

Qualification Test Report Decline Test according to VDA 19.1 2015

Articles information (information provided by the customer)			
Part name:		Incoming date:	
Part number:		Sampling place:	
Supplier:		Examiner:	
Report number:		Test date:	
Customer:		Part Description:	
Address:		No. of parts received:	
Contract:		Order Number:	

Extraction			
Procedure:	Spray	Equipment:	Analysis system
Liquid:	Desolvit	Membrane type:	PET 5 µm
Amount [L]:	5,1	Volume flow[l/min]:	1,5
Rewash quantity[L]:	0,2	Test environment:	Filtered & climate-controlled
Nozzle diameter:	2,5 mm	Number of parts:	18
Nozzle geometry:	Round	Surface of each part [cm²]:	56,398
Spraying distance:	<15cm	Volume [cm³]:	3,043

Summary of particle contamination without fibers [µm]										
	50-100	100-150	150-200	200-400	400-600	600-1000	1000-1500	1500-2000	2000-3000	>3000
#1	48	8	2	0	0	0	0	0	0	0
#2	3	0	0	0	0	0	0	0	0	0
#3	3	0	0	0	0	0	0	0	0	0
#4	1	1	0	1	0	0	0	0	0	0
#5	0	0	0	0	0	0	0	0	0	0
#6	0	0	0	0	0	0	0	0	0	0

Size interval: ≥ 50 µm							
Pos.	Sample	#1	#2	#3	#4	#5	#6
1	Cleanliness value	58	3	3	3	0	0
2	Cleanliness value cumulated	58	61	64	67	67	67
3	Proportion %	100,00	4,92	4,69	4,48	0,00	0,00

Result: The second sampling reaches a value of **4,92%** (Decline criterion ≤ 10%). Therefore, the flow volume for the parts is **5,1L (n-1)**. (see decline curve)

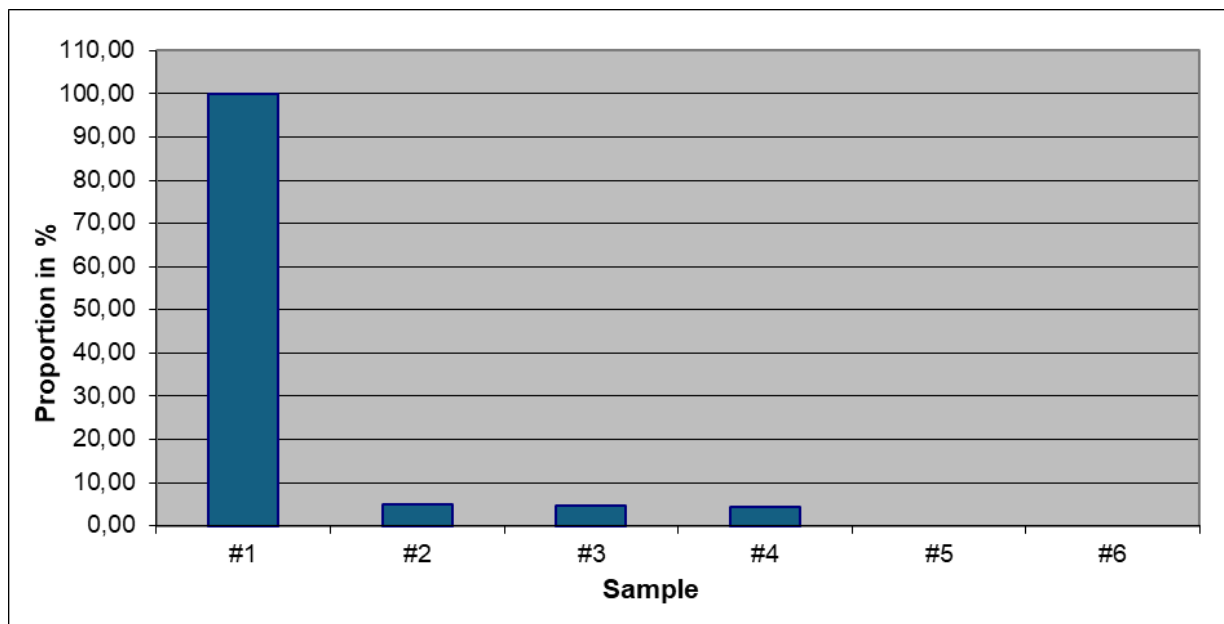


Fig. 1: decline curve

Signature