

<b>PACKAGES CONVERTORS LIMITED BU-FC</b>	Document type WORK INSTRUCTION  Title METHOD FOR DETERMINATION OF THICKNESS OF PAPER & BOARDS
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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/8.2.4/09
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#### 1.0 PURPOSE:

To check the thickness Board.

#### 2.0 SCOPE:

This method covers the measurement of thickness Board.

#### 3.0 REFERENCES:

Sr.No.	Reference Document	Doc. No.
3.1	Standard Test Method	T 411 om-05

#### 4.0 APPARATUS:

4.1	Precision Micrometer	Progage Thickness Tester
4.2	Cutting Templates	6x6 cm, 10x10 cm, 25x30 cm, 20x25 cm
4.3	Cutting Knife	Alpha cutter knife

#### 5.0 PROCEDURE:

SR. NO.	ACTIVITIES
	Control Key Functions of Instrument
5.1.1	Zero: Zero the instrument.
5.1.2	Test: Starts a test.
5.1.3	Mode: Select operating. Push repeatedly to select, SINGLE,



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METHOD FOR DETERMINATION OF THICKNESS OF  
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SR. NO.	ACTIVITIES
5.2	TEST SPECIMEN:
5.2.1	Sample shall be flat and free from folds, wrinkles and dust.
5.2.2	Sample shall be representative of the pallets.
5.3	TESTING:
5.3.1	For single sheet thickness, cut test pieces of 60 mm x 60 mm or larger, from the sample. A size of 100 mm x 100 mm is usually satisfactory.
5.3.2	Check zero position of the micrometer before and also occasionally during the measurements.
5.3.3	For single sheet thickness insert the test piece between the faces so that the measurement will be made at least 20 mm from the nearest edge. Press TEST key. Presssure food will move down, contact the sample, and measurement reading will appear on display. Take at least four readings from a single sample.
5.1.4	Units: Select unit of measure: Push repeatedly to select MILS, MICRONS, MILLIMETERS, INCHES.
5.1.5	Review: Select review of test results. Push repeatedly to page through test results. Results are displayed last-first-out.
5.1.6	Statistics: Review statisticl data in READE mode. Data includes average, high, low, and standard deviation.
5.1.7	Clear: Clear current data results, results from a specific test number, or all test results from the memory.

## 6.0 CALCULATIONS:

SR. NO.	ACTIVITIES
6.1	For single sheet thickness, calculate the mean. Report the mean as the single sheet thickness to the nearest 1 $\mu$ .

## 7.0 RESPONSIBILITY:

- QA Supervisor
- Lab. Assistant

