

GA Brick Specifications

1000 ml Square PLH

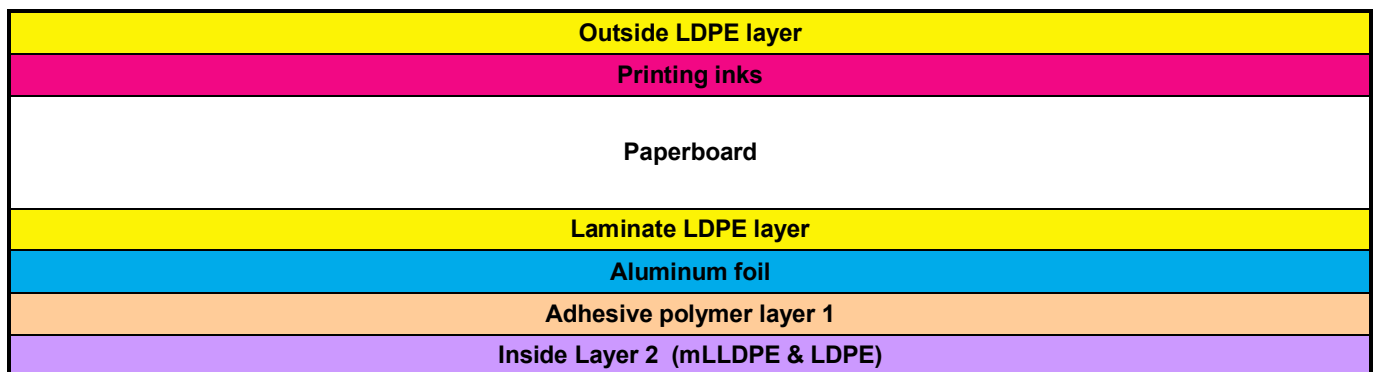
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Specification Packaging Material – GA Brick

Denomination of the packaging material	GA Brick/ Juice & Milk
Quality-size code	13 ^{xx} - 836-06
Description of the packaging material	
<ul style="list-style-type: none"> • Printing Method • Base Material • Stiffness for Paperboard (mN) • Field of Application 	Flexo / Flexo-process, water based ink C Duplex board 260 mN Juices, nectars and soft drinks. Flavored milk products. UHT milk product. Sweet and condensed milk. Soft cheese. Soya bean and Coconut drinks. Tea and coffee. Vinegar Products (max 1% acetic acid). Baby food

Structure of the packaging material

The specified packaging material has a laminate structure with several layers. The layer composition is in accordance with the picture below:



	Unit	Nominal
Outside PE layer	g/m ²	16
Paperboard	g/m ²	276
Lamination PE layer	g/m ²	29
Aluminum foil	g/m ²	24
Adhesive polymer layer 1	g/m ²	6
Inside layer 2	g/m ²	32
Weight of the packaging material	g/m²	383 ± 19

Weight (g) of packaging material per package: 31.9 ± 1.6

Specification Packaging Material – GA Brick

Function properties of the packaging material

<i>Item</i>	<i>Standard</i>
Adhesion between:	
Paperboard and outer LDPE layer	≥70%
Paperboard and Lamination LDPE layer	≥50%
Lamination layer and Al-foil	≥1N/15mm
Al-foil and Inside(Blend of mLLDPE and LDPE+polymer) layers	≥2N/15mm
Edge wicking, HP/70 Index	Max 2.0kg/m ²
Edge wicking, LA/23 Index	Max 0.8kg/m ²
Microbial load	≤5 CFU/100/cm ²
Moisture content	Min 5.0% Max 8.0%

Dimensions of the packaging material

<i>Item</i>	<i>Nominal Value (mm)</i>	<i>Tolerances (+/-)</i>
Repeat length (print to print)	285.0	±0.3
Web width	292.0	±1.0
Web edge - L crease	39.0	±1.0
Distance from filling code to crease line	9.15	±1.0
Diameter of the pre-punched hole	25.0	±0.5
Distance pre-punched hole edge – vertical creasing line	24.0	±0.5
Distance pre-punched hole edge – horizontal creasing line	5.25	±0.5

Properties of the packaging material

<i>Item</i>	<i>Unit</i>	<i>Value</i>	<i>Max</i>	<i>Min</i>
Bending Force	mN	375	450	300
Crease Strength CD/MD	%	\	85/90	\

Specifications of the packaging material reel

<i>Item</i>	<i>Jumbo reel</i>	<i>Normal reel</i>
Nominal number of packs/reel	7300	
Nominal weight/reel(kg)	233	
Diameter	Max 114cm	Max 56cm
Core inner diameter, minimum	150 mm	69.5 mm
Number of packaging material splices/reel	Max 5	Max 3
Distance between splices and from reel ends	>25m	>25m

Rest reels:

A commercial order can have up to 5 incomplete reels bigger than 50% of a complete reel.

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Labeling & Identification

Label on each individual reel with:

- Production order number
- Reel number
- Packaging Material type & volume
- Quantity (number of packages)
- Customer number

Print on each individual package:

- Lane number printed on every package
- Date code printed on every package
- Design number printed on every package

Distribution

Number of reels per pallet:	5
Weight of each full pallet:	1183kg
Pallet size:	Disposable pallet size 1175mm x 1200mm or 1150mm x 1150mm
Dimensions of full pallet:	1600mm
Pallet material:	Wood, free from chemicals, heat treated according to standard ISPM15 A corrugated board is placed between the pallet and the reels
Pallet wrapping:	Each pallet is fully protected with stretched film
Pallet stacking:	Max. 3 pallets can be stacked on top of each other, a protection sheet must be used between the pallets
Pallet label:	Each pallet is identified with a label giving the: Production order number/pallet number Number of the reels Total number of the packs Production date Quality size Customer order number Customer name

Storage of the packaging material

1. Use the material on a first in - first out basis.
2. The storage premises must be kept clean.
3. The material must be stored completely separate from other goods, such as milk powder, essences, animal food, chemicals, detergents, etc. There is a great risk that the packaging material is absorbing vapor which could result in off-taste problems.
4. Store the material on pallets only! The space to nearest wall should be kept min.100mm.
5. The material must not be exposed to direct moisture, such as condensation dropping from pipe etc. neither exposed to direct sunlight.

Storage conditions of the packaging material

1. Storage temperature: between 10-40C°
2. Storage relative humidity (RH %): between 40-65%

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Storage time limit which guarantees the function of the material is specified for each material and additional material types. The storage time is counted from the manufacturing date of material. The material storage time is limited to 12 months.

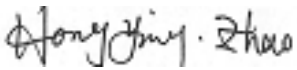
Food compliance

The packaging material and the raw material components comply with the Health & Food Safety regulations of EU and USA. A Declaration of Legal Food Compliance is available separately.

Approval and update of the packaging material specifications

The customer will be informed of any relevant changes in the specification.

Date: 17.10.2019

Name : 

Position: Quality Manager