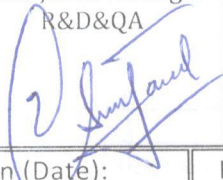
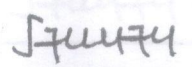


PACKAGES CONVERTORS LIMITED

BU-FC

Document type
WORK INSTRUCTION

Title
METHOD FOR TESTING OF CREASE STIFFNESS OF FLAT
HING ELIDS

Prepared by Asad Javed Manager R&D&QA 	Approved by Salman Fazul -u- Rehman BUMFC 	PAGE 1(2)	REV 1	DATE 01.07.2024	DOC NO. WIQA/BU-FC/8.2.4/04
--	---	--------------	----------	--------------------	--------------------------------

Reviewed on (Date):

Reviewed on (Date):

Reviewed on (Date):

Reviewed on (Date):

Reviewed by:

Reviewed by:

Reviewed by:

Reviewed by:

Approved on (Date):

Approved on (Date):

Approved on (Date):

Approved on (Date):

Approved by:

Approved by:

Approved by:

Approved by:

1.0 PURPOSE:

To check the crease stiffness of flat cigarette hingelids.

2.0 SCOPE:

This method covers determination of crease stiffness in finished product produced in BU-FC.

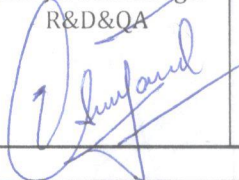
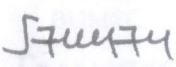
3.0 REFERENCES:

Internal Method

5.0 PROCEDURE:

SR. NO.	ACTIVITIES
5.1	Number the flat hingelid cartons to be tested.
5.2	Cut out the flat hingelid cartons as shown in figure 1 attached.
5.3	Set the crease tester with the help of template provided.
5.4	Click on the START on attached P.C (Personal Computer).
5.5	Click on PROGRAMS and then click on DYNAMIC CREASE TESTER.
5.6	Click on MEASURE option.
5.7	To select BLANK TYPE click the arrowhead to raise the list of blank and setting plate options and click the option required.
5.8	Move the cursor into BRAND box using mouse or indent key and type up to 15 alphanumeric characters, avoiding prohibited characters. Similarly enter RUN as a number between 1 and 999. This creates the test result file name.
5.9	Advance to CODE box and enter any required text, which may be of use to the tester. This text will be presented as part of test result.

<p style="text-align: center;">PACKAGES CONVERTORS LIMITED</p> <p style="text-align: center;">BU-FC</p>	<p>Document type WORK INSTRUCTION</p> <hr/> <p>Title METHOD FOR TESTING OF CREASE STIFFNESS OF FLAT HING ELIDS</p>
--	--

<p>Prepared by Asad Javed Manager R&D&QA</p> 	<p>Approved by Salman Fazul –u- Rehman BUMFC</p> 	<p>PAGE 1(2)</p>	<p>REV 1</p>	<p>DATE 01.07.2024</p>	<p>DOC NO. WIQA/BU-FC/8.2.4/04</p>
--	--	---------------------------	-----------------------	---------------------------------	---

5.11	Click the CONTINUE button and an instruction Prepare For Offset Measurement will appear. Click on OK button.
5.12	After a few seconds the Offset Measurement Procedure will be completed.
5.13	Enter the flat hinge lid reference in the relevant box. Place the flat hinge lid into the tester and click TEST.
5.14	A message Insert Blank For Crease Measurement will appear.
5.15	Lower the handle and a message Please Wait will appear.
5.16	At the end of WAIT period result screen (attached figure 2) will appear.
5.17	Remove the flat hinge lid and repeat the process with all samples to be tested. After a number of flat hinge lids have been tested the results shown in attached figure 3 will appear.

5.0 PROCEDURE:

SR. NO.	ACTIVITIES
5.18	When the last sample has been tested (or sooner if it is desired to finish the test early) click FINISH button and the screen shown in attached figure 4 will appear.
5.19	Double click the cursor anywhere on the empty row above the MEAN row. Select the required MAX and click the indent key. The result table as shown in attached figure 5 will appear.
5.20	Click PRINT button. The table as shown in attached figure 6 will be produced.

6.0 REPONSIBILITY:

- Lab Assistant
- Quality Assurance Supervisor