

TEST PROCEDURE GUIDELINES

TEST METHODS: MEASURING IML LABEL PLACEMENT
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PURPOSE OF PROCEDURE:

To provide the customer with the label placement quality that they require.

Scope: This procedure will provide an explanation of IML label placement measurement techniques.

Responsibilities: While it is the responsibility of the line operator to maintain quality label placement, it is also the responsibility of QA personnel to see that quality standards are maintained.

Communications: There must be an open line of communication between QA personnel and production personnel on quality standards and any variations found in the production.

DEFINITION OF TERMS:

IML Quality Check Sheet cues:

FB - Front Baseline

BB - Back Baseline

FT - Front Top Registration

BT - Back Top Registration

FL - Front Lower Registration

BL - Back Lower Registration

FS - Front Skew

BS - Back Skew

EQUIPMENT/MATERIALS NEEDED:

1. 6inch (15cm) Ruler in 1/64inch (1mm) increments.
2. IML Quality Check Sheet (see Documentation).

TEST PROCEDURE:

1. Baselines
 - A. Place the bottle on a flat surface.
 - B. Hold a ruler vertically against the bottle with the "0" on the flat surface.
 - C. Use the ruler to determine the distance from the flat surface to the bottom of the label. (*Use the center of the label as a measurement reference point.*)
 - D. Record the measurement on the IML Quality Check Sheet at FB or BB.
2. Side to Side Registration

- A. Determine the location of the measurements to be taken on both sides of the panel. (*See Diagram*)

MEASURING IML LABEL PLACEMENT (cont'd)

- B. Subtract the distance from side to side and divide the difference by two.
1. Measure the side to side registration at the determined areas at the top of the panel and the bottom of the panel.
 2. If the left side distance is less than the right side distance, the registration will be negative. (*The label is off register to the left.*)
 3. If the left side distance is greater than the right side distance, the registration will be positive. (*The label is off register to the right.*)
- C. Record the measurement on the IML Quality Check Sheet at FT/FL and BT/BL.

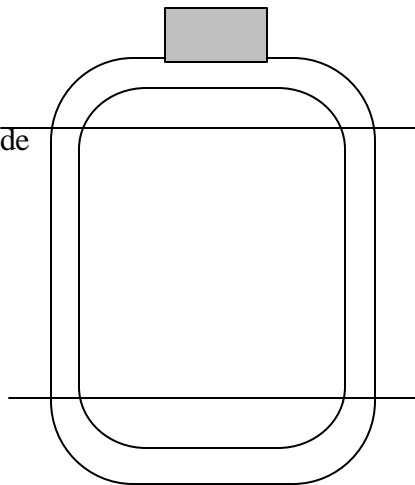
3. Skewness

- A. Measure the side to side registration at the top and bottom of the bottle in the pre-determined areas using the instructions from #2 (A and B)
1. If the side to side registration at the top is positive and the side to side registration at the bottom is positive *subtract* the two numbers to determine the label skew.
 2. If the side to side registration at the top is positive and side to side registration at the bottom is negative *add* the numbers together. The sum is the label skew.
 3. If the side to side registration at the top and the side to side registration at the bottom is the same the skew will be "0".
 4. If the side to side registration at the top is negative and the side to side registration at the bottom is negative *subtract* the numbers to find the label skew.
- B. Record the measurement on the IML Quality Check Sheet at FS or BS.

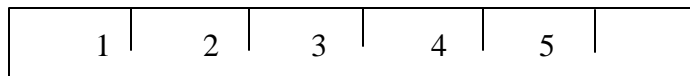
DIAGRAM:

Measure side to side
top reg. here

Measure side to
side bottom
reg. here



6 Inch Ruler (15cm), 1/64inch (1mm) increments



MEASURING IML LABEL PLACEMENT (cont-d)

DOCUMENTATION:

IML Quality Check Sheet Sample

Customer _____ Date _____ Description _____

Cavity # _____

TIME	FB	FT	FL	FS	BB	BT	BL	BS

Cavity # _____

Cavity # _____

FB	FT	FL	FS	BB	BT	BL	BS

FB	FT	FL	FS	BB	BT	BL	BS

REFERENCES: