novocapsule

CAPSULE COMPATIBILITY CHECKLIST

Geometry & Fit

- [ ] Rim diameter verified against spec (±0.10 mm for Original; ±0.15 mm for others)
- [ ] Skirt angle and shell depth confirmed on optical comparator
- [ ] Wall thickness meets min.–max. range; Brinell / Shore D hardness logged
- [ ] Clamp-insertion torque ≤ OEM value + 10%

Lid Integrity

- [ ] Foil gauge within approved band (e.g., 38 µm ± 2 µm)
- [ ] Emboss pattern matches drawing; no shadowing over barcode/ink ring
- [ ] Heat-seal peel strength 1.0–1.5 N per 15 mm strip
- [ ] Burst-pressure test ≥ 30% above operating pressure

Coffee Bed

- [ ] Grind size targets met (platform-specific microns)
- [ ] Fill weight ±0.05 g (3σ) on check-weigher
- [ ] Bed density 0.50–0.55 g cm^{-3}; tamp verified by insertion-force curve
- [ ] Headspace ≥ 6% and residual O_2 ≤ 1%

Digital Authentication

- [ ] Vertuo barcode or Keurig ink ring present and scan-verified (0 % error, n = 500)
- [ ] Latest machine firmware tested; no “incompatible” messages
- [ ] Artwork/emboss alignment holds across full lid-stock roll

Environmental Resilience

- [ ] Climatic cycle (40 °C / 75% RH → 5 °C / 30 % RH) passed with no lid creep or weight gain
- [ ] Altitude chamber to 60 kPa: zero doming or leaks
- [ ] Drop (1m) and vibration tests completed post-conditioning

Pilot & QC Data

- [ ] Pilot run ≥ 10 k units over two shifts; jam, burst, and brew-time stats within action limits
- [ ] Cp/Cpk for critical dimensions ≥ 1.33
- [ ] All validation reports filed in living quality dossier

Customer-Support Readiness

- [ ] Lot codes printed and traceable to batch records
- [ ] Troubleshooting scripts updated for current specs
- [ ] Return-mailers stocked; photo-evidence protocol shared with frontline agents

Sign-Off

- [ ] Engineering
- [ ] Quality
- [ ] Operations
- [ ] Sales / Private-Label Client