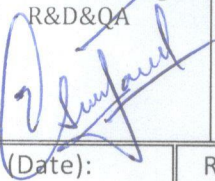
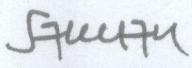


# PACKAGES CONVERTORS LIMITED

BU-FC

Document type  
WORK INSTRUCTION

Title  
METHOD FOR TESTING OF CREASE STIFFNESS OF FLAT  
HING ELIDS

|                                                                                                                                  |                                                                                                                                         |              |          |                    |                                |
|----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------|--------------|----------|--------------------|--------------------------------|
| Prepared by<br>Asad Javed Manager<br>R&D&QA<br> | Approved by<br>Salman Fazul -uy<br>Rehman<br>BUMFC<br> | PAGE<br>1(2) | REV<br>1 | DATE<br>01.07.2024 | DOC NO.<br>WIQA/BU-FC/8.2.4/04 |
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| Approved on (Date):<br><br>Approved by: | Approved on (Date):<br><br>Approved by: | Approved on (Date):<br><br>Approved by: | Approved on (Date):<br><br>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:

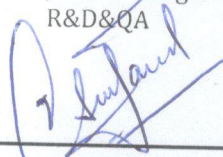
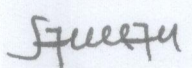
Internal Method

## 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.                                                                                        |



|                                                         |                                                                    |
|---------------------------------------------------------|--------------------------------------------------------------------|
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|                                                                                                                                  |                                                                                                                                         |                  |              |                        |                                    |
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|----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------|------------------|--------------|------------------------|------------------------------------|

|      |                                                                                                                                                                                        |
|------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 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 REPOSIBILITY:

- Lab Assistant
- Quality Assurance Supervisor

