



SLOVENSKI STANDARD
SIST EN 2375:2001

01-junij-2001

Aerospace series - Resin preimpregnated materials - Production batch sampling procedure

Aerospace series - Resin preimpregnated materials - Production batch sampling procedure

Luft- und Raumfahrt - Harz imprägnierte Werkstoffe - Verfahren zur Probenahme aus Fertigungslosen

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Série aérospatiale - Matériaux préimprégnés de résine - Echantillonnage des lots de production

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Ta slovenski standard je istoveten z: EN 2375:1992

ICS:

49.025.40 Guma in polimerni materiali Rubber and plastics

SIST EN 2375:2001

en

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EUROPEAN STANDARD

EN 2375:1992

NORME EUROPÉENNE

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Descriptors: Aircraft industry, reinforcing materials, preimpregnated products, resins, sampling, sampling tables

English version

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Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CENEuropean Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

Foreword

This European Standard has been prepared by the European Association of Aerospace Manufacturers (AECMA).

After inquiries and votes carried out in accordance with the rules of this Association, this Standard has successively received the approval of the National Associations and the Official Services of the member countries of AECMA, prior to its presentation to CEN.

According to the Common CEN/CENELEC Rules, the following countries are bound to implement this European Standard :

Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

1 Scope and field of application

1.1 This standard specifies the method for sampling batches of resin impregnated fibre reinforcement used for aerospace applications.

1.2 The method is only applicable to impregnated woven fabrics and unidirectional reinforcement but is not suitable for impregnated rovings.

2 Definitions

2.1 Production batch

A production batch of impregnated material shall consist of rolls or sheets impregnated in a continuous manufacturing operation that conforms to a fixed manufacturing process and using a single mixture of resin ingredients and one type of reinforcement, simple or hybrid, of single source and constant over the whole of the batch.

2.2 Continuous manufacturing operation

A continuous manufacturing operation is defined as one in which the process is not interrupted for more than 24 continuous hours or by a different product run.

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2.3 Elementary unit

An elementary unit shall be a maximum of 50 kg. This elementary unit may consist of one roll or a number of rolls or sheets, produced in a continuous operation, unless otherwise agreed between purchaser and manufacturer.

3 Numbering of rolls and sheets

Rolls and sheets shall be numbered in the sequence of production.

4 Sampling

4.1 The sampling plan shown below indicates the number of elementary units to be taken from a specific batch size.

| Number of elementary units in the batch | Total of elementary units to be sampled | |
|---|---|-------------|
| | Normal | Statistical |
| Up to 3 | 1 | All |
| 4 to 15 | 2 | 3 |
| 16 to 25 | 4 | 4 |
| 26 to 40 | 5 | 5 |
| 41 to 65 | 7 | 7 |

4.2 The normal method shall be used unless the purchaser and manufacturer agree that the statistical method is required.

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4.3 The sampling sequence shall be in accordance with the following :
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- 2 elementary units sampled : first and last.
- Above 2 elementary units sampled : first and every $\frac{n}{x-1}$ (to the lowest whole number).

where :

n = number of elementary units in the batch,

x = number of elementary units to be sampled.

Example :

For a batch of 35 elementary units we take the first and every $\frac{35}{5-1}$ i.e. every 8th unit (to the lowest whole number)

Then the elementary units to be sampled are :

No. 1, No. 8, No. 16, No. 24 and No. 32.