottle. Place the bottle on the thickness gauge and measure at the previous marked point/points. Move the bottle around on the point until the smallest measurement is achieved. Record this measurement and continue until all of the points have been measured. Remove the steel ball and return it to the thickness gauge.

DOCUMENTATION:

The number of bottles, the number of points on each bottle, and the thickness for each point should be agreed upon by the customer and the bottle manufacturer.

The allowable tolerance that is agreed upon by the customer should be in written specifications provided by the customer.

The frequency of the test to be performed must also be agreed upon by the customer. That is to say that the customer should provide in their specification how often the test is to be done and

by what form of sampling method, (random or non-random). These will be used to record results.

WALL THICKNESS (cont'd)

Sampling data should be kept on file for an agree upon period of time. The frequency of these retains should also be specified to ensure compliance.

REFERENCES: