

TEST PROCEDURE GUIDELINES

<i>TEST METHODS:</i> STATIC

PURPOSE OF PROCEDURE:

To determine effect of static within the in-mold process as a whole.

DEFINITION OF TERMS:

Electrical discharges in the atmosphere that interfere with the equipment, labels and substrates of the in-mold process.

EQUIPMENT/MATERIALS NEEDED:

1. Static meter
2. Static elimination devices
3. Static neutralizers

TEST PROCEDURE:

Measure static throughout each process with a static meter at a distance of 1 - 3 inches from the material. Record data daily to ensure that static is under control in all conditions. Static control should be recorded with incoming quality checks at each suppliers facility.

Converter: Control static throughout the process and ensure that the lowest amount of static is recorded before product is shipped. The use of static control equipment throughout the process will aid in the elimination of static.

Blow Molder: Measure and record static readings at the point of application of in-mold labels. Control static with static elimination equipment to increase accuracy of the label and reduce waste.

Note: At times a joint development agreement will be needed.

STATIC (cont'd)

DOCUMENTATION:

The allowable tolerance that is agreed upon by the customer should be in written specifications provided by the customer.

The frequency of the test to be performed must also be agreed upon by the customer. That is to say that the customer should provide in his specification how often the test is to be done and by what form of sampling method, (random or non-random). These will be used to record results.

Many customers will require representative samples to be kept in inventory to reference in the event that the customer finds a defect in the provided order. This frequency of these retains should also be specified to ensure compliance.

REFERENCES: