
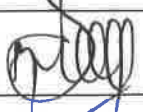


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	PACKING MATERIAL SPECIFICATION			
Name of Material	380 x 365 x 330MM 5 PLY GHPL PRINTED SHIPPER			
Specification No.	SPEC-PTMT0038-00	Revision No.	00	Item Code: PTMT0038
Supersedes	NIL	Effective Date	12/06/2025	Page No.: 1 of 4

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	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			for 
Date	10/06/2025	11/06/2025	12/06/2025

Format No: ST/QC/058:A1

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	PACKING MATERIAL SPECIFICATION			
Name of Material	380 x 365 x 330MM 5 PLY GHPL PRINTED SHIPPER			
Specification No.	SPEC-PTMT0038-00	Revision No.	00	Item Code: PTMT0038
Supersedes	NIL	Effective Date	12/06/2025	Page No.: 2 of 4

S.NO	TEST (s)	SPECIFICATION (s)
1.0	Description	5 Ply corrugated shipper with vertical corrugation having upward direction arrow, GENERIC HEALTHCARE PVT. LTD., INDIA and GHPL logo. Text matter shall be printed in Pantone Black C on natural kraft paper. It should comply with the approved standard design.
2.0	Dimensions: Length Breadth Height	380±5.0mm (375 to 385 mm) 365±5.0mm (360 to 370 mm) 330±5.0mm (325 to 335 mm)
3.0	Total Grammage:	
	Outside Linear kraft	180 g/sq.m ± 5% (171.0 – 189.0 g/sq.m)
	Flute 1	180 g/sq.m ± 5% (171.0 – 189.0 g/sq.m)
	Middle Linear kraft	180 g/sq.m ± 5% (171.0 – 189.0 g/sq.m)
	Flute 2	180 g/sq.m ± 5% (171.0 – 189.0 g/sq.m)
	Inner Linear kraft	180 g/sq.m ± 5% (171.0 – 189.0 g/sq.m)




Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
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Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			for 
Date	10/06/2025	11/06/2025	12/06/2025

Format No: ST/QC/058:A1

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	PACKING MATERIAL SPECIFICATION			
Name of Material	380 x 365 x 330MM 5 PLY GHPL PRINTED SHIPPER			
Specification No.	SPEC-PTMT0038-00	Revision No.	00	Item Code: PTMT0038
Supersedes	NIL	Effective Date	12/06/2025	Page No.: 3 of 4

S.NO	TEST (s)	SPECIFICATION (s)
4.0	Flute Percentage: Flute 1 Flute 2	Not less than 25.0% 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 be free from 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	10/06/2025	11/06/2025	12/06/2025

Format No: ST/QC/058:A1




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	PACKING MATERIAL SPECIFICATION			
Name of Material	380 x 365 x 330MM 5 PLY GHPL PRINTED SHIPPER			
Specification No.	SPEC-PTMT0038-00	Revision No.	00	Item Code: PTMT0038
Supersedes	NIL	Effective Date	12/06/2025	Page No.: 4 of 4

REVISION HISTORY:


Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PTMT0038-00	New Specification prepared.	NA	12/06/2025

**** 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			for 
Date	10/06/2025	11/06/2025	12/06/2025

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	STANDARD TESTING PROCEDURE			
Name of Material	380 x 365 x 330MM 5 PLY GHPL PRINTED SHIPPER			
STP No.	STP-PTMT0038-00	Revision No.	00	Item Code: PTMT0038
Supersedes	NIL	Effective Date	12/06/2025	Page No.: 1 of 4

1.0	DESCRIPTION: 5 Ply corrugated shipper with vertical corrugation having upward direction arrow, GENERIC HEALTHCARE PVT. LTD., INDIA AND GHPL logo. Text matter shall be printed in Pantone Black C on golden brown natural kraft paper. It should comply with the approved standard design.
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: $\text{GSM} = \frac{\text{W (gms)} \times 100 \times 100}{\text{Length (in cm)} \times \text{Height (in cm)}}$


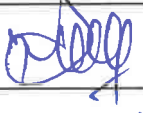

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			for 
Date	10/06/2025	11/06/2025	12/06/2025

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	STANDARD TESTING PROCEDURE			
Name of Material	380 x 365 x 330MM 5 PLY GHPL PRINTED SHIPPER			
STP No.	STP-PTMT0038-00	Revision No.	00	Item Code: PTMT0038
Supersedes	NIL	Effective Date	12/06/2025	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,

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Signature			for 
Date	10/06/2025	11/06/2025	12/06/2025

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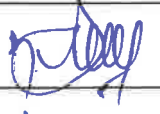

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	STANDARD TESTING PROCEDURE			
Name of Material	380 x 365 x 330MM 5 PLY GHPL PRINTED SHIPPER			
STP No.	STP-PTMT0038-00	Revision No.	00	Item Code: PTMT0038
Supersedes	NIL	Effective Date	12/06/2025	Page No.: 4 of 4

REVISION HISTORY:


STP No.	Reason for Review	Change control No.	Effective Date
STP-PTMT0038-00	New STP prepared	NA	12/06/2025

**** 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			for 
Date	10/06/2025	11/06/2025	12/06/2025

Format No: ST/QC/058:A1

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	PACKING MATERIAL SPECIFICATION			
Name of Material	GLIDE-M 60/500, 60/850 LEAFLET			
Specification No.	SPEC-PML00086-00	Revision No.	00	Item Code: PML00086
Supersedes	NIL	Effective Date	25/06/2025	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 Leaflets.
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	Dy. Manager-QC	AGM-QA
Signature			
Date	23/06/2025	24/06/2025	25/06/2025


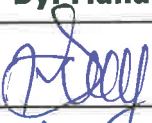

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	PACKING MATERIAL SPECIFICATION			
Name of Material	GLIDE-M 60/500, 60/850 LEAFLET			
Specification No.	SPEC-PML00086-00	Revision No.	00	Item Code: PML00086
Supersedes	NIL	Effective Date	25/06/2025	Page No.: 2 of 3


S.NO	TEST (s)	SPECIFICATION (s)
1	*Description	60 GSM Maplitho paper printed in Blue colour with 4 foldings.
2	Dimensions Length Height	210±2.0mm (208 to 212 mm) 170±2.0mm (168 to 172 mm)
3	Total Grammage	54.0 – 66.0 g/sq.m
4	*Text matter	Should comply with approved Artwork or shade card.
5	*Colour	Should comply with approved shade card.
6	*Printing quality	Should be free from dots, colour variation and foreign particles.
7	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	23/06/2025	24/06/2025	25/06/2025

Format No: ST/QC/058:A1




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	PACKING MATERIAL SPECIFICATION			
Name of Material	GLIDE-M 60/500, 60/850 LEAFLET			
Specification No.	SPEC-PML00086-00	Revision No.	00	Item Code: PML00086
Supersedes	NIL	Effective Date	25/06/2025	Page No.: 3 of 3

REVISION HISTORY:


Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PML00086-00	New Specification prepared.	NA	25/06/2025

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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	23/06/2025	24/06/2025	25/06/2025

Format No: ST/QC/058:A1

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	STANDARD TESTING PROCEDURE		
Name of Material	GLIDE-M 60/500, 60/850 LEAFLET		
STP No.	STP-PML00086-00	Revision No.	00
Supersedes	NIL	Effective Date	25/06/2025
		Item Code: PML00086	
		Page No.: 1 of 3	

1.	DESCRIPTION: 60GSM Maplitho paper printed in Blue colour with 4 foldings.
2.	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.	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: $\text{GSM} = \frac{\text{W (gms)} \times 100 \times 100}{\text{Length (in cm)} \times \text{Height (in cm)}}$
4.	TEXT MATTER: Check the text matter in comparison with approved Artwork or shade card.
5.	COLOUR: Check the colour in comparison with approved shade card.


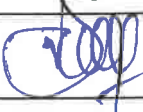

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			
Date	23/06/2025	24/06/2025	25/06/2025

Format No: ST/QC/058:A1

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	STANDARD TESTING PROCEDURE		
Name of Material	GLIDE-M 60/500, 60/850 LEAFLET		
STP No.	STP-PML00086-00	Revision No.	00
Supersedes	NIL	Effective Date	25/06/2025
		Item Code: PML00086	Page No.: 2 of 3

6.	PRINTING QUALITY: Check the printing Quality randomly and free from dots, colour variation and foreign particles.
7.	CLEANLINESS CHECK: Check the cleanliness of the foils. The test passes if the foils 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	23/06/2025	24/06/2025	25/06/2025

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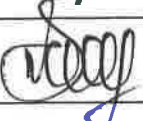

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	STANDARD TESTING PROCEDURE		
Name of Material	GLIDE-M 60/500, 60/850 LEAFLET		
STP No.	STP-PML00086-00	Revision No.	00
Supersedes	NIL	Effective Date	25/06/2025
		Item Code: PML00086	
		Page No.: 3 of 3	

REVISION HISTORY:


STP No.	Reason for Review	Change control No.	Effective Date
STP-PML00086-00	New STP prepared.	NA	25/06/2025

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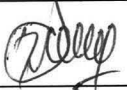
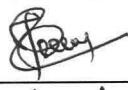

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	K.SARAVANAN	S.MARAN
Designation	Asst. Manager-QC	Dy. Manager-QC	AGM-QA
Signature			
Date	23/06/2025	24/06/2025	25/06/2025

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	PACKING MATERIAL SPECIFICATION			
Name of Product	190MM PVC CLEAR			
Specification No.	SPEC-PMPV0021-00	Revision No.	00	Item code: PMPV0021
Supersedes	NIL	Effective Date	29/07/2023	Page No.: 1 of 2

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	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	26/07/2023	27/07/2023	28/07/23

Format No: ST/QC/058:A1

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	PACKING MATERIAL SPECIFICATION			
Name of Product	190MM PVC CLEAR			
Specification No.	SPEC-PMPV0021-00	Revision No.	00	Item code: PMPV0021
Supersedes	NIL	Effective Date	29/07/2023	Page No.: 2 of 2

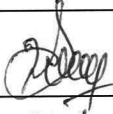
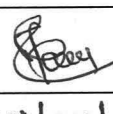
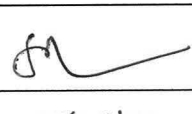
S.NO	TEST (s)	SPECIFICATION (s)
1.0	*Description	190mm PVC Clear glass film.
2.0	Dimensions: Width Thickness	188 to 192 mm 0.22 to 0.28 mm
3.0	Total Grammage	315.0 – 385.0 g/sq.m
4.0	*Pinholes	Should be absent
5.0	*Cleanliness check	Should comply

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

REVISION HISTORY:

Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PMPV0021-00	New Specification prepared	NA	

**** 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	26/07/2023	27/07/2023	28/07/23

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STANDARD TESTING PROCEDURE

Name of Product	190MM PVC CLEAR			
STP No.	STP-PMPV0021-00	Revision No.	00	Item code: PMPV0021
Supersedes	NIL	Effective Date	29/01/2023	Page No.: 1 of 2

1.0 DESCRIPTION:

190mm PVC Clear glass film.

2.0 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.

3.0 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 PVC film randomly and take the average.

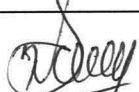

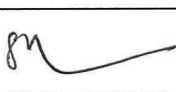
CALCULATION:

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

Where W = Weight in gram, L = Length in cm, H = Height in cm
The result gives the GSM of PVC.

4.0 PIN HOLES:

Check the PVC film by placing the foil sample in pinholes tester and check under light for pinholes.

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	26/07/2023	27/07/2023	28/07/23

Format No: ST/QC/058:A1

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STANDARD TESTING PROCEDURE

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Name of Product 190MM PVC CLEAR

STP No. STP-PMPV0021-00

Revision No.

00

Item code: PMPV0021

Supersedes

NIL

Effective Date

29/01/2023

Page No.: 2 of 2

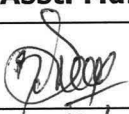
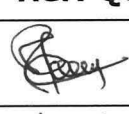
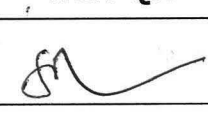
5.0 CLEANLINESS CHECK:

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

REVISION HISTORY:


STP No.	Reason for Review	Change control No.	Effective Date
STP-PMPV0021-00	New STP prepared	NA	29/01/2023

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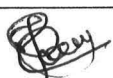

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	AGM-QC	AGM-QA
Signature			
Date	26/07/2023	27/07/2023	28/07/23

Format No: ST/QC/058:A1

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	PACKING MATERIAL SPECIFICATION			
Name of Product	GLIDE-M 60/850 SALES PRINTED CARTON 10's			
Specification No.	SPEC-PMG00075-00	Revision No.	00	Item Code: PMG00075
Supersedes	PMSG00075-00	Effective Date	02/12/2023	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 Cartons.
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	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	GM-QC	AGM-QA
Signature			
Date	29/11/23	30/11/2023	01/12/23


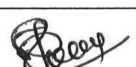

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	PACKING MATERIAL SPECIFICATION		
Name of Product	GLIDE-M 60/850 SALES PRINTED CARTON 10's		
Specification No.	SPEC-PMG00075-00	Revision No.	00
Supersedes	PMSG00075-00	Effective Date	02/12/2023
		Item Code: PMG00075	
		Page No.: 2 of 3	


S. NO	TEST (s)	SPECIFICATION (s)
1.0	*Description	300 GSM Cyber XL board printed carton with UV varnish and reverse tuck-in, side opening type and printing should be as per standard, approved text, design and colour scheme.
2.0	Dimensions: Length Breadth Height	93 to 97 mm 28 to 32 mm 63 to 67 mm
3.0	Total Grammage	285.0 - 315.0 g/sq.m
4.0	*Text matter	Should comply with approved Artwork or shade card.
5.0	*Colour	Should comply with approved shade card.
6.0	*Printing Quality	Should comply
7.0	*Pasting Quality	Should comply
8.0	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

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Name of Product	GLIDE-M 60/850 SALES PRINTED CARTON 10's			
Specification No.	SPEC-PMG00075-00	Revision No.	00	Item Code: PMG00075
Supersedes	PMSG00075-00	Effective Date	02/12/2023	Page No.: 3 of 3

REVISION HISTORY:


Specification No.	Reason for Review	Change control No.	Effective Date
SPEC-PMG00075-00	i) Periodic review ii) Specification numbering procedure revised as per SOP No: ST/QC/058.	ST/CC/23/063	02/12/2023

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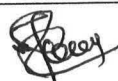

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Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	GM-QC	AGM-QA
Signature			
Date	29/11/23	30/11/2023	01/12/23

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	Safetab Life Science Puducherry		MASTER COPY	
	STANDARD TESTING PROCEDURE			
Name of Product	GLIDE-M 60/850 SALES PRINTED CARTON 10's			
STP No.	STP-PMG00075-00	Revision No.	00	Item Code: PMG00075
Supersedes	PMTG00075-00	Effective Date	02/12/2023	Page No.: 1 of 3

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

Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
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Designation	Asst. Manager-QC	GM-QC	AGM-QA
Signature			
Date	29/11/23	30/11/2023	01/12/23

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Puducherry

STANDARD TESTING PROCEDURE

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Name of Product	GLIDE-M 60/850 SALES PRINTED CARTON 10's			
STP No.	STP-PMG00075-00	Revision No.	00	Item Code: PMG00075
Supersedes	PMTG00075-00	Effective Date	02/12/2023	Page No.: 2 of 3

5.0 COLOUR:

Check the colour in comparison with approved shade card.

6.0 PRINTING QUALITY:




Check the printing Quality randomly.

7.0 PASTING QUALITY:

Check the pasting Quality randomly.


8.0 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	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




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	STANDARD TESTING PROCEDURE		
Name of Product	GLIDE-M 60/850 SALES PRINTED CARTON 10's		
STP No.	STP-PMG00075-00	Revision No.	00
Supersedes	PMTG00075-00	Effective Date	02/12/2023
		Item Code: PMG00075	Page No.: 3 of 3

REVISION HISTORY:


STP No.	Reason for Review	Change control No.	Effective Date
STP-PMG00075-00	i) Periodic review ii) STP numbering procedure revised as per SOP No: ST/QC/058.	ST/CC/23/063	02/12/2023

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Particulars	PREPARED BY	REVIEWED BY	APPROVED BY
Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
Designation	Asst. Manager-QC	GM-QC	AGM-QA
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	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

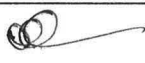
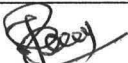

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Name of Product	GLIDE-M 60/850 SALES PRINTED FOIL 10's			
Specification No.	SPEC-PMG00077-00	Revision No.	00	Item Code: PMG00077
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S.NO	TEST (s)	SPECIFICATION (s)
1.0	*Description	0.025mm thickness, 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
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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

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	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, $\text{GSM of Aluminium layer} = \frac{W \times 100 \times 100}{5 \times 5}$ $\text{Aluminium thickness} = \frac{B}{2.71 \times 1000}$ <p>Where, W = Weight of the Aluminium layer. B = Grammage of Aluminium layer.</p>
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.




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Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
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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 cello tape 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.

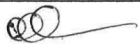


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Name	C.K.SARAVANAN	M.VIJAYAKUMAR	S.MARAN
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Supersedes	PMTG00077-00	Effective Date	02/12/2023	Page No.: 3 of 3

10.0	<p>CLEANLINESS CHECK:</p> <p>Check the cleanliness of the foils. The test passes if the foils are not dirty, mutilated, torn or stained.</p> <p>REVISION HISTORY:</p> <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> <p style="text-align: center;">** END OF THE DOCUMENT **</p>	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
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