

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

252 MM LOLIP 20 PRINTED FOIL

Item Code: PPF/SP/L016

Format No.: F/QCGN/045/01

Page 1 of 1

No. PMS: PPF/SP/L016

Revision No.: 01

Review Period: 3 Years

Effective Date: 25/07/2024

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 251 and 253 mm	GTP/PM/002
3	COLOUR SCHEME	As per approved artwork..	GTP/PM/004
4	TEXT MATTER	As per approved art work.	GTP/PM/005
6	PIN HOLES	Should be absent	GTP/PM/007
7	THICKNESS	Between 0.022 and 0.028 mm	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 79.17 gsm	GTP/PM/003

HISTORY


S. No.	Revision Number	Reason for Revision
1	Revision No.: 00	New Specification No PMS: PPF/SP/L016
2	Revision No.: 01	Periodic Revision

END OF DOCUMENT

	Prepared by	Checked by	Approved By
Designation	Executive QC	Sr. Executive QC	Manager QC
Signature			
Date	25/07/2024	25/07/2024	25/07/2024
Department: Quality Control		Date of Issue: 25/07/2024	

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


	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
	PACKING MATERIAL SPECIFICATION	No. PMS: PBF/SP/A004
Title:	252 MM ALU/ALU BASE FOIL	Revision No.: 01
		Review Period: 3 Years
		Effective Date: 25/06/24

S. No.	TEST	SPECIFICATION	METHOD
1	DESCRIPTION	Alu/Alu base foil.	GTP/PM/001
2	WIDTH	Between 251 mm and 253 mm	GTP/PM/002
3	TOTAL THICKNESS	Between 0.136 mm and 0.66 mm.	GTP/PM/002
4	TOTAL GRAMMAGE	Between 247.5 and 302.5 gsm	GTP/PM/003


HISTORY

S. No.	Revision Number	Reason for Revision
1	Revision No.: 00	New Specification No PMS: PBF/SP/A004
2	Revision No.: 01	Periodic Revision

END OF DOCUMENT

	Prepared by	Checked by	Approved By
Designation	Executive QC	Sr. Executive QC	Manager QC
Signature			
Date	25/06/2024	25/06/2024	26/06/2024
Department: Quality Control		Date of Issue: 25/06/24	

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


	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
	PACKING MATERIAL SPECIFICATION	No. PMS: PPC/SP/L016
Title:	3X10'S LOLIP 20 PRINTED CARTON	Revision No.: 01
	Item Code: PPC/SP/L016	Review Period: 3 Years
		Effective Date: 25/07/2024

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 2716 C, Pantone 485 C black.	GTP/PM/004
3	TEXT MATTER	As per approved artwork.	GTP/PM/005
4	LENGTH	Between 128 mm and 132 mm.	GTP/PM/002
5	BREADTH	Between 23 mm and 27 mm.	GTP/PM/002
6	HEIGHT	Between 58 mm and 62 mm.	GTP/PM/002
7	TYPE OF PAPER	ITC cyber XL, UV varnished	GTP/PM/001
8	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: PPC/SP/L016
2	Revision No.: 01	Periodic revision

END OF DOCUMENT

	Prepared by	Checked by	Approved By
Designation	Executive QC	Sr.Executive QC	Manager QC
Signature			
Date	25/07/2024	25/07/2024	25/07/2024
Department: Quality Control		Date of Issue: 25/07/2024	

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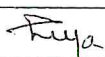


	SAI PRIMUS LIFE BIOTECH PVT LTD Factory: R.S.No. 4/3, Plot No.33, Kurumbapet Industrial Estate, Villianur Commune, Puducherry-605009	Page 1 of 1
		No. PMS: PPL/SP/L019
Title:	PACKING MATERIAL SPECIFICATION	Revision No.: 01
	LOLIP 10/20/80 PRINTED LEAFLET	Review Period: 3 Years
	Item Code: PPL/SP/L019	Effective Date: 24/07/2024

S. No.	TEST	SPECIFICATION	METHOD
1	DESCRIPTION	Printed leaflet.	GTP/PM/001
2	HEIGHT	Between 174 and 176 mm	GTP/PM/002
3	NO OF COLOURS	As per approved artwork.	GTP/PM/004
4	TEXT MATTER	As per approved artwork.	GTP/PM/005
5	TYPE OF PAPER	Maolitho white paper.	GTP/PM/001
6	LENGTH	Between 139 and 141 mm	GTP/PM/002
7	GRAMMAGE	Not less than 60 gsm	GTP/PM/003

HISTORY


S. No.	Revision Number	Reason for Revision
1	Revision No.: 00	New Specification No. PMS: PPL/SP/L019
2	Revision No.: 01	Periodic revision

END OF DOCUMENT

	Prepared by	Checked by	Approved By
Designation	Executive QC	Sr.Executive QC	Manager QC
Signature			
Date	24/07/2024	24/07/2024	24/07/2024
Department: Quality Control		Date of Issue: 24/07/2024	


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	SAI PRIMUS LIFE BIOTECH PRIVATE LIMITED R.S. No. 4/3, plot No. 33, Kurumbapet Industrial Estate, Villianur Commune, Pondicherry- 605009	Page 1 of 5	Issued by QA/Date:
	TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS	No.: F/QCGN/026/02	
		Revision No.: 03	
		Review Period: 03 years	
TITLE:	QUALITY CONTROL TEST METHOD (General Test Procedure)	Effective Date: 04/01/2024	

Sr. No.	TEST	METHOD	GTP No.
1.	Description	Take the sample check physically and record the observation.	GTP/PM/001
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.	
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.	GTP/PM/002
	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.	
	Grammage	<p>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.</p> $\text{GSM} = \frac{\text{Weight of piece in gram} \times 10^4}{\text{Length(mm)} \times \text{Width(mm)} \text{ or Area}}$ <p>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.</p> $\text{GSM} = \frac{\text{Weight of piece in gram} \times 10^4}{\text{Length(mm)} \times \text{Width(mm)} \text{ or Area}}$	GTP/PM/003


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	SAI PRIMUS LIFE BIOTECH PRIVATE LIMITED R.S. No. 4/3, plot No. 33, Kurumbapet Industrial Estate, Villianur Commune, Pondicherry- 605009	Page 2 of 5	Issued by QA/Date:	
		No.: F/QCGN/026/02		
	TITLE:	TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS QUALITY CONTROL TEST METHOD (General Test Procedure)	Revision No.: 03	Review Period: 03 years
			Effective Date: 04/01/2024	

		<p>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</p> $\text{GSM} = \frac{\text{Weight of piece in gram} \times 10^4}{\text{Length(mm)} \times \text{Width(mm)} \text{ or Area}}$	
		<p>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.</p> <p>Calculation:</p> $\text{GSM} = \frac{\text{Weight of piece in gram} \times 10^4}{\text{Length(mm)} \times \text{Width(mm)} \text{ or Area}}$	
		<p>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.</p> $\text{GSM} = \frac{\text{Weight of piece in gram} \times 10^4}{\text{Length(mm)} \times \text{Width(mm)} \text{ or Area}}$	


	SAI PRIMUS LIFE BIOTECH PRIVATE LIMITED R.S. No. 4/3, plot No. 33, Kurumbapet Industrial Estate, Villianur Commune, Pondicherry- 605009	Page 3 of 5	Issued by QA/Date:
	TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS	No.: F/QCGN/026/02	Revision No.: 03
TITLE:	QUALITY CONTROL TEST METHOD (General Test Procedure)	Review Period: 03 years	Effective Date: 07/01/2024

		<p>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: $\text{GSM} = \frac{\text{Weight of piece in gram} \times 10^4}{\text{Length(mm)} \times \text{Width(mm)} \text{ or Area}}$</p>	
		<p>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: $\text{GSM} = \frac{\text{Weight of piece in gram} \times 10^4}{\text{Length(mm)} \times \text{Width(mm)} \text{ or Area}}$ Grammage of Adhesive = (A-B)</p>	

	SAI PRIMUS LIFE BIOTECH PRIVATE LIMITED R.S. No. 4/3, plot No. 33, Kurumbapet Industrial Estate, Villianur Commune, Pondicherry- 605009	Page 4 of 5	Issued by QA/Date:
		No.: F/QCGN/026/02	
	TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS	Revision No.: 03	
		Review Period: 03 years	
TITLE:	QUALITY CONTROL TEST METHOD (General Test Procedure)	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.	Grain direction	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

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		No.: F/QCGN/026/02	
	TESTING, APPROVAL AND REJECTION OF PACKING MATERIALS	Revision No.: 03	
		Review Period: 03 years	
TITLE:	QUALITY CONTROL TEST METHOD^o (General Test Procedure)	Effective Date: 04/01/2024	

Sr. No.	TEST	METHOD	GTP No.
17.	Design/Style	<p>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.</p> <p>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.</p> <p>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.</p>	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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QUALITY CONTROL	CERTIFICATE OF ANALYSIS	Format No.: F/QCGN/020/05

PACKING MATERIAL

Material Name	LOLIP10/20/80 PRINTED LEAFLET		
Batch No.	-	GRN No.	SPL/2223/GRN/GPM/00928
Mfg. Date		A.R. No.	SPL/2223/QCG/PMG/01542
Exp. Date		Report Date	30/01/2023
Mfg. by	ANUP PRINTERS	Supp. by	ANUP PRINTERS PVT LTD.
Qty. Received	113200.000 NOS	Sample Qty.	4.000 NOS
Retest Date			

SRL	PROPERTY	SPECIFICATION	Actual Observation	RESULT
1	DESCRIPTION	Printed leaflet.	Printed leaflet.	Complies
2	NO OF COLOURS	As per approved artwork.	As per approved artwork.	Complies
3	TEXT MATTER	As per approved artwork (English/ French).	As per approved artwork (English/ French).	Complies
4	TYPE OF PAPER	Maplitho white paper.	Maplitho white paper.	Complies
5	LENGTH	Between 139 and 141 mm		139 mm
6	HEIGHT	Between 174 and 175 mm		175 mm
7	GRAMMAGE	Not Less Than 60 gsm		65.2 gsm

Result: PASSED

Note:

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

ANALYSED BY

Reba
30/01/2023

CHECKED BY

CH
30/01/2023

APPROVED BY

h
30/01/2023

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 MATERIAL			
Material Name	3X10'S LOLIP 20 PRINTED CARTON		
Batch No		GRN No.	SPL/2324/GRN/GPM/01573
Mfg. Date		A.R. No.	SPL/2324/QCG/PMG/02520
Exp. Date		Report Date	22/03/2024
Mfg. by	ANUP PRINTERS	Supp. by	ANUP PRINTERS PVT LTD.
Qty. Received	20800.000 NOS	Sample Qty.	5.000 NOS
Retest Date			

SRI	PROPERTY	SPECIFICATION	Actual Observation	RESULT
1	DESCRIPTION	Rectangular non laminated carton with printed matter.	Rectangular non laminated carton with printed matter.	Complies
2	NO OF COLOURS	Pantone 4975, Pantone 2716, Pantone 485, Black	Pantone 4975, Pantone 2716, Pantone 485, Black	Complies
3	TEXT MATTER	As per approved artwork.	As per approved artwork.	Complies
4	FEEL/LINESS OF CARTON	Complies.	Complies.	Complies
5	LENGTH	Between 128 and 132 mm		130 mm
6	BREADTH	Between 23 and 27 mm		24 mm
7	HEIGHT	Between 58 and 62 mm		60 mm
8	TYPE OF PAPER	ITC Cyber XL, UV Varnished.	ITC Cyber XL, UV Varnished.	Complies
9	WEIGHTAGE	Not Less than 300 gsm		305.6 gsm

Result: PASSED		
Note:		
Remarks: The sample COMPLIES with the prescribed standards as per IH specifications.		
ANALYSED BY Kup 22/03/2024	CHECKED BY P/ 22/03/24	APPROVED BY 22/03/24

SAI PRIMUS LIFE PVT. LTD.	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 MATERIAL

Material Name	252MM LOLIP 20PRINTED FOIL0.025MM		
Batch No.	-	GRN No.	SPL/2324/GRN/GPM/01054
Mfg. Date		A.R. No.	SPL/2324/QCG/PMG/01646
Exp. Date		Report Date	11/12/2023
Mfg. by	RAJMUDRA PACKAGING	Supp. by	RAJMUDRA PACKAGING
Qty. Received	21.400 KGS	Sample Qty.	2.000 KGS
Retest Date			

SRI	PROPERTY	SPECIFICATION	Actual observation	RESULT
1	DESCRIPTION	Aluminium polyester foil printed in 'N' number of colours as per standard artwork.	Aluminium polyester foil printed in 'N' number of colours as per standard artwork.	Complies
2	PIN HOLE TEST	Should be absent.	Absent.	Complies
3	INK LIFTING TEST	No text matter got removed with cello tape.	No text matter got removed with cello tape.	Complies
4	THICKNESS	Between 0.022 and 0.028 mm		0.028 mm
5	WIDTH	Between 251 and 253 mm		252 mm
6	TOTAL GSM	Between 66.93 and 79.17 gsm		75.2 gsm
7	TEXT MATTER	As per approved artwork.	As per approved artwork.	Complies
8	COLOUR SCHEME	As per approved artwork.	As per approved artwork.	Complies

Result: PASSED

Note:

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

ANALYSED BY

Praba
11/12/2023

CHECKED BY

J 11/12/2023

APPROVED BY

h 11/12/2023

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 MATERIAL

Material Name	5 PLY 390X390X430 MM GHPL PRINTED SHIPPER		
Batch No.	-	GRN No.	SPL/2324/GRN/GPM/00640
Mfg. Date		A.R. No.	SPL/2324/QCG/PMG/00992
Exp. Date		Report Date	07/09/2023
Mfg. by	TRUE CARTONS	Supp. by	TRUE CARTONS
Qty. Received	512.000 NOS	Sample Qty.	8.000 NOS
Retest Date			

SRL	PROPERTY	SPECIFICATION	Actual Observation	RESULT
1	DESCRIPTION	Rectangular brown coloured 5 ply shipper.	Rectangular brown coloured 5 ply shipper.	Complies
2	LENGTH	Between 385 and 395 mm		393 mm
3	BREADTH	Between 385 and 395 mm		395 mm
4	HEIGHT	Between 425 and 435 mm		425 mm
5	GRAMMAGE	Between 864 and 1056 gsm		969 gsm
6	BURSTING STRENGTH	Not Less Than 15 kg/cm ²		15 kg/cm ²

Result: PASSED

Note:

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

ANALYSED BY

CHECKED BY

APPROVED BY

Pkba
07/09/2023

Jr
07/09/2023

M
07/09/2023