

BJP, s.r.o. Jeremenkova 1160/90a 13000 Praha 3	DPE and HDPE sacks	PN-3-2017
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Company standard

This Company Standard applies to the production of rolled LDPE and HDPE bags.

I. THE USE OF ROLLED BAGS

Rolled bags (herein after 'sacks') 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.

Sacks are produced in one class of quality.

Order Contents:

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

Dimensions of sacks in stock are given: width + total length of side stock x height x force in mm

II. APPEARANCE AND PRODUCTION

Sacks are made by welding from the appropriate non-toxic PE foils.

These foils comply with the ČSN EN 13430 standards on recycling of materials, ČSN EN 13428 standards on hazardous and noxious substances, ČSN CR 13695-1 standards on heavy metal content, ČSN EN 13431 standards on energy evaluation.

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

The sack walls 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 Characters:

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

Our colour is PANTONE 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 mm
- e) Incomplete recycling marks may also appear on the bag - at least one set must be complete
- f) slight turbidity of the foil due to the type of granulate

Permissible deviations:

	within 300 mm	within 600 mm	within 1000 mm	within 1000 mm
Bag width	+5 mm	+10 mm	+15 mm	+20 mm
Bag length	+10 mm	+10 mm	+15 mm	+25 mm
Report mark	+8 mm	+8 mm	+8 mm	+8 mm
Side fold (1 side)	+15 mm	+15 mm	+15 mm	+15 mm
Straightening of the role	+20 mm on each side			

- Tolerance of tolerance to foil thickness is $\pm 5\%$

- Tolerance of character blur in 0.5% bags

Colour:

Sacks are made transparent or coloured or printed on the outside.

III. TESTING

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

IV. MARKING, PACKAGING, TRANSPORT

Each packaging unit is labelled with:

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

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

They are stored according to ČSN 640090 standard.

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

Sacks of LDPE and HDPE foils are classified and labelled 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

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

Conducted by: Jiří Linhart

On October 1, 2017

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