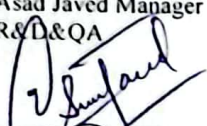



PACKAGES CONVERTORS LIMITED BU-FC	Document type WORK INSTRUCTION Title METHOD FOR DETERMINATION OF TOTAL SOLID CONTENTS OF ADHESIVES and VARNISH
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Prepared by Asad Javed Manager R&D&QA 	Approved by Salman Fazul -ur Rehman BUMFC 	PAGE 1 (1)	REV 1	DATE 01.07.2024	DOC NO. WIQA/BU-FC/8.2.4/11
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1.0 PURPOSE:

To check the total solid contents of adhesives & varnishes to be used in BU-FC

2.0 SCOPE:

This method covers measurement of total solid contents of Adhesives and varnishes

3.0 REFERENCES:

Sr. No.	Reference Document	Doc. No.
3.1	Supplier's Test Method	MCN 001 A
3.2	Standard Test Method	SCAN-p 61:88

4.0 APPARATUS:

4.1	Analytical balance	
4.2	Oven	
4.3	Weighing dish	
4.4	Dessicator	

5.0 PROCEDURE:

SR. NO.	ACTIVITIES
5.1	Weigh a empty weighing dish (A)
5.2	Accurately weigh 1 g sample (B)
5.3	Add 1-2 ml of MEK to the sample to spread the material in case of dry bond lamination adhesive.
5.4	Place the sample in the oven @ 120oC for one hour for dry bond lamination adhesive.
5.5	Place the sample in the oven @ 115oC for two hours for others.
5.6	Take out the sample from oven, place in a dessicator and cool down to the room temperature.
5.7	Again weigh the weighing dish (C)
5.8	Calculation: Total solids = $(C - A) / (B - A) \times 100 = \%$

6.0 RESPONSIBILITY: Lab Assistant/ QA Supervisor

**CONTROLLED
DOCUMENT**

BUSINESS UNIT FOLDING CARTON (BUFC)