

PACKAGES LIMITED BU-FC			Document type Raw Material Specifications Title Tobacco, Poly coated, Duplex (CWDB) & Bleached Board (CWBB) to be used for printing		
Prepared by Asad Javed Manager R&D&QA	Approved by Salman Fazlur Rehman BUMFC	PAGE 1(1)	REV 2	DATE 01.07.2024	DOC NO. SPQA/BUFC/RM/01

Reviewed on (Date): Reviewed by:	Reviewed on (Date): Reviewed by:	Reviewed on (Date): Reviewed by:	Reviewed on (Date): Reviewed by:
Approved on (Date): Approved by:	Approved on (Date): Approved by:	Approved on (Date): Approved by:	Approved on (Date): Approved by:

1. Tobacco Board :

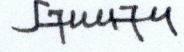
Parameter	Unit	Test Method/Standard	Equipment.	CWBB Tobacco (Roto)	
Grammage	g/m ²	T 410 om-02	Weighing scale	208 ± 4%	225 ± 4 %
Moisture	%	Tappi-412 om-11	Oven	6.5 ± 0.5	6.5 ± 0.5
Thickness	micron	T 411 om-05	Thickness meter	300 ± 5%	345 ± 5%
Curling	mm	Internal Method	Measuring tape/ruler	3-8	3-8
Twist	mm	Internal Method	Measuring tape/ruler	0-4	0-4
Size Variation	mm	---	Measuring tape	±1	±1
Wrong Size	mm	--	Measuring tape/ruler	0.0	0.0
Board Stiffness	'mN	SCAN P-29:95	L & W Stiffness tester	MD 155, CD 80 -15%	MD 240, CD 120 -15%
Internal Bond	J/m2	T 569pm-00	Internal Bond Tester	125-225	125-225
De-Lamination	OK/Not OK	Board should not delaminate	Visual	--	--
Slitting Dust / Burr	OK/Not OK	Tape Test	Manual	--	--
Dirty Reels	OK/Not OK	Board should not be dirty	Visual	--	--
Coating Lines	OK/Not OK	Lines should be not be visible from arm length	Visual	--	--
Scratches	OK/Not OK	Material should be scratches free	Visual	--	--
Cloudiness	OK/Not OK	Material should not be cloudy	Visual	--	--
Patchiness	OK/Not OK	Material should be patchiness free	Visual	--	--
Stains spots, Wrinkles	OK/Not OK	Material should be stains free	Visual	--	--
Weevil, Core Press	OK/Not OK	Material should be weevil free and core should not pressed	Visual		
Loose Winding	OK/Not OK	Winding of Reels should be tight	Visual	--	--
Damage	OK/Not OK	Board should not be damage	Visual	--	--

PACKAGES LIMITED

BU-FC

Document type
Raw Material Specifications

Title
Tobacco, Poly coated, Duplex (CWDB) & Bleached Board
(CWBB) to be used for printing

Prepared by Asad Javed Manager R&D&QA 	Approved by Salman Fazlur Rehman BUMFC 	PAGE 1(2)	REV 2	DATE 01.07.2024	DOC NO. SPQA/BUFC/RM/01
---	---	--------------	----------	--------------------	----------------------------

Shade Variation of Board	OK/Not OK/	As per Board shade card	Visual	--	--
Wrapping	OK/Not OK	Wrapping should be proper	Visual		--
Stacking	OK/Not OK	Material should properly stacked	Visual	--	--
Coating Test	20 ± 2g	Manual	--	--	--

2. Bleach Board & Poly Coated Board

[illegible]

PACKAGES LIMITED

BU-FC

Document type
Raw Material Specifications

Title
Tobacco, Poly coated, Duplex (CWDB) & Bleached Board (CWBB) to be used for printing

Prepared by Asad Javed Manager R&D&QA	Approved by Salman Fazlur Rehman BUMFC	PAGE 1(2)	REV 2	DATE 01.07.2024	DOC NO. SPQA/BUFC/RM/01
--	--	--------------	----------	--------------------	----------------------------

Weevil/Cor e Press	OK/ Not OK	Material should be weevil free and core should not pressed	Visual	--	--	--	--	--	--	--	--	--	--
Dirty Piles	OK/ Not OK	Board should not be dirty	Visual	--	--	--	--	--	--	--	--	--	--
Large Pallets	OK/ Not OK	Board should not be smaller large	Visual	--	--	--	--	--	--	--	--	--	--
Patchiness	OK/ Not OK	Material should not be cloudy	Visual	--	--	--	--	--	--	--	--	--	--

Cloudiness	OK/ Not OK	Material should not be cloudy	Visual	--	--	--	--	--	--	--	--	--	--
Pile height	OK/ Not OK	As per standard(13 00+20mm)	Manual	--	--	--	--	--	--	--	--	--	--
Dammage Material	OK/ Not OK	Board should not be dammage	Visual	--	--	--	--	--	--	--	--	--	--
Inverted Sheets	OK/ Not OK	Sheets should not be inverted	Visual	--	--	--	--	--	--	--	--	--	--
Shade Variation of board	OK/ Not OK/ Nok Ok	As per Board shade card	Visual	--	--	--	--	--	--	--	--	--	--
Wrapping	OK/ Not OK	Wrapping should be proper	Visual	--	--	--	--	--	--	--	--	--	--
Stacking	OK/ Not OK	Material should properly stacked	Visual	--	--	--	--	--	--	--	--	--	--
Coating Test	OK/ Not OK	20 ± 2g	Manual	--	--	--	--	--	--	--	--	--	--
Board Stiffness	mN	SCAN P- 29:95	Stiffnes s Tester	MD 120,C D 65 - 15%	MD 195,C D 105 - 15%	MD 310,C D 160 - 15%	MD 430,C D 205 - 15%	MD 670,C D 360 - 15%	MD 140,C D 85 - 15%	MD 140,C D 85 - 15%	MD 150,C D 85 - 15%	MD 200,C D 125 - 15%	MD 200,C D 125 - 15%
Internal Bond	J/m2	T 569pm-00	Internal Bond	125- 225	125- 225	125- 225	125- 225	125- 225	--	--	--	--	--

PACKAGES LIMITED

BU-FC

Document type
Raw Material Specifications

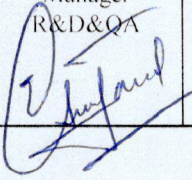
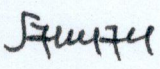
Title
Tobacco, Poly coated, Duplex (CWDB) & Bleached Board (CWBB) to be used for printing

Prepared by Asad Javed Manager R&D&QA	Approved by Salman Fazlur Rehman BUMFC	PAGE 1(2)	REV 2	DATE 01.07.2024	DOC NO. SPQA/BUFC/RM/01
--	--	--------------	----------	--------------------	----------------------------

Duplex Board

Parameter	Unit	Test Method	Equipment	CWDB Offset				
				230	250	275	300	325
Grammage	g/m ²	T 410 om-02	Weighing scale	230 ± 4%	250 ± 5%	275 ± 4%	275 ± 4%	300 ± 4%
Moisture	%	Tappi-412 om-11	Oven	7.5 ± 1	7.5 ± 1	7.5 ± 1	7.5 ± 1	7.5 ± 1
Thickness	micron	T 411 om-05	Thickness Meter	290±5%	320±5%	345±5%	380±5%	425±5%
Squareness	mm	Internal Method	Measuring tape	0.2 maximum	0.2 maximum	0.2 maximum	0.2 maximum	0.2 maximum
Wrong Size	mm	---	Measuring tape	± 0.00	± 0.00	± 0.00	± 0.00	± 0.00
Size Variation	mm	---	Measuring tape	±1 mm	±1 mm	±1 mm	±1 mm	±1 mm
Waviness/Flatness	mm	Internal Method	Measuring tape	MD- 0-15	MD- 0-15	MD- 0-15	MD- 0-15	MD- 0-15
				CD- 0-15	CD- 0-15	CD- 0-15	CD- 0-15	CD- 0-15
De-Lamination	OK/Not OK	Board should not delaminate	Visual	--	--	--		--
Slitting Dust / Burr	OK/Not OK	Tape Test	Visual	--	--	--		--
Scratches	OK/Not OK	Material should be scratches free	Visual	--	--	--		--
Coating Lines	OK/Not OK	Lines should be not be visible from arm length	Visual	--	--	--		--
Stains spots, Wrinkles	OK/Not OK	Material should be stains and Wrinkles free	Visual	--	--	--		--
Weevil/Core Press	OK/Not OK	Material should be weevil free and core should not pressed	Visual	--	--	--		--
Dirty Piles	OK/Not OK	Board should not be dirty	Visual	--	--	--		--
Large Pallets	OK/Not OK	Board should not be smaller and large	Visual	--	--	--		--
Patchiness	OK/Not OK	Material should be patchiness free	Visual	--	--	--		--
Cloudiness	OK/Not OK	Material should not be cloudy	Visual	--	--	--		--
Pile height	OK/Not OK	As per standard(1300+20 mm)	Manual	--	--	--		--
Dammage Material	OK/Not OK	Board should not be dammage	Visual	--	--	--		--
Inverted Sheets	OK/Not OK	Sheets should not be inverted	Visual	--	--	--		--

PACKAGES LIMITED BU-FC				Document type Raw Material Specifications Title Tobacco, Poly coated, Duplex (CWDB) & Bleached Board (CWBB) to be used for printing				
Shade Variation of board	OK/Not OK/Nok Ok	As per Board shade card	Visual	--	--	--		--

Prepared by Asad Javed Manager R&D&QA 	Approved by Salman Fazlur Rehman BUMFC 	PAGE 1(2)	REV 2	DATE 01.07.2024	DOC NO. SPQA/BUFC/RM/01
---	---	--------------	----------	--------------------	----------------------------

Wrapping	OK/Not OK	Wrapping should be proper	Visual		--	--		--
Stacking	OK/Not OK	Material should properly stacked	Visual	--	--	--		--
Coating Test	OK/Not OK	20 ± 2g.	Manual	--	--	--		--
Board Stiffness	‘mN	SCAN P-29:95	Stiffness Tester	MD110,CD6 5 - 15%	MD155,CD8 0 - 15%	MD192,CD11 2 - 15%	MD360,CD13 5 - 15%	MD320,CD17 0 - 15%
Internal Bond	J/m2	T 569pm-00	Internal Bond	125-225	125-225	125-225	125-225	125-225

**CONTROLLED
DOCUMENT**

BUSINESS UNIT FOLDING CARTON (BUFC)