

TEST PROCEDURE GUIDELINES

TEST METHODS: STORAGE AND HANDLING CONDITIONS FOR IN-MOLD
--

PURPOSE OF PROCEDURE:

To outline recommendations of storage and handling conditions for In-Mold substrates in all forms (sheets, rolls, labels, printed and unprinted).

SCOPE:

Applies to all In-Mold substrates in any format.

DEFINITION OF TERMS:

N/A

EQUIPMENT/MATERIALS NEEDED:

As required.

TEST PROCEDURE:

Storage of materials should be maintained within the following guidelines:

1. Ambient Conditions:
 - A. *Temperature:* Maintain storage at 72E F plus or minus 5 degrees (22° C +/- 2° C).
 - B. *Humidity:* 50% R.H. plus or minus 10%.
 - C. Temperatures that exceed these limits will have a detrimental effect on the material.
 - D. Effects worsen with higher temperature, humidity, and longer periods.
 - E. Materials stored under conditions other than these are suspect.

2. General Handling:
 - A. Do not double tier pallets or rolls.
 - B. Ship rolls in a **A**poker chip@ fashion (laying flat), not in a rolled position.
 - C. Store supplied materials in a clean and moisture free environment. Follow instructions supplied by the manufacturers.
 - D. When ambient temperatures exceed limits listed above, refrigerated trucks are preferred for shipping.
 - E. Maintain the lowest amount of tension in rolls, but still achieve a constant stable roll.

STORAGE AND HANDLING CONDITIONS FOR IN-MOLD (cont'd)

3. Inks and Coatings:

Follow manufacturer's guidelines for temperature, exposure and shelf life.

4. Stock Rotation:

First In, First Out (FIFO) should be practiced on all materials. Always follow suppliers guidelines and recommendations for shelf storage life and usage of material.

DOCUMENTATION:

Consistent with good manufacturing practice.

REFERENCES:

1. These procedures are guidelines and recommendations to achieve optimum performance of all materials associated with In-Mold labeling.
2. These recommendations were compiled from material suppliers, ink and coating manufacturers, converters, and blow molders.