

<b>BJP, s.r.o.</b> <b>Jeremenkova 1160/90a</b> <b>13000 Praha 3</b>	<b>CPP and BOPP pouches and bags</b>	<b>PN-1-2017</b>
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## **COMPANY STANDARD**

**This company standard applies to the manufacture of CPP and BOPP pouches and bags.**

### **I. Use of pouches**

Pouches and bags (hereinafter, the pouches) are used to pack various products that do not cause damage to the pouch by their shape, weight or chemical effect. In a suitable form they protect these products from moisture, contamination or dryness.

The pouches are made in one quality class.

#### **Order content:**

- a) name of product
- b) dimensions in the following order: material width, height, thickness
- c) quantity in pieces
- d) packaging in cardboard and on pallets

### **II. APPEARANCE AND execution**

Pouches and bags are made by welding from the corresponding non-toxic PP foils. These foils comply with the standard ČSN EN 13430 – Material Recycling, ČSN EN 13428 – dangerous and harmful substances, ČSN CR 13695-1 – contents of heavy metals, ČSN EN 13431 – energy recovery.

The walls of the bags and pouches must be intact, without holes and cracks.

The dimensions are measured by a metal ruler or tape measure in three places, uniformly distributed on the product with the precision of  $\pm 1$  mm. Recycling codes are printed in black colour.

#### **Recycling codes:**

- a) print size 6-17 mm
- b) print pigment – measured by photospectrometer, with deviation determined against a PANTONE sampler. Our colour is PANTONE BLACK with max. deviation of  $\Delta E 20$ .

#### **Permitted defects:**

- a) smaller folds not affecting the functional properties of the pouches
- b) mild adhesiveness of pouch side walls unless affecting the functional properties
- c) mild creasing of the side weld
- d) 3-4 mm eyes in the bottom side of the weld in perforated foils of the thickness of 0.05 mm
- e) the pouch can also contain incomplete recycling codes, but at least one set must always be complete
- f) slight foil clouding due to granulate type

#### **Permitted deviations:**

	up to 300 mm	up to 600 mm	up to 1000 mm	above 1000
pouch width	+5 mm	+10 mm	+15 mm	+20 mm
pouch length	+5 mm	+10 mm	+15 mm	+20 mm
bottom fold	+7 mm	+ 7 mm	+ 7 mm	+ 7 mm
flap	+7 mm	+ 7 mm	+ 7 mm	+ 7 mm

- tolerance of foil thickness deviation is +- 5%
- tolerance of quantity deviation in individual cartons is 2 %
- tolerance of weight deviation in individual cartons is 5 %
- tolerance of code blurring deviation in 0.5 % of pouches
- tolerance of weld strength +- 5% by quantity

#### **Colour:**

Pouches are made in transparent execution or coloured, or possibly with print on the outer side.  
Pouch dimensions are stated as follows: width x height x thickness in mm (+ possibly lower fold and flaps)  
Dimensions of pouches with fold are stated as follows: width + total length of the side fold x height  
x thickness in mm  
Width = the open side of the pouch

#### **III. TESTING**

The appearance and execution are checked visually for conformity with art. II, the dimensions are measured by a ruler and micrometer (measuring equipment is calibrated); weld strength is checked according to ČSN 7700140.

#### **IV. LABELLING, PACKING, TRANSPORT**

Each packaging unit contains a label bearing the following data:

- a) product name and type
- b) product dimensions in mm
- c) quantity in pcs
- d) manufacture date and barcode

Pouches are transported in covered, clean and dry vehicles to prevent their damage.  
They are stored in compliance with ČSN 640090.

Pallet units are transported by various means of transport. The load must be secured against shifting and damage by sharp objects.

CPP foil pouches are classified and marked pursuant to Act No. 258/2000 Coll., on Protection of Public Health and the Decree of the Ministry of Health 38/2001 on Hygienic Requirements for Products Intended to Come into Contact with Foodstuffs. They comply with the requirements of the Commission Regulation (EU) No. 10/2011 on Plastic Materials and Articles Intended to Come into Contact with Foodstuffs.

#### **V. Waste disposal instructions**

Pouches and bags made of CPP and BOPP foils are environmentally and hygienically harmless.  
They are 100% recyclable and can be disposed of by burning.