

BJP, s.r.o. Jeremenkova 1160/90a 13000 Praha 3	LDPE and HDPE bags and sacks with lower weld	PN-3-2017
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COMPANY STANDARD

This business standard applies to the manufacture of LDPE and HDPE sacks and bags with lower welds.

I. USE OF BAGS AND SACKS

Bags and sacks (hereinafter referred to as "BAGS") are used to package different products that do not cause damage to the bag due to its shape, weight or chemical action. In a suitable form, they protect these products from dampening, dirt or drying.

Bags are produced in one class of quality.

Order Contents:

- a) the name of the product
- b) dimensions in order of width, height, and material thickness
- c) quantities in pieces
- d) packaging in cartons and pallets

The dimensions of the bags are given: Width x Height x Strength in mm (+ or lateral storage)

Width = open side of bag

II. APPEARANCE AND FINISHMENT

Both bags and sacks are made by welding from the appropriate non-toxic PE foils.

These foils comply with the ČSN EN 13430 standards - recycling of materials, ČSN EN 13428 - hazardous and noxious substances, ČSN CR 13695-1 - Heavy metal content, ČSN EN 13431 - Energy appreciation.

Mild differences in color saturation and color shades are not considered to be a defect.

The walls of both sacks and bags must be solid, without holes and cracks.

Dimensions are measured with a metallic meter or band at three points uniformly distributed on the product with an accuracy of + -1 mm. Recycling characters are printed in black.

Recycling signs:

- a) print size of 6-17 mm
- b) printing pigmentation - measured with a photo-spectrometer, where the deviation is determined by PANTONE sampler

Our color is PNATONE BLACK with maximum delta E 20 deviation.

Permitted defects:

- a) minor folds which do not affect the functional properties of the bags
- b) slight adhesion of the side walls of the bag, unless it affects the functional properties
- c) moderate ribbing of the side weld
- d) 3-4 mm loops in the lower sidewall of the weld with perforated foils at a thickness of 0.05 my
- e) Incomplete recycling marks may also appear on the bag, but at least one set must be complete
- f) slight turbidity of the foil due to the type of granulate

Permissible deviations:

	under 300 mm	under 600 mm	to 1000 mm	over 1000 mm
bag width	+ -20 mm	+ -20 mm	+ -20 mm	+ -20 mm
bag length	+ -10 mm	+ -10 mm	+ -15 mm	+ -20 mm
raport mark	+ - 8 mm	+ - 8 mm	+ - 8 mm	+ - 8 mm
side stock	+ -15 mm	+ -15 mm	+ -15 mm	+ -15 mm

- the deviation tolerance to foil thickness is + - 5%
- the deviation tolerance in quantity in individual cartons is 2%
- the tolerance of the weight deviation in individual cartons is 5%
- the tolerance of character blur in 0.5% bags
- the tolerance of the strength of the weld is + + - 5%

For bag length over 2000 mm the tolerance is + -30 mm

Perforation:

diameter 6, 8, 10 and 12 mm, positioning according to the design with a tolerance of + - 15 mm

C section:

deviation in position to length + - 10 mm and width + - 15 mm

Color:

The bags are made in transparent or colored material that can be printed on.

III. TESTING

Appearance and design are checked visually whether they correspond to Art. II, dimensions are measured by metro and micrometer (measuring means are calibrated), weld strength according to ČSN 770140.

IV. MARKING, PACKAGING, TRANSPORT

Each packaging unit is labeled with:

- a) the name of the product; type of the product
- b) dimensions of the product in mm
- c) quantity in pieces
- d) production date and barcode

The bags are transported in covered, clean and dry vehicles so as not to damage them.

They are stored according to ČSN 640090.

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

Bags and sacks made of LDPE and HDPE foils are classified and labeled according to Act 258/2000 Coll. Health Protection Act and Exc. MZ No 38/2001 on hygiene requirements for products intended for contact with foodstuffs. They meet the requirements of Commission Regulation (EU) No. 10/2011 on plastic materials and articles intended to come into contact with food.

V. WASTE MANAGEMENT GUIDELINES

Bags and sacks made from LDPE and HDPE foils are environmentally and hygienically safe. Upon perfect combustion (above 500 ° C), CO₂ and H₂O are produced, and no toxic substances are formed. They are 100% recyclable and can be disposed of by combustion.

Conducted by: Jiří Linhart

On October 1, 2017

Effective from: 1. 10. 2017