

	Safetab Life Science Puducherry		MASTER COPY
	PACKING MATERIAL SPECIFICATION		
Name of Material	LITACOLD FLU SALES PRINTED FOIL		
Specification No.	SPEC-PML00081/01-00	Revision No.	00
Supersedes	PMSL00081-00	Effective Date	29/12/2023
		Item Code:	PML00081/01
		Page No.:	1 of 4

S.NO	PACKING MATERIAL GENERAL SPECIFICATION (s)	
1.	Storage condition	Store in below 30°C.
2.	Precautions, Handling hazards & Special instructions for sampling if any	No special instructions.
3.	Total Quantity of sample required for analysis	1 meter of foil from each roll. Minimum 60% from total number of rolls are to be sampled.
4.	Quantity of reserve sample	Not applicable.
5.	Sampling Instructions	Follow the Standard operating procedure number: ST/QC/041.
6.	Destruction Instructions	Follow the Standard operating procedure number: ST/QC/032.
7.	Retest period	12 months from the date of release.

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			
Date	27/12/2023	28/12/2023	29/12/2023

Format No: ST/QC/058:A1

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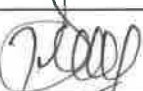
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S.NO	TEST (s)	SPECIFICATION (s)
1	*Description	0.07mm thickness, 302mm Aluminium strip foil and printing should be as per standard, approved text, design and colour scheme.
2	Dimensions: Width Thickness	302±2.0mm (300 to 304 mm) 0.07±0.005mm (0.065 to 0.075 mm)
3	Total Grammage	107.5 – 126.2 g/sq.m
	GSM of Aluminium layer	74.8 – 87.8 g/sq.m
	GSM of Nylon layer	32.7 – 38.4 g/sq.m
4	Peel test	Should comply
5	*Text matter	Should comply with approved Artwork or approved shade card.
6	*Colour	Should comply with approved shade card.
7	Pinholes	Should be absent

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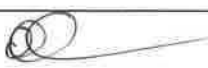
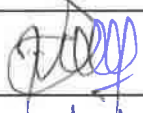
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S.NO	TEST (s)	SPECIFICATION (s)
8	Winding direction	Should comply with approved artwork.
9	*Printing Quality	Should be free from dots, colour variation and Foreign particles.
10	Cleanliness check	Should be free from dirty, mutilated, torn or stained.

Remarks: The above * Marked tests are to be performed while retesting the material.

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REVISION HISTORY:

Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PML00081/01-00	(i) Periodic review. (ii) Specification numbering procedure revised as per SOP No. ST/QC/058.	ST/CC/23/063	29/12/2023

**** END OF THE DOCUMENT ****

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STANDARD TESTING PROCEDURE

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Name of Material	LITACOLD FLU SALES PRINTED FOIL			
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1. DESCRIPTION:	0.07mm thickness, 302mm Aluminium strip foil and printing should be as per standard, approved text, design and colour scheme.
2. DIMENSIONS:	Width: Measure the width (in mm) of the foil randomly and take the average. Thickness: Measure the thickness (in mm) of the foil randomly and take the average.
3. TOTAL GRAMMAGE:	Cut a perfect square of 5cm x 5cm of the foil and weigh the piece (W gms) and calculate the Grammage (GSM) using the following formula. Check the aluminium strip foil randomly and take the average. CALCULATION: $\text{GSM} = \frac{\text{W (gms)} \times 100 \times 100}{\text{Length (in cm)} \times \text{Height (in cm)}}$ GSM OF ALUMINIUM (NET METAL) AND NYLON LAYER: Cut a piece of foil and note the length and height in cm. Weigh the piece in a balance and record the weight. Soak the piece of foil in Glacial acetic acid for ½ hour. Remove the foil and separate aluminium and nylon layer after washing in tap water. Dry the pieces using a cloth. Weigh the aluminium and nylon layer separately. Calculate the GSM of respective aluminium and nylon from the formula, $\text{GSM} = \frac{\text{W} \times 10000}{\text{L} \times \text{H}}$

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Where W = Weight in gram, L = Length in cm, H = Height in cm

The result gives the GSM of Aluminium (Net metal) and Nylon.

4. PEEL TEST:

Place a length of cellotape across the printed/coated surface of the test piece so that all the colour/coating are included. Press the tape onto the surface firmly using your thumb. Steadily pull the tape away from the printed/coated surface. Inspect both the surface for any ink removal.

5. TEXT MATTER:

Check the text matter in comparison with approved Artwork or approved shade card.

6. COLOUR:

Check the colour in comparison with approved shade card.

7. PIN HOLES:

Check the Aluminium strip foil by placing the foil sample in pinholes tester and check under light for pinholes.

8. WINDING DIRECTION:

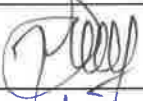
Check the winding direction to confirm with the artwork.

9. PRINTING QUALITY:

Check the printing Quality randomly and free from dots, colour variation and foreign particles.

10. CLEANLINESS CHECK:

Check the cleanliness of the foils. The test passes if the foils are not dirty, mutilated, torn or stained.

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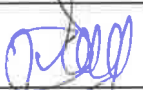
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