
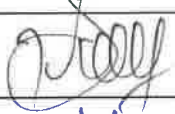


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	PACKING MATERIAL SPECIFICATION		
Name of Material	RICHFER CAPSULES SALES PRINTED CARTON		
Specification No.	SPEC-PMR00147-00	Revision No.	00
Supersedes	PMSR00147-00	Effective Date	18/11/2023
		Item Code:	PMR00147
		Page No.:	1 of 3

S.NO	PACKING MATERIAL GENERAL SPECIFICATION (s)	
1.	Storage condition	Store in room temperature.
2.	Precautions, Handling hazards & Special instructions for sampling if any	No special instructions.
3.	Total Quantity of sample required for analysis	5 number of Cartons. Sampling shall be done as per British Military Standard.
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	24 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	By. Manager-QC	AGM - QA
Signature			
Date	16/11/2023	17/11/2023	18/11/2023


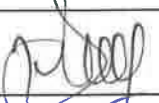

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	PACKING MATERIAL SPECIFICATION			
Name of Material	RICHFER CAPSULES SALES PRINTED CARTON			
Specification No.	SPEC-PMR00147-00	Revision No.	00	Item Code: PMR00147
Supersedes	PMSR00147-00	Effective Date	18/11/2023	Page No.: 2 of 3


S.NO	TEST (s)	SPECIFICATION (s)
1	*Description	300 GSM Cyber XL board printed carton with UV varnish, Braille text dots embossed and reverse tuck-in, side opening type and printing should be as per standard, approved text, design and colour scheme.
2	Dimensions: Length Breadth Height	84±2.0mm (82 to 86 mm) 30±2.0mm (28 to 32 mm) 66±2.0mm (64 to 68 mm)
3	Total Grammage	NLT 285.0 g/sq.m
4	*Text matter	Should comply with approved Artwork or approved shade card.
5	*Colour	Should comply with approved shade card.
6	*Printing Quality	Should be free from dots, colour variation and foreign particles.
7	*Pasting Quality	Should comply
8	Cleanliness check	Should be free from dirty, mutilated, torn or stained.

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

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	16/11/2023	17/11/2023	18/11/2023

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	PACKING MATERIAL SPECIFICATION		
Name of Material	RICHFER CAPSULES SALES PRINTED CARTON		
Specification No.	SPEC-PMR00147-00	Revision No.	00
Supersedes	PMSR00147-00	Effective Date	18/11/2023
		Item Code: PMR00147	
		Page No.: 3 of 3	

REVISION HISTORY:

Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PMR00147-00	(i) Periodic review. (ii) Specification numbering procedure revised as per SOP No. ST/QC/058.	ST/CC/23/063	18/11/2023

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

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	16/11/2023	17/11/2023	18/11/2023

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Puducherry

STANDARD TESTING PROCEDURE

MASTER COPY


Name of Material	RICHFER CAPSULES SALES PRINTED CARTON			
STP No.	STP-PMR00147-00	Revision No.	00	Item Code: PMR00147
Supersedes	PMTR00147-00	Effective Date	18/11/2023	Page No.: 1 of 3

1. DESCRIPTION:	300 GSM Cyber XL board printed carton with UV varnish, Braille text dots embossed and reverse tuck-in, side opening type and printing should be as per standard, approved text, design and colour scheme.
2. DIMENSIONS:	<p>Length:</p> <p>Measure the length (in mm) of 5 cartons individually and take the average.</p> <p>Breadth:</p> <p>Measure the breadth (in mm) of 5 cartons individually and take the average.</p> <p>Height:</p> <p>Measure the Height (in mm) of 5 cartons individually and take the average.</p>
3. TOTAL GRAMMAGE:	<p>Cut the cartons and weigh the piece (W gms) and calculate the Grammage (GSM) using the following formula. Check the 5 cartons individually and take the average.</p> <p>CALCULATION:</p> $\text{GSM} = \frac{W \text{ (gms)} \times 100 \times 100}{\text{Length (in cm)} \times \text{Height (in cm)}}$
4. TEXT MATTER:	Check the text matter in comparison with approved Artwork or approved shade card.




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	16/11/2023	17/11/2023	18/11/2023

Format No: ST/OC/058-A1

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Name of Material	RICHFER CAPSULES SALES PRINTED CARTON			
STP No.	STP-PMR00147-00	Revision No.	00	Item Code: PMR00147
Supersedes	PMTR00147-00	Effective Date	18/11/2023	Page No.: 2 of 3

5. COLOUR: Check the colour in comparison with approved shade card. 6. PRINTING QUALITY: Check the printing Quality randomly and free from dots, colour variation and foreign particles. 7. PASTING QUALITY: Check the pasting Quality randomly. 8. CLEANLINESS CHECK: Check the cleanliness of the cartons. The test passes if the cartons are not dirty, mutilated, torn or stained.

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	16/11/2023	17/11/2023	18/11/2023

Format No: ST/OC/058-A1


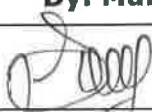

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	STANDARD TESTING PROCEDURE			
Name of Material	RICHFER CAPSULES SALES PRINTED CARTON			
STP No.	STP-PMR00147-00	Revision No.	00	Item Code: PMR00147
Supersedes	PMTR00147-00	Effective Date	18/11/2023	Page No.: 3 of 3

REVISION HISTORY:


STP No.	Reason for Review	Change control No.	Effective Date
STP-PMR00147-00	(i) Periodic review. (ii) STP numbering procedure revised as per SOP No. ST/QC/058.	ST/CC/23/063	18/11/2023

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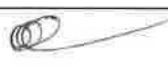


Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst.Manager-QC	Dy. Manager-QC	AGM - QA
Signature			
Date	16/11/2023	17/11/2023	18/11/2023

Format No: ST/QC/058-A1

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	Safetab Life Science Puducherry		MASTER COPY	
	PACKING MATERIAL SPECIFICATION			
Name of Material	RICHFER CAPSULES LEAFLET			
Specification No.	SPEC-PML00088-00	Revision No.	00	Item Code: PML00088
Supersedes	PMSL00088-00	Effective Date	18/11/2023	Page No.: 1 of 3

S.NO	PACKING MATERIAL GENERAL SPECIFICATION (s)	
1.0	Storage condition	Store in a room temperature.
2.0	Precautions, Handling hazards & Special instructions for sampling if any	No special instructions.
3.0	Total Quantity of sample required for analysis	5 number of Leaflets.
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	24 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	17/11/2023	18/11/2023	18/11/2023

Format No: ST/QC/058:A1




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	PACKING MATERIAL SPECIFICATION		
Name of Material	RICHFER CAPSULES LEAFLET		
Specification No.	SPEC-PML00088-00	Revision No.	00
Supersedes	PMSL00088-00	Effective Date	18/11/2023
		Item Code:	PML00088
		Page No.:	2 of 3

S.NO	TEST (s)	SPECIFICATION (s)
1.0	*Description	60 GSM Maplitho paper printed in Blue colour with 4 foldings.
2.0	Dimensions: Length Height	240±2.0mm (238 to 242 mm) 200±2.0mm (198 to 202 mm)
3.0	Total Grammage	54.0 – 66.0 g/sq.m
4.0	*Text matter	Should comply with approved Artwork or approved shade card.
5.0	*Colour	Should comply with approved shade card.
6.0	*Printing quality	Should be free from dots, colour variation and foreign particles.
7.0	Cleanliness check	Should be free from dirty, mutilated, torn or stained.


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

REVISION HISTORY:

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	17/11/2023	18/11/2023	18/11/2023


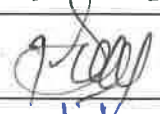

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	PACKING MATERIAL SPECIFICATION			
Name of Material	RICHFER CAPSULES LEAFLET			
Specification No.	SPEC-PML00088-00	Revision No.	00	Item Code: PML00088
Supersedes	PMSL00088-00	Effective Date	18/11/2023	Page No.: 3 of 3


Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PML00088-00	(i) Periodic review. (ii) Specification numbering procedure revised as per SOP No. ST/QC/058.	ST/CC/23/063	18/11/2023

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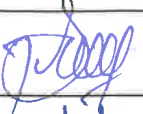

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			
Date	17/11/2023	18/11/2023	18/11/2023

Format No: ST/QC/058:A1

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	Safetab Life Science Puducherry		MASTER COPY
	STANDARD TESTING PROCEDURE		
Name of Product	RICHFER CAPSULES LEAFLET		
STP No.	STP-PML00088-00	Revision No.	00
Supersedes	PMTL00088-00	Effective Date	18/11/2023
		Item Code: PML00088	Page No.: 1 of 3

1.0 DESCRIPTION: 60 GSM Maplitho paper printed in Blue colour with 4 foldings.
2.0 DIMENSIONS: Length: Measure the length (in mm) of the leaflet randomly and take the average. Height: Measure the height (in mm) of the leaflet randomly and take the average.
3.0 TOTAL GRAMMAGE: Measure the dimensions of leaflets. Weigh the leaflet (W gms) and calculate the total Grammage (GSM) using the following formula. Check the 5 leaflets individually and take the average. CALCULATION: $\text{GSM} = \frac{W \text{ (gms)} \times 100 \times 100}{\text{Length (in cm)} \times \text{Height (in cm)}}$
4.0 TEXT MATTER: Check the text matter in comparison with approved Artwork or approved shade card.
5.0 COLOUR: Check the colour in comparison with approved shade card.


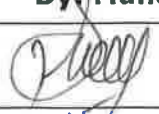

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			
Date	17/11/2023	18/11/2023	18/11/2023

Format No: ST/QC/058:A1

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	STANDARD TESTING PROCEDURE		
Name of Product	RICHFER CAPSULES LEAFLET		
STP No.	STP-PML00088-00	Revision No.	00
Supersedes	PMTL00088-00	Effective Date	18/11/2023
		Item Code: PML00088	Page No.: 2 of 3

6.0	PRINTING QUALITY: Check the printing Quality randomly and free from dots, colour variation and foreign particles.
7.0	CLEANLINESS CHECK: Check the cleanliness of the leaflets. The test passes if the leaflets are not dirty, mutilated, torn or stained.

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	17/11/2023	18/11/2023	18/11/2023

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	STANDARD TESTING PROCEDURE		
Name of Product	RICHFER CAPSULES LEAFLET		
STP No.	STP-PML00088-00	Revision No.	00
Supersedes	PMTL00088-00	Effective Date	18/11/2023
		Item Code: PML00088	Page No.: 3 of 3

REVISION HISTORY:


STP No.	Reason for Review	Change control No.	Effective Date
STP-PML00088-00	(i) Periodic review. (ii) STP numbering procedure revised as per SOP No. ST/QC/058.	ST/CC/23/063	18/11/2023

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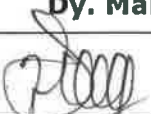

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			
Date	17/11/2023	18/11/2023	18/11/2023

Format No: ST/OC/058:A1

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	Safetab Life Science Puducherry		MASTER COPY	
	PACKING MATERIAL SPECIFICATION			
Name of Material	RICHTER CAPSULES SALES PRINTED FOIL			
Specification No.	SPEC-PMR00148-00	Revision No.	00	Item Code: PMR00148
Supersedes	PMSR00148-00	Effective Date	18/11/2023	Page No.: 1 of 3

	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.
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	K.SARAVANAN	S.MARAN
Designation	Asst.Manager-QC	Dy. Manager-QC	AGM-QA
Signature			
Date	16/11/2023	17/11/2023	18/11/2023




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	PACKING MATERIAL SPECIFICATION			
Name of Material	RICHFER CAPSULES SALES PRINTED FOIL			
Specification No.	SPEC-PMR00148-00	Revision No.	00	Item Code: PMR00148
Supersedes	PMSR00148-00	Effective Date	18/11/2023	Page No.: 2 of 3


S.NO	TEST (s)	SPECIFICATION (s)
1.0	*Description	0.025mm thickness, 160mm Aluminium blister foil and printing should be as per standard, approved text, design and colour scheme.
2.0	Dimensions: Width Thickness	160±2.0mm (158 to 162 mm) 0.025±0.003mm (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 approved shade card.
6.0	*Colour	Should comply with approved shade card.
7.0	Pinholes	Should be absent
8.0	Winding direction	Should comply with approved artwork.
9.0	*Printing Quality	Should be free from dots, colour variation and Foreign particles.
10.0	Cleanliness check	Should be free from dirty, mutilated, torn or stained.

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

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	16/11/2023	17/11/2023	18/11/2023

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	PACKING MATERIAL SPECIFICATION		
Name of Material	RICHFER CAPSULES SALES PRINTED FOIL		
Specification No.	SPEC-PMR00148-00	Revision No.	00
Supersedes	PMSR00148-00	Effective Date	18/11/2023
			Item Code: PMR00148 Page No.: 3 of 3

REVISION HISTORY:


Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PMR00148-00	(i) Periodic review. (ii) Specification numbering procedure revised as per SOP No. ST/QC/058.	ST/CC/23/063	18/11/2023

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




Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst.Manager-QC	Dy. Manager-QC	AGM-QA
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	STANDARD TESTING PROCEDURE			
Name of Material	RICHFER CAPSULES SALES PRINTED FOIL			
STP No.	STP-PMR00148-00	Revision No.	00	Item Code: PMR00148
Supersedes	PMTR00148-00	Effective Date	18/11/2023	Page No.: 1 of 3

1.0 DESCRIPTION:	0.025mm thickness, 160mm Aluminium blister foil and printing should be as per standard, approved text, design and colour scheme.
2.0 DIMENSIONS:	<p>Width:</p> <p>Measure the width (in mm) of the foil randomly.</p> <p>Thickness:</p> <p>Measure the thickness (in mm) of the foil randomly.</p> <p>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,</p> $\text{GSM of Aluminium layer} = \frac{W \times 100 \times 100}{5 \times 5}$ $\text{Aluminium thickness} = \frac{B}{2.71 \times 1000}$ <p>Where, W = Weight of the Aluminium layer. B = Grammage of Aluminium layer.</p>
3.0 TOTAL GRAMMAGE:	<p>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.</p>


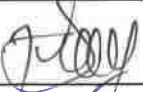

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
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Name of Material	RICHFER CAPSULES SALES PRINTED FOIL		
STP No.	STP-PMR00148-00	Revision No.	00
Supersedes	PMTR00148-00	Effective Date	18/11/2023
		Item Code: PMR00148	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 approved 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 and free from dots, colour variation and foreign particles.


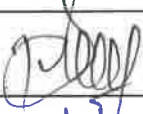

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Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			
Date	16/11/2023	17/11/2023	18/11/2023

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Name of Material	RICHFER CAPSULES SALES PRINTED FOIL		
STP No.	STP-PMR00148-00	Revision No.	00
Supersedes	PMTR00148-00	Effective Date	18/11/2023
		Item Code: PMR00148	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"> <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-PMR00148-00</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>18/11/2023</td> </tr> </tbody> </table>	STP No.	Reason for Review	Change control No.	Effective Date	STP-PMR00148-00	(i) Periodic review. (ii) STP numbering procedure revised as per SOP No. ST/QC/058.	ST/CC/23/063
STP No.	Reason for Review	Change control No.	Effective Date					
STP-PMR00148-00	(i) Periodic review. (ii) STP numbering procedure revised as per SOP No. ST/QC/058.	ST/CC/23/063	18/11/2023					
** END OF THE DOCUMENT **								




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	16/11/2023	17/11/2023	18/11/2023

Format No: ST/QC/058:A1

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	Safetab Life Science Puducherry		MASTER COPY
	PACKING MATERIAL SPECIFICATION		
Name of Product	164MM PVDC CLEAR FILM		
Specification No.	SPEC-PMPD0029-00	Revision No.	00
Supersedes	NIL	Effective Date	07/10/2023
		Item Code: PMPD0029	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	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Dy. Manager-QC	GM-QC	AGM-QA
Signature			
Date	04/10/2023	05/10/2023	05/10/23

Format No: ST/QC/058:A1

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Puducherry

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PACKING MATERIAL SPECIFICATION

Name of Product	164MM PVDC CLEAR FILM			
Specification No.	SPEC-PMPD0029-00	Revision No.	00	Item Code: PMPD0029
Supersedes	NIL	Effective Date	07/10/2023	Page No.: 2 of 3


S.NO	TEST (s)	SPECIFICATION (s)
1.0	*Description	164mm PVDC clear glass film with composition of PVC and PVDC layer.
2.0	Dimensions: Width Thickness	162 to 166 mm 0.27 to 0.31 mm
3.0	Total Grammage	360.0 – 440.0 g/sq.m
	GSM of PVC layer	306.0 – 374.0 g/sq.m
	GSM of PVDC layer	54.0 – 66.0 g/sq.m
4.0	*Pinholes	Should be absent
5.0	*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	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Dy. Manager-QC	GM-QC	AGM-QA
Signature			
Date	04/10/2023	05/10/2023	05/10/23

Format No: ST/QC/058:A1




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	PACKING MATERIAL SPECIFICATION			
Name of Product	164MM PVDC CLEAR FILM			
Specification No.	SPEC-PMPD0029-00	Revision No.	00	Item Code: PMPD0029
Supersedes	NIL	Effective Date	07/10/2023	Page No.: 3 of 3

REVISION HISTORY:


Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PMPD0029-00	New Specification prepared	NA	07/10/2023

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

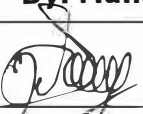


Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Dy. Manager-QC	GM-QC	AGM-OA
Signature			
Date	04/10/2023	05/10/2023	05/10/23

Format No: ST/QC/058:A1

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	STANDARD TESTING PROCEDURE			
Name of Product	164MM PVDC CLEAR FILM			
STP No.	STP-PMPD0029-00	Revision No.	00	Item Code: PMPD0029
Supersedes	NIL	Effective Date	01/10/2023	Page No.: 1 of 3

1.0	DESCRIPTION: 164mm PVDC clear glass film with composition of PVC and PVDC layer.
2.0	DIMENSIONS: Width: Measure the width (in mm) of the PVDC film randomly and take the average. Thickness: Measure the thickness (in mm) of the PVDC film randomly and take the average.
3.0	TOTAL GRAMMAGE: Cut a perfect square of 5cm x 5cm of the foil and weigh the piece (W gm) and calculate the Grammage (GSM) using the following formula. Check the PVDC film randomly and take the average. CALCULATION: $\text{GSM} = \frac{W \text{ (gm)} \times 100 \times 100}{\text{Length (in cm)} \times \text{Height (in cm)}}$ GSM OF PVC AND PVDC 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 Ethyl acetate for 1/2 hours. Remove the foil and separate PVC and PVDC layer after washing in tap water. Dry the pieces using a cloth. Weigh the PVC and PVDC layer separately. Calculate the GSM of respective PVC and PVDC from the formula,


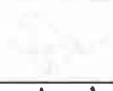

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Dy. Manager-QC	GM-QC	AGM-QA
Signature			
Date	04/10/2023	05/10/2023	05/10/23

Format No: ST/QC/058:A1

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	STANDARD TESTING PROCEDURE			
Name of Product	164MM PVDC CLEAR FILM			
STP No.	STP-PMPD0029-00	Revision No.	00	Item Code: PMPD0029
Supersedes	NIL	Effective Date	07/10/2023	Page No.: 2 of 3

	$\text{GSM} = \frac{W \times 100 \times 100}{L \times H}$ <p>Where W = Weight in gram, L = Length in cm, H = Height in cm The result gives the GSM of PVC and PVDC.</p>
4.0 PIN HOLES:	Check the PVDC film by placing the foil sample in pinholes tester and check under light for pinholes.
5.0 CLEANLINESS CHECK:	Check the cleanliness of the PVDC film. The test passes if the PVDC film is not dirty, mutilated, torn or stained.

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Dy. Manager-QC	GM-QC	AGM-QA
Signature			
Date	07/10/2023	05/10/2023	05/10/23

Format No: ST/QC/058:A1




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	STANDARD TESTING PROCEDURE			
Name of Product	164MM PVDC CLEAR FILM			
STP No.	STP-PMPD0029-00	Revision No.	00	Item Code: PMPD0029
Supersedes	NIL	Effective Date	07/10/2023	Page No.: 3 of 3

REVISION HISTORY:

STP No.	Reason for Review	Change control No.	Effective Date
STP-PMPD0029-00	New STP prepared	NA	07/10/2023

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

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Dy. Manager-QC	GM-QC	AGM-QA
Signature			
Date	04/10/2023	05/10/2023	05/10/23

Format No: ST/QC/058:A1

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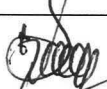


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PACKING MATERIAL SPECIFICATION

Name of Product	380 x 365 x 430MM GHPL PRINTED 5 PLY SHIPPER			
Specification No.	SPEC-PTMT0018-00	Revision No.	00	Item Code: PTMT0018
Supersedes	NIL	Effective Date	13/09/2023	Page No.: 1 of 4

S.NO	PACKING MATERIAL GENERAL SPECIFICATION (s)	
1.0	Storage condition	Store in room temperature.
2.0	Precautions, Handling hazards & Special instructions for sampling if any	No special instructions.
3.0	Total Quantity of sample required for analysis	1 number of Shipper.
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	NA

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	08/09/2023	09/09/2023	11/09/23

Format No: ST/QC/058:A1

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PACKING MATERIAL SPECIFICATION

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Name of Product	380 x 365 x 430MM GHPL PRINTED 5 PLY SHIPPER			
Specification No.	SPEC-PTMT0018-00	Revision No.	00	Item Code: PTMT0018
Supersedes	NIL	Effective Date	13/09/2023	Page No.: 2 of 4

S.NO	TEST (s)	SPECIFICATION (s)
1.0	Description	Golden yellow colour 5ply shipper and printed on all sides of the shipper.
2.0	Dimensions: Length Breadth Height	 377 to 383 mm 362 to 368 mm 427 to 433 mm
3.0	Total Grammage:	
	Outside Linear kraft	Not less than 180 g/sq.m
	Flute 1	Not less than 180 g/sq.m
	Middle Linear kraft	Not less than 180 g/sq.m
	Flute 2	Not less than 180 g/sq.m
	Inner Linear kraft	Not less than 180 g/sq.m

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	08/09/2023	09/09/2023	11/09/23

Format No: ST/QC/058:A1

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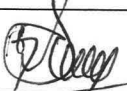


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PACKING MATERIAL SPECIFICATION

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Name of Product	380 x 365 x 430MM GHPL PRINTED 5 PLY SHIPPER			
Specification No.	SPEC-PTMT0018-00	Revision No.	00	Item Code: PTMT0018
Supersedes	NIL	Effective Date	13/09/2023	Page No.: 3 of 4

S.NO	TEST (s)	SPECIFICATION (s)
4.0	Flute Percentage	Not less than 25.0%
5.0	Staples	Clean and free from rust copper pin to be applied in pairs. Pairs of staples shall be applied at approximate equal distance.
6.0	Flaps	No gap or overlaps between two flaps.
7.0	Moisture content	Not more than 10.0%
8.0	Bursting Strength	Not less than 15.0 Kg/Cm ²
9.0	Printing Quality	Should comply
10.0	Cleanliness check	Should comply

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	08/09/2023	09/09/2023	11/09/23

Format No: ST/QC/058:A1

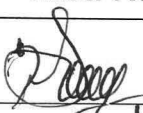
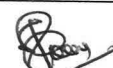

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	PACKING MATERIAL SPECIFICATION			
Name of Product	380 x 365 x 430MM GHPL PRINTED 5 PLY SHIPPER			
Specification No.	SPEC-PTMT0018-00	Revision No.	00	Item Code: PTMT0018
Supersedes	NIL	Effective Date	13/09/2023	Page No.: 4 of 4

REVISION HISTORY:

Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PTMT0018-00	New Specification prepared.	ST/CC/23/175	13/09/2023

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

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	08/09/2023	09/09/2023	11/09/23

Format No: ST/QC/058:A1

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Puducherry

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STANDARD TESTING PROCEDURE

Name of Product	380 x 365 x 430MM GHPL PRINTED 5 PLY SHIPPER			
STP No.	STP-PTMT0018-00	Revision No.	00	Item Code: PTMT0018
Supersedes	NIL	Effective Date	13/09/2023	Page No.: 1 of 4

1.0 DESCRIPTION:

Golden yellow colour 5ply shipper and printed on all sides of the shipper.

2.0 DIMENSIONS:

Length:

Measure the length of the shipper by using calibrated scale (in mm).

Breadth:

Measure the breadth of the shipper by using calibrated scale (in mm).

Height:

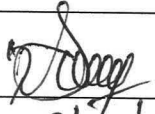
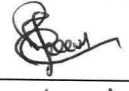

Measure the Height of the shipper by using calibrated scale (in mm).

3.0 TOTAL GRAMMAGE:

Using calibrated scale mark 10 x 10cm cut the shipper and soak in water for 15 minutes, separate the layers and dry in hot air oven at 105° for 15 minutes. After drying weigh the each layer (W gms) and calculate the GSM for each layer using the following formula.

CALCULATION:

$$\text{GSM} = \frac{W \text{ (gms)} \times 100 \times 100}{\text{Length (in cm)} \times \text{Height (in cm)}}$$

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	08/09/2023	09/09/2023	11/09/23

Format No: ST/QC/058:A1

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Puducherry

STANDARD TESTING PROCEDURE

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Name of Product	380 x 365 x 430MM GHPL PRINTED 5 PLY SHIPPER			
STP No.	STP-PTMT0018-00	Revision No.	00	Item Code: PTMT0018
Supersedes	NIL	Effective Date	13/09/2023	Page No.: 2 of 4

4.0 FLUTE PERCENTAGE:

After determination of GSM for each layer, weigh the flute 1 and flute 2 layer (W1 gm) and cut in 10 x 10cm and weigh (W2 gm). Calculate the flute 1 and flute 2 percentage using the following formula.

Calculation:

$$= \frac{(W1 - W2)}{W1} \times 100$$

Where,

W1 – Weight of the flute before cutting.

W2 – Weight of the flute after cutting.

5.0 STAPLES:

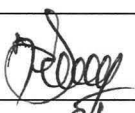
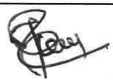

Check the shipper is clean and free from rust copper pin to be applied in pairs. Pairs of staples shall be applied at approximate equal distance.

6.0 FLAPS:

Check for gap or overlap between two flaps and report the observation.

7.0 MOISTURE CONTENT:

Using calibrated scale mark 10 x 10cm and weigh the shipper (W1 gm), cut into small pieces and dry in an oven at a temperature 105°C for 30 minutes. After drying, cool in desiccator and weigh the small pieces of shipper (W2 gm) and calculate the moisture content in percentage using the formula,

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	08/09/2023	09/09/2023	11/09/23

Format No: ST/QC/058:A1

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STANDARD TESTING PROCEDURE

Name of Product 380 x 365 x 430MM GHPL PRINTED 5 PLY SHIPPER

STP No. STP-PTMT0018-00 **Revision No.** 00 **Item Code:** PTMT0018

Supersedes NIL **Effective Date** 13/09/2023 **Page No.:** 3 of 4

Calculation:

$$= \frac{(W1 - W2)}{\text{Weight of Shipper (W1)}} \times 100$$

8.0 BURSTING STRENGTH:

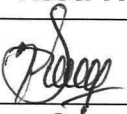


Carry out this using a bursting strength apparatus. Check the bursting strength of the sample in three different places and find the average.

9.0 PRINTING QUALITY:

Check the pasting Quality randomly.

10.0 CLEANLINESS CHECK:

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

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	08/09/2023	09/09/2023	11/09/23

Format No: ST/QC/058:A1

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Puducherry

STANDARD TESTING PROCEDURE

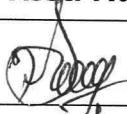
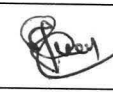
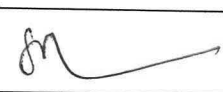
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Name of Product	380 x 365 x 430MM GHPL PRINTED 5 PLY SHIPPER			
STP No.	STP-PTMT0018-00	Revision No.	00	Item Code: PTMT0018
Supersedes	NIL	Effective Date	13/09/2023	Page No.: 4 of 4

REVISION HISTORY:

STP No.	Reason for Review	Change control No.	Effective Date
STP-PTMT0018-00	New STP prepared	ST/CC/23/175	13/09/2023

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

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	08/09/2023	09/09/2023	11/09/23

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