
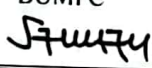



PACKAGES CONVERTORS LIMITED BU-FC

Document type
Work Instruction

Title
BENDING RESISTANCE / STIFFNESS TEST.

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1.0 SCOPE:

This test method is used for the measurement of bending resistance/stiffness of the Board.

2.0 REFERENCES:

- 2.1 Scan Method (SCAN - P 29:95).
- 2.2 Equipment Manual.

3.0 DEFINITION:

The ability of board to with stand bending. It is also define as "The force required to bend a rectangular test piece which is clamped at one end, the force being measured under specified conditions".

4.0 EQUIPMENT:

- 4.1 Stiffness Tester.
- 4.2 Sample Cutter.

5.0 TEST PROCEDURE:

- 5.1 Cut the test strip 38+-1mm wide and 70-80mm long in machine direction & cross direction with the help of sample cutter.
- 5.2 Switch On the stiffness tester.
- 5.3 Set the bending length to 50mm and bending angle to 15°.
- 5.4 Check that the function switch is in position "OPERATION".
- 5.5 Insert the test strip into the clamp.
- 5.6 Adjust zero by knob BAL.
- 5.7 Adjust the knife till it just touches the test strip.
- 5.8 Start the test cycle by pressing "START". When clamp returns to its starting position, note the bending resistance (mN) from the panel meter.
- 5.9 Check the bending resistance of the test strip once from the top side and once from the wire side.
- 5.10 Similarly, check at least 2 test strips in MD (machine direction) and 2 in CD(cross direction) each.

6.0 RESPONSIBILITY:

QA Supervisor
Lab Assistant

