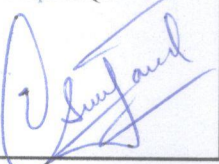
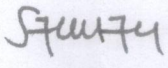


# PACKAGES CONVERTORS LIMITED

(BU – Folding Carton)

Document type  
WORK INSTRUCTION

Title  
SAMPLING AND TESTING PLAN FOR FINISHED  
PRODUCTS

Prepared by Asad Javed Manager R&D&QA 	Approved by Salman Fazul –ur Rehman BUMFC 	PAGE  1(9)	REV  18	DATE  01.07.2024	DOC NO.  WIQA/BU-FC/8.2.4/02
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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:

## 1.0 PURPOSE:

To ensure that the quality of the finished products meets the specifications.

## 2.0 SCOPE:

This is applicable to the finished products of the Business Unit – Folding Carton.

## 3.0 DEFINITIONS:

3.1	UNGLUED CARTONS	Unglued cartons include flat hinge lids, flat cartons, tucks, labels, sheets, wrappers, display cartons, dispensers, flat tops & bottoms, flat shells, match/cigarette slides, skillets, lids, sleeves etc.
3.2	GLUED CARTONS	Glued cartons include cartons, shells, glued dispensers, glued tops & bottoms, glued tucks, glued display cartons etc.
3.3	LOT SIZE	Total number of cartons packed in a specific number of cases or on a pallet will be considered a lot and will be taken as lot size. However Crease Stiffness (HLs) will be tested once/shift for every job.

## 4.0 REFERENCES:

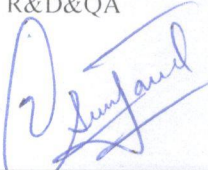
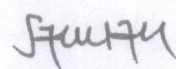
Sr. No.	Reference Document	Doc. No.
4.1	Sampling Plan	ISO 2859-1: 1999 (E)
4.2	Quality Plan	QPQA/BU-FC/02
4.3	Specifications	Finished Product Specifications
4.4	Labeling Plan	WIQA /BU-FC/7.5.3/01
4.5	Test Methods	--

## 5.0 PROCEDURE:

SR. NO.	ACTIVITIES	RESPONSIBILITY
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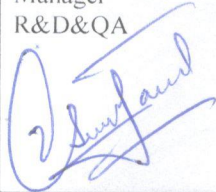
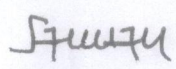
Prepared by Asad Javed Manager R&D&QA 	Approved by Salman Fazul –uy Rehman BUMFC 	PAGE  2(9)	REV  18	DATE  01.07.2024	DOC NO.  WIQA/BU-FC/8.2.4/02
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5.1	Sampling	Lab Assistant/ QA Supervisor
5.1.1	Glued / Unglued Cartons Of FG And CC Departments:	
	Samples will be taken from the cases being packed of each and every machine and / or pallet as per sampling plan of annexure – 2, after assigning the pile numbers according to the Identification and Traceability Procedure.	
5.1.2	Unglued Cartons Of Lemanic Department:	
	Samples will be taken from each and every pallet as per sampling plan of annexure – 1, after assigning the pallet numbers according to the Identification and Traceability Procedure.	
5.1.3	Paper Cups:	
	Samples will be taken from the cases being packed of each and every machine and / or pallet as per sampling plan of annexure – 2, after assigning the pile numbers according to the Identification and Traceability Procedure.	

#### 5.0 PROCEDURE:

SR. NO.	ACTIVITIES	RESPONSIBILITY
5.2	Inspection and Testing	Lab Assistant/ QA Supervisor
5.2.1	Inspection & testing will be done according to the quality plan No. QPQA/BU-FC/02.	
5.2.2	Glued Cartons Of FG Department:	
5.2.2.1	Attributes (AQL 0.15)	
	Smudging/filling in Hickies (skin) Rubbing Offsetting Lines/scratch/wrinkles Un-cut flaps Creases cut through Glueability Lamination Sticking Seepage of poly Stiffener Height Packing in poly Bar code readability Tuck In	
5.2.2.2	Attributes (AQL 1.5)	

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	Print/text missing Board cracking on crease Print to print registration Cut to print registration Emboss to print registration Color variation Window patching Perforation	
5.2.2.3	Attributes (AQL 4.0)	
	Embossing missing Varnish missing Stains/spots Picking Folding Carton damage Dust/Burr Bade smell Orientation Strips Hot foiling	
5.2.2.4	Special Testing:	
	05 samples from every lot will be inspected to verify grammage.	

#### 5.0 PROCEDURE:

5.2.3	Flat cartons/HL (un-glued cartons) of CC Department	
5.2.3.1	Attributes (AQL 0.15)	
	Print to print registration Cut to print registration Emboss to print registration Un-cut flaps Crease cut through Varnish position Cutting	
5.2.3.2	Attributes (AQL 1.5)	
	Print/text missing Board cracking on crease	
5.2.3.3	Attributes (AQL 4.0)	

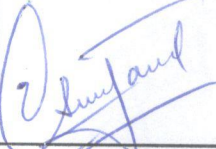
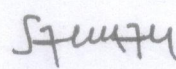


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	Colour variation Embossing missing Varnish missing Smudging/filling in Lines/scratches/wrinkles Stain/spots Picking Hickies (skin) Rubbing Offsetting Lamination Carton damage Bad Smell Dust/Burr Orientation Hot foiling	
5.2.3.4	Special Testing:	
	One sample from every lot will be tested for Curl (Bow) at four points for hinge lid cartons.	
	For the jobs of PTC, PMI H/L cartons, once in a shift, one sample of each UP will be tested for crease stiffness.	
	01 samples from every lot will be tested to verify grammage.	

## 5.0 PROCEDURE:


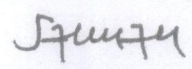
SR. NO.	ACTIVITIES	RESPONSIBILITY
5.2.4	Unglued cartons of Roto Line:	
5.2.4.1	Attributes (AQL 2.5)	

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	<ul style="list-style-type: none"> <li>Colour variation</li> <li>Embossing missing</li> <li>Print/text missing</li> <li>Varnish missing</li> <li>Smudging/filling in</li> <li>Lines/scratches/wrinkles</li> <li>Stain/spots</li> <li>Picking</li> <li>Hickies (skin)</li> <li>Rubbing</li> <li>Offsetting</li> <li>Print to print registration</li> <li>Cut to print registration</li> <li>Emboss to print registration</li> <li>Un-cut flaps</li> <li>Crease cut through</li> <li>Board cracking on crease</li> <li>Varnish position</li> <li>Bade smell</li> <li>Dust/ burr</li> <li>Stacking of bundle</li> <li>Nicks</li> <li>Long Fibers</li> <li>Quantity per bundle</li> </ul>	
5.2.4.2	Special Testing:	
	One sample from every lot will be tested for Curl (Bow) at four points of hinge lid cartons.	
	Once per shift, one sample of each UP will be tested for crease stiffness.	
	One sample daily will be tested for solvent retention.	
	05samples from every lot will be tested to verify grammage.	
	One sample per shift from every job will be tested for moisture %.	

## 5.0 PROCEDURE:

SR. NO.	ACTIVITIES	RESPONSIBILITY
5.2.5	Glued cartons for Pakistan Tobacco Company:	
5.2.5.1	Attributes (AQL 2.5)	

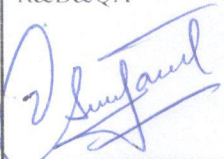
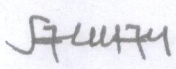


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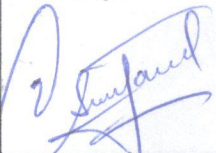
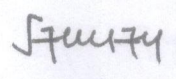
Prepared by	Approved by	PAGE	REV	DATE	DOC NO.
Asad Javed Manager R&D&QA 	Salman Fazul –uy Rehman BUMFC 	6(9)	18	01.07.2024	WIQA/BU-FC/8.2.4/02

	<ul style="list-style-type: none"> <li>Colour variation</li> <li>Embossing missing</li> <li>Print/text missing</li> <li>Varnish missing</li> <li>Smudging/filling in</li> <li>Lines/scratches/wrinkles</li> <li>Stain/spots</li> <li>Picking</li> <li>Hickies (skin)</li> <li>Rubbing</li> <li>Offsetting</li> <li>Print to print registration</li> <li>Cut to print registration</li> <li>Emboss to print registration</li> <li>Crease cut through</li> <li>Board cracking on crease</li> <li>Glueability</li> <li>Folding</li> </ul>	
5.2.5.2	Special Testing:	
	03 samples from every lot will be tested to verify grammage.	
5.2.6	Paper Cups:	
5.2.6.1	Attributes (AQL 0.15)	
	<ul style="list-style-type: none"> <li>Sealability</li> <li>Grease/burn marks on cups</li> </ul>	
5.2.6.2	Attributes (AQL 1.5)	
	<ul style="list-style-type: none"> <li>Offsetting</li> <li>Lip formation</li> <li>Bottom folding</li> <li>Cup formation</li> <li>Bade smell</li> <li>Dust burr</li> </ul>	
5.2.6.3	Attributes (AQL 4.0)	
	<ul style="list-style-type: none"> <li>Print to print registration</li> <li>Varnish missing</li> <li>Smudging/filling in</li> <li>Lines/scratch/wrinkles</li> <li>Stain/spots</li> <li>Picking</li> <li>Hickies (skin)</li> <li>Rubbing</li> <li>Colour variation</li> <li>Print/text missing</li> </ul>	

**PACKAGES  
CONVERTORS  
LIMITED**  
(BU – Folding Carton)

Document type  
WORK INSTRUCTION

Title  
SAMPLING AND TESTING PLAN FOR FINISHED  
PRODUCTS

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5.2.6.4	Special Testing:	
	05 samples from every lot will be tested to verify grammage.	

5.0 PROCEDURE:

SR. NO.	ACTIVITIES	RESPONSIBILITY
5.3	Reporting	
5.3.1	The results will be reported on the respective test report Performa.	Lab Assistant/ QA Supervisor
5.3.2	Manager QA or I/c QA or his representative will countersign the reports.	Manager QA I/c QA
5.4	Releasing Of Stock	Lab Assistant/ QA Supervisor
5.4.1	The testing will be done at ambient conditions. At Temperature 25±5 and Humidity RH 60±10	
5.4.2	Release / hold of the lot will be based on the results of the critical parameters only.	
5.4.3	For variable parameters lot will be released / held according to the sampling table for variable parameters. If the number of samples having observed value beyond specifications is more than “k” the lot will be held otherwise released.	
5.4.4	For attribute parameters lot will be released / held according to the sampling table for attribute parameters. If the number of defective samples equals to or is greater than “Re”, lot will be held otherwise released.	
5.4.5	The lot will be released / held according to the sampling tables of annexure.	
5.4.6	On the basis of test report, stickers of "RELEASED", OR "HOLD" will be pasted on each box or pallet of glued / unglued cartons / paper cups according to the labeling plan No. WIQA/7.5.3/01. A stamp may be used in lieu of stickers.	

ANNEXURE – 1  
Sampling Table For Attributes

AQL 2.5; Sampling Level S-3

Single sampling plans for normal inspection (Master Table)

Lot Size	Sample Size	Acceptance Number	Rejection Number
N	n	Ac	Re
2 – 15	2	0	1
16 – 50	3	0	1

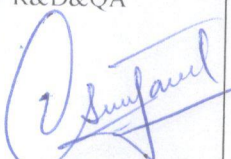
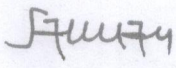


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51 – 150	5	0	1
151 – 500	8	0	1
501 – 3200	13	1	2
3201 – 35000	20	1	2
35001 – 500000	32	2	3
500001 and over	50	3	4

Note:

Lot size equals to the total quantity of cartons in a specified lot and the sample size will be according to that lot size.

## ANNEXURE – 2

### Sampling Table For Attributes

#### Sampling Level S-3

Lot size	Sample size	Critical defects (AQL 0.15 %)		Major defects (AQL 1.5 %)		Minor defects (AQL 4.0 %)	
		Acceptance Number	Rejection Number	Acceptance Number	Rejection Number	Acceptance Number	Rejection Number
N	n	Ac	Re	Ac	Re	Ac	Re
2 – 15	2	0	1	0	1	0	1
16 – 50	3	0	1	0	1	0	1
51 – 150	5	0	1	0	1	0	1
151 – 500	8	0	1	0	1	1	2
501 – 3200	13	0	1	0	1	1	2
3201 – 35000	20	0	1	0	1	2	3
35001 – 500000	32	0	1	1	2	3	4
500001 & above	50	0	1	2	3	5	6

Note:

Lot size equals to the total quantity of cartons / paper cups in a specified lot and the sample size will be according to that lot size.

Note: On 2<sup>nd</sup> complaints following sampling plan will be followed (Means we will shift on tightened sampling plan).

## ANNEXURE – 1

### Sampling Table For Attributes

#### AQL 2.5; Sampling Level S-4

Single sampling plans for normal inspection (Master Table)

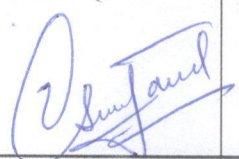
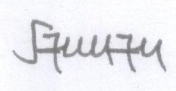


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Lot Size	Sample Size	Acceptance Number	Rejection Number
N	n	Ac	Re
2 – 15	2	0	1
16 – 50	5	0	1
51 – 150	8	0	1
151 – 500	13	0	1
501 – 3200	32	1	2
3201 – 35000	50	2	3
35001 – 500000	80	3	4

Note:

Lot size equals to the total quantity of cartons in a specified lot and the sample size will be according to that lot size.

## ANNEXURE – 2

### Sampling Table For Attributes

#### Sampling Level S-4

Lot size	Sample size	Critical defects (AQL 0.15 %)		Major defects (AQL 1.5 %)		Minor defects (AQL 4.0 %)	
		Acceptance Number	Rejection Number	Acceptance Number	Rejection Number	Acceptance Number	Rejection Number
N	n	Ac	Re	Ac	Re	Ac	Re
2 – 15	2	0	1	0	1	0	1
16 – 50	5	0	1	0	1	0	1
51 – 150	8	0	1	0	1	1	2
151 – 500	13	0	1	0	1	1	2
501 – 3200	32	0	1	0	1	2	3
3201 – 35000	50	0	1	1	2	3	4
35001 – 500000	80	0	1	2	3	5	6

Note: Lot size equals to the total quantity of cartons / Paper cups in a specified lot and the samples size will be according to that lot size.

