

	Safetab Life Science Puducherry		MASTER COPY	
	PACKING MATERIAL SPECIFICATION			
Name of Product	GLIDE-M 60/850 SALES PRINTED FOIL 10's			
Specification No.	SPEC-PMG00077-00	Revision No.	00	Item Code: PMG00077
Supersedes	PMSG00077-00	Effective Date	02/12/2023	Page No.: 1 of 3

S.NO	PACKING MATERIAL GENERAL SPECIFICATION (s)	
1.0	Storage condition	Store in below 30°C.
2.0	Precautions, Handling hazards & Special instructions for sampling if any	No special instructions.
3.0	Total Quantity of sample required for analysis	1 meter of foil from each roll. Sampling shall be done as per British Military Standard.
4.0	Quantity of reserve sample	Not applicable.
5.0	Sampling Instructions	Follow the Standard operating procedure number: ST/QC/041.
6.0	Destruction Instructions	Follow the Standard operating procedure number: ST/QC/032.
7.0	Retest period	12 months from the date of release.

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	GM-QC	AGM-QA
Signature			
Date	09/11/23	30/11/2023	01/12/23

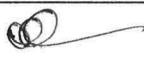
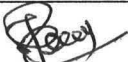
Format No: ST/QC/058:A1

UNCONTROLLED COPY

	Safetab Life Science Puducherry		MASTER COPY	
	PACKING MATERIAL SPECIFICATION			
Name of Product	GLIDE-M 60/850 SALES PRINTED FOIL 10's			
Specification No.	SPEC-PMG00077-00	Revision No.	00	Item Code: PMG00077
Supersedes	PMSG00077-00	Effective Date	02/12/2023	Page No.: 2 of 3

S.NO	TEST (s)	SPECIFICATION (s)
1.0	*Description	0.025mm thickness, 186mm Aluminium blister foil and printing should be as per standard, approved text, design and colour scheme.
2.0	Dimensions: Width Thickness	184 to 188 mm 0.022 to 0.028 mm
3.0	Total Grammage	63.0 – 78.0 g/sq.m
4.0	Peel test	Should comply
5.0	*Text matter	Should comply with approved Artwork or shade card.
6.0	*Colour	Should comply with approved shade card.
7.0	Pinholes	Should be absent
8.0	Winding direction	Should comply
9.0	*Printing Quality	Should comply
10.0	Cleanliness check	Should comply

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

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	GM-QC	AGM-QA
Signature			
Date	29/11/23	30/11/2023	01/12/23

Format No: ST/QC/058:A1

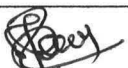
UNCONTROLLED COPY

	Safetab Life Science Puducherry		MASTER COPY	
	PACKING MATERIAL SPECIFICATION			
Name of Product	GLIDE-M 60/850 SALES PRINTED FOIL 10's			
Specification No.	SPEC-PMG00077-00	Revision No.	00	Item Code: PMG00077
Supersedes	PMSG00077-00	Effective Date	02/12/2023	Page No.: 3 of 3

REVISION HISTORY:

Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PMG00077-00	i) Periodic review ii) Specification numbering procedure revised as per SOP No: ST/QC/058.	ST/CC/23/063	02/12/2023

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

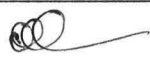
Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	GM-QC	AGM-QA
Signature			
Date	29/11/23	30/11/2023	01/12/23

Format No: ST/QC/058:A1

UNCONTROLLED COPY

	Safetab Life Science Puducherry		MASTER COPY	
	STANDARD TESTING PROCEDURE			
Name of Product	GLIDE-M 60/850 SALES PRINTED FOIL 10's			
STP No.	STP-PMG00077-00	Revision No.	00	Item Code: PMG00077
Supersedes	PMTG00077-00	Effective Date	02/12/2023	Page No.: 1 of 3

1.0	DESCRIPTION: 0.025mm thickness, 186mm Aluminium blister foil and printing should be as per standard, approved text, design and colour scheme.
2.0	DIMENSIONS: Width: Measure the width (in mm) of the foil randomly. Thickness: Measure the thickness (in mm) of the foil randomly. Cut a piece of 5cm x 5cm of the foil and soak the piece of foil in Con.Nitric acid for 20 minutes. Wash the foil in tap water. Remove the foil and separate aluminium and HSL (Heat seal Lacquer) layer. Dry the pieces using a cloth. Weigh the aluminium and HSL (Heat seal Lacquer) layer separately. Calculate the thickness of aluminium from the formula, $\text{GSM of Aluminium layer} = \frac{W \times 100 \times 100}{5 \times 5}$ $\text{Aluminium thickness} = \frac{B}{2.71 \times 1000}$ Where, W = Weight of the Aluminium layer. B = Grammage of Aluminium layer.
3.0	TOTAL GRAMMAGE: Cut a perfect square of 5cm x 5cm of the foil and weigh the piece (W gms) and calculate the total Grammage (GSM) using the following formula. Check the Aluminium blister foil randomly and take the average.

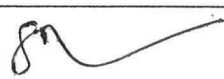
Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	GM-QC	AGM-QA
Signature			
Date	23/11/23	30/11/2023	01/12/23

Format No: ST/QC/058:A1

UNCONTROLLED COPY

	Safetab Life Science Puducherry		MASTER COPY	
	STANDARD TESTING PROCEDURE			
Name of Product	GLIDE-M 60/850 SALES PRINTED FOIL 10's			
STP No.	STP-PMG00077-00	Revision No.	00	Item Code: PMG00077
Supersedes	PMTG00077-00	Effective Date	02/12/2023	Page No.: 2 of 3

	CALCULATION: $\text{GSM} = \frac{W \text{ (gms)} \times 100 \times 100}{\text{Length (in cm)} \times \text{Height (in cm)}}$
4.0	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.
5.0	TEXT MATTER: Check the text matter in comparison with approved Artwork or shade card.
6.0	COLOUR: Check the colour in comparison with approved shade card.
7.0	PIN HOLES: Check the Aluminium blister foil by placing the foil sample in pinholes tester and check under light for pinholes.
8.0	WINDING DIRECTION: Check the winding direction to confirm with the artwork.
9.0	PRINTING QUALITY: Check the printing Quality randomly.

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	GM-QC	AGM-QA
Signature			
Date	29/11/23	30/11/2023	01/12/23

Format No: ST/QC/058:A1

UNCONTROLLED COPY

	Safetab Life Science Puducherry		MASTER COPY	
	STANDARD TESTING PROCEDURE			
Name of Product	GLIDE-M 60/850 SALES PRINTED FOIL 10's			
STP No.	STP-PMG00077-00	Revision No.	00	Item Code: PMG00077
Supersedes	PMTG00077-00	Effective Date	02/12/2023	Page No.: 3 of 3

10.0	CLEANLINESS CHECK: Check the cleanliness of the foils. The test passes if the foils are not dirty, mutilated, torn or stained. REVISION HISTORY: <table border="1" style="width: 100%;"> <thead> <tr> <th>STP No.</th> <th>Reason for Review</th> <th>Change control No.</th> <th>Effective Date</th> </tr> </thead> <tbody> <tr> <td>STP-PMG00077-00</td> <td> i) Periodic review ii) STP numbering procedure revised as per SOP No: ST/QC/058. </td> <td>ST/CC/23/063</td> <td>02/12/2023</td> </tr> </tbody> </table> ** END OF THE DOCUMENT **	STP No.	Reason for Review	Change control No.	Effective Date	STP-PMG00077-00	i) Periodic review ii) STP numbering procedure revised as per SOP No: ST/QC/058.	ST/CC/23/063	02/12/2023
STP No.	Reason for Review	Change control No.	Effective Date						
STP-PMG00077-00	i) Periodic review ii) STP numbering procedure revised as per SOP No: ST/QC/058.	ST/CC/23/063	02/12/2023						

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	GM-QC	AGM-QA
Signature			
Date	29/11/23	30/11/2023	01/12/23

Format No: ST/QC/058:A1

UNCONTROLLED COPY