Format No.: F/QCGN/045/01



SAI PRIMUS LIFE BIOTECH PVT LTD Factory: R.S.No. 4/3, Plot No.33, Kurumbapet Industrial Estate, Villianur Commune, Puducherry-605009

Page 1 of 1 No. PMS: PPF/SP/G013

PACKING MATERIAL SPECIFICATION

Revision No.: 02

Title:

144mm GENSET DOUBLE SIDE PRINTED FOIL0.025

Review Period: 3 Years

Item Code: PPF/SP/G013

Effective Date: 23 10 1/20 25

S. No.	TEST	SPECIFICATION	METHOD
1	DESCRIPTION	Aluminium polyester foil printed in 'N'number of colours or as per standard art work.	GTP/PM/001
2	WIDTH	Between 143 and 145mm	GTP/PM/002
3	COLOUR SCHEME	As per approved sample.	GTP/PM/004
4	TEXT MATTER	As per art work.	GTP/PM/005
5	REGISTRATION	Should be clear	GTP/PM/009
6	PIN HOLES	To be absent.	GTP/PM/007
7	THICKNESS	0.025mm +/- 10%	GTP/PM/002
8	INK LIFTING TEST / SCOTCH	No text matter should get removed with cellotape.	GTP/PM/006
9	TOTAL GSM	Between 66.93 and 78.57 gsm	GTP/PM/003

HISTORY

S. No.	Revision Number	Reason for Revision
1	Revision No.: 00	New Specification No PMS: PPF/SP/G013
2	Revision No.: 01	Periodic Revision
3	Revision No.: 02	Periodic Revision

	Prepared by	Checked by	Approved By
Designation	Executive QC	Sr. Executive QC	Manager QC
Signature	N.A.	Pf	m
Date	2-3/01/2025	23/01/2028	23/01/202
Department: Quality C	ontrol	Date of Issue: 23 101/20 25	





SAI PRIMUS LIFE BIOTECH PVT LTD
Factory: R.S.No. 4/3, Plot No.33, Kurumbapet Industrial
Estate, Villianur Commune, Puducherry-605009
PACKING MATERIAL SPECIFICATION
Revision No.: 02

Title:

Item Code: PBF/SP/P002

Format No.: F/QCGN/045/01

Page 1 of 1

No. PMS: PBF/SP/P002

Revision No.: 02

Review Period: 3 Years

S. No.	TEST	SPECIFICATION	METHOD
1	DESCRIPTION	Clear pvc film.	GTP/PM/001
2	WIDTH	148 mm +/- 1 mm	GTP/PM/002
3	PIN HOLES	Should be absent	GTP/PM/007
4	THICKNESS OF FILM	Between 0.225 and 0.275mm	GTP/PM/003
5	GSM OF FILM	Between 306 and 374 gsm	GTP/PM/003

HISTORY

S. No.	Revision Number	Reason for Revision
1	Revision No.: 00	New Specification No. PMS: PBF/SP/P002
. 2	Revision No.: 01	Periodic revision
3	Revision No.: 02	Periodic revision

	Prepared by	Checked by	Approved By
Designation	Executive QC	Sr.Executive QC	Manager QC
Signature	-tiga	Pf	fm
Date	16/07/2024	16107/2024	ldollon
Department: Quality Control		Date of Issue: 16 07 12014	





Format No.: F/QCGN/045/01

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(C. ED	SAI PRIMUS LIFE BIOTECH PVT LTD	Page 1 of 1
SAI PRIMUS LIFE	Factory: R.S.No. 4/3, Plot No.33, Kurumbapet Industrial Estate, Villianur Commune, Puducherry-605009	No. PMS: PHC/SP/G001
	PACKING MATERIAL SPECIFICATION	Revision No.: 02
Title:	3x10's GENSET PRINTED CARTON	Review Period: 3 Years
	Item Code: PHC/SP/G001	Effective Date: 24/09/2024

S. No.	TEST	SPECIFICATION	METHOD
1	DESCRIPTION	Rectangular non laminated carton with printed matter.	GTP/PM/001
2	NO.OF COLOURS	Pantone 4975 C Pantone 2567 C Pantone 355 C black.	GTP/PM/004
3	TEXT MATTER	As per approved artwork.(French/English).	GTP/PM/005
5	LENGTH	Between 87 mm and 89 mm.	GTP/PM/002
6	WIDTH	Between 17 mm and 19 mm.	GTP/PM/002
7	HEIGHT	Between 33 mm and 35 mm.	GTP/PM/002
8	TYPE OF PAPER	ITC cyber XL, UV varnished	GTP/PM/001
9	GRAMMAGE	Not Less Than 300 gsm	GTP/PM/003

HISTORY

S. No.	Revision Number	Reason for Revision
1	Revision No.: 00	New Specification No. PMS: PHC/SP/G001
2	Revision No.: 01	Periodic revision
3	Revision No.: 02	Periodic revision

	Prepared by	Checked by	Approved By
Designation	Executive QC	Sr.Executive QC	Manager QC
Signature	tiya	Pf	M
Date	24/09/2024	24/04/2024	24/69-12-024
Department: Quality Control		Date of Issue: 24/09/202	4





SAI PRIMUS LIFE BIOTECH PVT LTD
Factory: R.S.No. 4/3, Plot No.33, Kurumbapet Industrial
Estate, Villianur Commune, Puducherry-605009

PACKING MATERIAL SPECIFICATION

Revision No.: 02

Review Period: 3 Years

GENSET INSERT

Item Code: PHL/SP/G001

Effective Date: -2 4 | 50 5 | 2024

S. No.	TEST	SPECIFICATION	METHOD
1	NO.OF COLOURS	Pantone 2725 C Pantone 2756 C	GTP/PM/001
2	WIDTH	Between 179 and 181 mm	GTP/PM/002
3	TEXT MATTER	As per approved artwork.	GTP/PM/005
4	TYPE OF PAPER	Maplitho white paper.	GTP/PM/001
5	LENGTH	Between 139 and 141 mm	GTP/PM/002
6	GSM OF FILM	Not less than 60 gsm	GTP/PM/003

HISTORY

S. No.	Revision Number	Reason for Revision
1	Revision No.: 00	New Specification No. PMS: PHL/SP/G001
2	Revision No.: 01	Periodic revision
3	Revision No.: 02	Periodic revision

	Prepared by	Checked by	Approved By
Designation	Executive QC	Sr.Executive QC	Manager QC
Signature	Lya	Pf	m
Date	24/06/2024	24/06/2024	21/10/212024
Department: Quality C	ontrol	Date of Issue: 24 06 702	4





Format No.: F/QCGN/045/01

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(C. III)	SAI PRIMUS LIFE BIOTECH PVT LTD	Page 1 of 1
SAI PRIMUS LIFE	Factory: R.S.No. 4/3, Plot No.33, Kurumbapet Industrial Estate, Villianur Commune, Puducherry-605009	No. PMS: PPS/SP/G002
	PACKING MATERIAL SPECIFICATION	Revision No.: 02
Title:	5 PLY 390X390X430 MM GHPL PRINTED SHIPPER	Review Period: 3 Years
	Item Code: PPS/SP/G002	Effective Date: 11 11 12024

S. No.	TEST	SPECIFICATION	METHOD
1	DESCRIPTION	Rectangular broen coloured 5 ply shipper.	GTP/PM/001
2	LENGTH	Between 385 and 395 mm	GTP/PM/002
3	HEIGHT	Between 425and 435 mm	
4	BREADTH	Between 385 and 395 mm	GTP/PM/002
5	BURSTING STRENGTH	Not less than 15 kg/cm2	GTP/PM/012
6	GRAMMAGE	Between 864 and 1056 mm	GTP/PM/003

HISTORY

S. No.	Revision Number	Reason for Revision
1	Revision No.: 00	New Specification No. PMS: PPS/SP/G002
2	Revision No.: 01	Periodic revision
3	Revision No.: 02	Periodic revision

¥ 5	Prepared by	Checked by	Approved By
Designation	Executive QC	Sr.Executive QC	Manager QC
Signature	tura	Pf	m
Date	11/11/2024	1111/2024	11/11/2024
Department: Quality Conti	·ol	Date of Issue: h in 1024	1







SAI PRIMUS LIFE BIOTECH PRIVATE LIMITED

R.S. No. 4/3, plot No. 33, Kurumbapet Industrial Estate, Villianur Commune, Pondicherry- 605009

TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS

TITLE:

QUALITY CONTROL TEST METHOD (General Test Procedure) Page 1 of 5

Issued by QA/Date:

No.: F/QCGN/026/02

Revision No.: 03

Review Period: 03 years

Effective Date: 04/01/2024

Sr. No.	TEST	METHOD	GTP No.
1.	Description	Take the sample check physically and record the observation.	110.
2.	Appearance	The Aluminium foil/Glassine foil/Bopp Tape / PVC/PVDC foil/Blister foil/Strip foil/Measuring spoon/catch cover/Container with cap/ Alu-Alu. Should be free from black particles, dust particles, oils. Stains, foreign particles & embedded black particles. The carton, Label & Shipper the surface should be free from black spots and dust free. It is check in the light and record the observation.	GTP/PM/00 I
3.	Dimension (Length, Width & Height, Core dia. Outer roll diameter	Measure the dimension of the all packaging component by calibrated Scale/Vernier caliper / Micrometer at difference position and record the observation.	
	Thickness	Cut the piece of PVC/PVDC foil/PE/ LDPE/Alu. Alu/. Alu. /container/bottle/spoon and measure thickness from micrometer and records the observation. Repeat the observation for 5 times.	GTP/PM/002
	Grammage	Blister foil: Cut the blister foil 100x100 mm or 50mm x 50 mm piece, take weight then deep the piece in nitric acid for 5 to 10 minutes and separate the VMCH and Aluminium foil and dry it in oven or tissue paper and take weight and calculate the GSM by following formula. Weight of piece in gram x10 ⁴ GSM =	GTP/PM/003
	rantin utija inde unja reiti saliulis n jesas kun	Length(mm) x Width(mm) or Area	
		Strip foil: Cut the strip foil piece 100x100 mm or 50mm x 50 mm, take weight on balance, then deep the piece in Nitric acid for 5 to 10 minutes and separate the LDPE and Aluminum foil, dry both layers in oven or by tissue paper then take weight and calculate the GSM of following formula. Weight of piece in gram x10 ⁴ GSM =	
		Length(mm) x Width(mm) or Area	





TITLE:

SAI PRIMUS LIFE BIOTECH PRIVATE LIMITED

R.S. No. 4/3, plot No. 33, Kurumbapet Industrial Estate, Villianur Commune, Pondicherry- 605009

TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS

QUALITY CONTROL TEST METHOD

(General Test Procedure)

Page 2 of 5

Issued by QA/Date:

No.: F/QCGN/026/02

Revision No.: 03

Review Period: 03 years

Effective Date: 04/01/2024

PVC/PVDC film: Cut the PVC/PVDC film piece of 100x100 mm or 50 mm x 50 mm, take weight, then deep the PVDC piece (not PVC) in acetone and separate the PVC and PVDC film layers, after separate dry the layers in oven then take the weight and calculate the grammage of separated layers by following formula

Weight of piece in gram x104

Length(mm) x Width(mm) or Area

Label/ Carton/Leaflet/Catch Cover

Cut the Label/ Carton/Leaflet/ catch cover of 100 mm x100 mm or 50mm x 50 mm or according to sample size and weight and calculate the GSM by following formula.

Calculation:

Weight of piece in gram x104

Length(mm) x Width(mm) or Area

Alu-Alu. Foil (Base Foil): - Cut 50X50 mm or 100X100 mm foil piece and take total GSM after that deep this piece in Acetone for 2 to 3 minutes, PVC is separated by acetone after that deep this piece in 50 % acetic acid solution and boil. After boil alu. foil and opa layer will be separated, dry all layers by oven and tissue paper and take the GSM by Following Formula.

Weight of piece in gram x104

GSIM = ---

Length(mm) x Width(mm) or Area





BIOTECH PVI. LTD.

TITLE:

SAI PRIMUS LIFE BIOTECH PRIVATE LIMITED

R.S. No. 4/3, plot No. 33, Kurumbapet Industrial Estate, Villianur Commune, Pondicherry- 605009

TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS

QUALITY CONTROL TEST METHOD (General Test Procedure)

Page 3 of 5

Issued by QA/Date:

No.: F/QCGN/026/02

Revision No.: 03

Review Period: 03 years

Effective Date: 04/01/2024

Shipper/Shipper Pad

Cut the piece of shipper/shipper pas/ honey comb/ center plate of 100 mm x100 mm or 50mm x 50 mm and weight and deep in warm water and separate the layer, dry in oven and calculate the grammage by following formula.

Calculation:

Weight of piece in gram x104

GSM =

Length(mm) x Width(mm) or Area

Bopp Tape:

Cut the Bopp Tape of 100 mm x100 mm or 50mm x 50 mm or according to tape size and observe total grammage (A), then remove the adhesive by using acetone with the help of cotton/tissue paper, dry and calculate the GSM by following formula (B)

Calculation:

Weight of piece in gram x104

GSM = ---

Length(mm) x Width(mm) or Area

Grammage of Adhesive = (A-B)



SAI PRIMUS LIFE BIOTECH PRIVATE LIMITED

R.S. No. 4/3, plot No. 33, Kurumbapet Industrial Estate, Villianur Commune, Pondicherry- 605009

TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS

TITLE: QUALITY CONTROL TEST METHOD

(General Test Procedure)

Page 4 of 5

Issued by QA/Date:

No.: F/QCGN/026/02

Revision No.: 03

Review Period: 03 years

Effective Date: 04/01/2024

Sr. No.	TEST	METHOD	GTP No.
4.	Colour	Take the sample from sample kit and match with approved shade card and record the observation.	GTP/PM/004
5.	Text matter	Take the sample and check the printed text matter with approved artwork and the record observation.	GTP/PM/005
6.	Peel test (Ink adhesion)	Take the sample and affix the transparent cello tape on the printed side and hold for two minutes. After two minutes lift the cello tape from the sample and examine the cello tape for any ink sticking and record the observation. Repeat the observation For 3 times.	GTP/PM/006
7.	Pin holes Test	Take one meter sample, insert into the Pin Hole Tester and switch on the light. Check number of holes and records the observation.	GTP/PM/007
8.	Quality of printing	Take the sample and check Physically for sharpness, legibility & clarity of printing, record the observation	GTP/PM/008
9.	Clarity of impression	Take the sample and check physically the clarity of colour, smudging of printing, and record the observation.	GTP/PM/009
10.	Core used	Take the sample and check the core used is plastic core or paper core. Measure the core size and record the observation.	GTP/PM/010
11.	Type of flute	It is used for shipper/shipper pad, Check the flute type and record the observation.	GTP/PM/011
12	Bursting Strength	Operate the Bursting Strength apparatus as per SOP and check the strength of shipper and record the observation.	GTP/PM/012
13.	Configuration	Check the configuration of pack size and packing of total qty, and record the observation.	GTP/PM/013
14.	Weight	Take the sample and measure the weight of the sample on the weighing balance and record the observation.	GTP/PM/014
15.	Overflow capacity	Fill the container with water upto overflow. Transfer the water into A class measuring cylinder. Note down the lower level of water and record the observation.	GTP/PM/015
16.		A-Take the sample one by one deep in water and check the direction of label. The direction of label should be outside horizontal the label and record the observation. B-Take the sample one by one Vertical folding and check the direction of carton. The direction of carton should be perpendicular to the vertical creases of the carton and record the observation. C-Take the sample one by one horizontal folding and check the direction of carton. The direction of carton should be horizontal to the carton and record	GTP/PM/016







SAI PRIMUS LIFE BIOTECH PRIVATE LIMITED

R.S. No. 4/3, plot No. 33, Kurumbapet Industrial Estate, Villianur Commune, Pondicherry- 605009

TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS

TITLE:

QUALITY CONTROL TEST METHOD (General Test Procedure)

Page 5 of 5

Issued by QA/Date:

No.: F/QCGN/026/02

Revision No.: 03

Review Period: 03 years

Effective Date: 04/01/2024

		the observation	
Sr. No.	TEST	METHOD	GTP No.
17. Design/Style		A-Take the sample and check the sample of design/style of carton. Tuck-in-type top and lock bottom of carton and record the observation. B-Take the sample and check the sample of design/style of carton. The carton should be double/both side open flap lock of carton and record the observation. B-Take the sample and check the sample of design/style of carton. The carton should be one side auto lock & other side open flap lock of carton and record the observation.	GTP/PM/017
18.	Pack Size	Check the pack size of each carton /shipper/foil/catch cover/ label/ spoon/bottle/container/cap/dropper and pack of total qty, and record the observation.	GTP/PM/018
19.	Identification of PVDC	Moisten the PVDC film with Morpholine solution, A brownish orange colour indicates the presence of PVDC.	GTP/PM/019
20.	Pasting	Take the sample check the pasting of the carton, no sticking & extra gum between the carton and record the observation.	GTP/PM/0020
21.	Cutting & Creasing	Take the sample check the cutting of carton & Creasing of carton with matching of the specimen and record the observation.	GTP/PM/0021
22.	Roll Winding	Take the roll, observe visually winding direction of roll, unwinding direction should as per approved artwork and No. of joints should not more than 2 per rolls and marked with red tape and record the observation	GTP/PM/0022
23.	Die Cut constriction	Take the sample observe the die cuttings of the carton, should be match as per approved specimen and record the observation	GTP/PM/0023
24,	Carton formation	Take the sample, make the carton box style and observe, it should be satisfactory.	GTP/PM/0024



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SAI PRIMUS LIFE BIOTECH PVT. LTD.

R.S. No. 4/3, Plot No. 33, Kurumbapet Indl. Estate, Villianur Commune, Pondicherry - 605009 Page: 1 of 1

QUALITY CONTROL

CERTIFICATE OF ANALYSIS

Format No.: F/QCGN/020/05

	PACKING MA	TERIAL	
Material Name 144mm Genset double side printed foil 0.025			
Batch No.	-	GRN No.	SPL/2324/GRN/GPM/01462
Mfg. Date		A.R. No.	SPL/2324/QCG/PMG/02337
Exp. Date		Report Date	26/02/2024
Mfg. by	ATHARV FOIL	Supp. by	ATHARVA FOILS
Qty. Received	367.160 KGS	Sample Qty.	0.020 KGS
Retest Date			

	OPERTY	SPECIFICATION	Actual Observation	RESULT
1	DESCRIPTION	Aluminium polyester foil printed in 'N' number of colours or as per standard art work	Aluminium polyester foil printed in 'N' number of colours or as per standard art work	Complies
2	PIN HOLE TEST	To be Absent.	Absent.	Complies
3	INK LIFTING TEST/SCOTCH	No text matter should get removed with cello tape.	No text matter get removed with cello tape.	Complies
4	THICKNESS	0.025mm ± 10%	0.025mm	Complies
٦.	MIDIH	Between 143 and 145 mm		145 mm
6	TOTAL GSM	Setween 66.93 and 78.57 gsm		77 26 gsm
7	TENT MATTER	As per art work (French)	As per art work (French)	Complies
8	COLOUR SCHEME	as per approved sample	As per approved sample	Complies
9	REGISTRATION	Should be clear	clear	Complies

Result: PASSED

Note:

Remarks: The sample COMPLIES with the prescribed standards as per IH specifications.

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ANALYSED BY

CHECKED BY

APPROVED BY

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SALERONAUS CIFE	SAI PRIMUS LIFE BIO R.S. No. 4/3, Plot No. 33, I Villianur Commune, Por	Estate,	
QUALITY CONTROL	CERTIFICATE OF	ANALYSIS	Format No.: F/QCGN/020/05
	PACKING M	IATERIAL	
Material Name	148 MM PVC Film Clear		
Batch No.	-	GRN No.	SPL/2526/GRN/GPM/00711
Mfg. Date		A.R. No.	SPL/2526/QCG/PMG/01040
Exp. Date		Report Date	18/07/2025
Mfg. by		Supp. by	ALL PACKS
Qty. Received	242.000 KGS	Sample Qty.	3.200 KGS
Retest Date			
i, PROPERTY	SPECIFICATION	Actual Observation	RESULT
DESCRIPTION	Clear pvc film.	Clear pvc film.	Complies
2 WIDTH	148 num ± 1 num.	148 mm.	Complies
3 PIN HOLES	should be absent	Absent	Complies
4 THICKNESS OF FIL	M Between 0.225 and 0.275 mm		().264 mm
5 GSM OF FILM	Between 306 and 374 gsm		330 gsm
Result: PASSED	,		
Remarks:The sam	ole COMPLIES with the presc	ribed standards a	as per IH specification
	CHECKED BY		APPROVED BY
ANALYSED BY	CHECKED BI		L.

SAI PRIMUS LIFE BIOTECH PVT. LTD. Page: 1 of 1 R.S. No. 4/3, Plot No. 33, Kurumbapet Indl. Estate, Villianur Commune, Pondicherry - 605009 SAL PRINCIPE LIFE Format No.: QUALITY CERTIFICATE OF ANALYSIS F/QCGN/020/05 CONTROL PACKING MATERIAL 3x10's Genset printed carton Material Name SPL/2425/GRN/GPM/00871 G18240901 GRN No. Batch No. A.R. No. SPL/2425/QCG/PMG/01443 Mfg. Date 20/09/2024 Report Date Exp. Date Supp. by HUEMAN GRAPHICS PRIVATE HUEMAN GRAPHICS Mfg. by 2.000 NOS Sample Qty. Oty. Received 4800.000 NOS Retest Date RESULT Actual Observation SPECIFICATION SRL PROPERTY Complies Rectangular non laminated Rectangular non laminated DESCRIPTION carton with printed marter carton with printed matter. Pantone 4975 C Pantone 2567 C Pantone 4975 C Pantone 2567 C Complies NO. OF COLOURS Pantone 355 C Black Pantone 355 C Black as per approved Complies As per approved TEXT MATTER . 3 artwork. (French/English) artwork. (French/English) Complies CLEANSINESS OF CARTON Complies Complies. S DIMENSION IN MIN 89 mm Between 87 and 89 mm Between 17 and 19 mm Between 33 and 35 mm 5.1 LENGTH 18 mm 5.2 WIDTH 34 mm 5.3 HEIGHT ITC Cyber XL, UV varnished IIC Cyber xt., UV varnished Complies TYPE OF PAPER 303 33 gsm GRAMMAGE Not Less Than 300 gsm Result: PASSED

Note:

Remarks: The sample COMPLIES with the prescribed standards as per TH specifications

ANALYSED BY

CHECKED BY

APPROVED BY

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SAI PRIMUS LIFE BIOTECH PVT. LTD. Page: 1 of 1 R.S. No. 4/3, Plot No. 33, Kurumbapet Indl. Estate, Villianur Commune, Pondicherry - 605009 SAI PRIMUS LIFE Format No.: QUALITY CERTIFICATE OF ANALYSIS F/QCGN/020/05 CONTROL PACKING MATERIAL Material Name Genset Insert SPL/2425/GRN/GPM/00387 GRN No. Batch No. SPL/2425/QCG/PMG/00643 A.R. No. Mfg. Date 22/06/2024 Report Date Exp. Date Supp. by RM. Graphics RM GRAPHICS Mfg. by 2.000 NOS Sample Qty. 8000.000 NOS Qty. Received Retest Date RESULT Actual Observation SRL PROPERTY SPECIFICATION Pantone 2925 C Pantone 2756 C Complies Pantone 2925 C Pantone 2756 C 1 NO. OF COLOURS As per approved artwork (English/French) Complies TEXT MATTER As per approved artwork (English/French) Maplitho White Paper. Complies Maplitho White Paper. TYPE OF PAPER 3 139 mm Between 139 and 141 mm LENGTH 1.80 mm Between 179 and 181 mm WIDTH 5 . 61.6 gsm Not Less Than 60 gsm GRAMMAGE

Result: PASSED

Note:

Remarks: The sample COMPLIES with the prescribed standards as per

IH specifications.

ANALYSED BY

106/2024

. CHECKED BY

APPROVED BY

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