
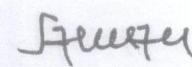


PACKAGES CONVERTORS LIMITED BU-FC	Document type WORK INSTRUCTION
	Title METHOD FOR VISUAL / MANUAL TESTING

Prepared by Asad Javed Manager R&D&QA 	Approved by Salman Fazul -u Rehman BUMFC 	PAGE 1(3)	REV 1	DATE 01.07.2024	DOC NO. WIQA/BU-FC/8.2.4/15
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Approved on (Date): Approved by:	Approved on (Date): Approved by:	Approved on (Date): Approved by:	Approved on (Date): Approved by:

1.0 PURPOSE:

To check the printing, cutting, creasing and gluing faults visually.

2.0 SCOPE:

This method covers determination of printing, cutting, creasing, gluing etc, faults in finished product produced in BU-FC.

3.0 REFERENCES:

Internal Method

4.0 PROCEDURE:

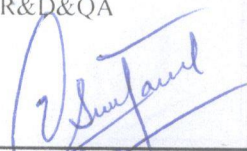
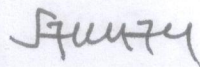
SR. NO.	ACTIVITIES
4.1	Color Variation (Shade): Match the sample with shade card/Approved /Reference sample. The shade card contains standard color sample with acceptable light and dark limits. The color shade of sample is OK if it comes in between light and dark limits.
4.2	Print / Text Missing: Observe the sample closely & completely. See if there is missing of any key element or text. See if there is ink missing anywhere and is visible at an arm's length. Compare with scale card to see acceptable limits.
4.3	Varnish Missing: Observe the sample closely & completely. See if there is varnish missing anywhere and is visible at an arm's length. Compare with scale card to see acceptable limits.

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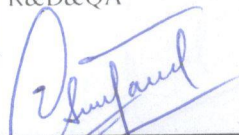
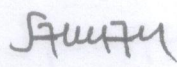
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4.4	Embossing Missing: Observe the sample closely & completely. See if there is embossing missing at any key element or text.
4.5	Varnish Position: Observe the sample closely & completely. Application of varnish should not exceed to glue able area. If found away, measure with the scale.
4.6	Smudging / Filling In: Observe the sample closely & completely. See if ink seems to be dragged down from printed text or design or ink fills text making it illegible and is visible at an arm's length. Compare with scale card to see acceptable limits.
4.7	Lines / Scratches / Stains / Spots: Observe the sample closely & completely. See if there are any lines of board or ink, stains/spots of ink/adhesives or water anywhere and are visible at an arm's length. Compare with scale card to see acceptable limits.
4.8	Picking : Observe the sample closely & completely. See if there are tiny white spots on the printed area in a considerable quantity and are visible at an arm's length. Compare with scale card to see acceptable limits.

SR. NO.	ACTIVITIES
4.9	Hickies (Skin): Observe the sample closely & completely. See if there are color spots encircled by white area on the printed area and are visible at an arm's length. Compare with scale card to see acceptable limits.
4.10	Offsetting: Observe the sample closely & completely. See if there is any transfer of print or ink on to the back side. Compare with scale card also to see acceptable limits.
4.11	Rubbing: Observe the sample closely & completely. See if there are impressions of belts rubbing off a color and are visible at an arm's length. Compare with scale card also to see acceptable limits.
4.12	Wrinkles: Observe the sample closely & completely. See if there is any longitudinal or transverse folding of paper / board that also causes print missing at printed area. Compare with scale card also to see acceptable limits.
4.13	Print To Print Registration: Observe the sample closely & completely. See whether the overlapping colors overlap completely or are away from each other. If found away, measure with the scale.

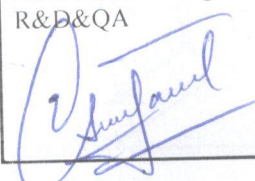
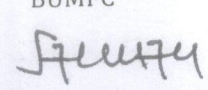
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4.14	Cut To Print Registration: Observe the sample closely & completely. See whether the print is in center with respect to design. If found away, measure with the scale.
4.15	Embossing To Print Registration: Observe the sample closely & completely. See whether the embossing overlaps the text or design. If found away, measure with the scale.
4.16	Uncut Flaps / Mitters: Observe the sample closely & completely. See whether the flaps / mitters are completely & cleanly cut and separable without applying pressure. Cutting will be improper if there is a sound or fiber of board comes along.
4.17	Creases Cut Through: Observe the sample closely & completely. There must be no detachment of flap / miter when folded at crease.
4.18	Board Cracking on Crease: Observe the sample closely & completely by folding each and every crease with hand. See whether there is any crack or fracture of board.
4.19	Glueability: Observe the sample closely & completely. Open the glued portion with hand and see if there is any glue missing / drying. Glue bond should be strong enough (with fiber pick in case of paper /board) and not easy to open by hand.
4.20	Reel Width: Keep the sample on a flat surface. Measure the width with the help of a measuring tape.

SR. NO.	ACTIVITIES
4.21	Welding (Sealing): Open the sealed portion with hand and see if there is any missing. Seal should be strong enough and not easy to open by hand.
4.22	Perforation: Observe the sample closely & completely. See if there is any missing of perforation. Tear the sample at perforation. It should tear with minimum force application without any distortion of material.

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4.23	Ink Adhesion: Keep the sample on a flat surface with printed side upwards. Take a piece of self adhesive tape and paste onto the printed surface keeping one end loose. Press entire length of tape with finger to eliminate air bubbles. Remove the tape quickly. See if there is any ink peeling off. Repeat the same by removing self adhesive tape slowly at an angle of 180 degree. See if there is any ink peeling off.
4.24	Carton Damage: Observe the sample closely & completely for any damage (corner damage, damage near window patching etc)
4.25	Cutting: Observe the sample closely & completely so that there is no burr, rough cutting & dust.
4.26	Sticking: Carton should not stick each other due to gluing, varnish, UV coating or any other process.
4.28	Print Centering: Check with the help of scale card that print is in the centre.

6.0 REPONSIBILITY:

- QA Supervisor
- Lab. Assistant

