



Enclosure no 1

**QUALITY STANDARDS**

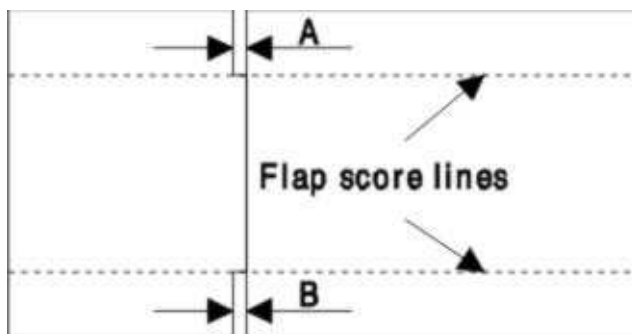
**I. Parameters of the packagings produced at the firm of ADAMS**

**1. Dimensional deviation**

Inconsistency of the internal dimensions to the dimensions indicated in the technological card of the Packaging	<ul style="list-style-type: none"> <li>- up to 100 mm - <math>\pm 1</math> mm</li> <li>- from 100 to 379 mm - <math>\pm 2</math> mm</li> <li>- from 380 to 570 mm - <math>\pm 3</math> mm</li> <li>- from 571 to 759 mm - <math>\pm 4</math> mm</li> <li>- from 760 to 1140 mm - <math>\pm 5</math> mm</li> </ul>
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**2. Deviation of the gap width at the glue joint:**

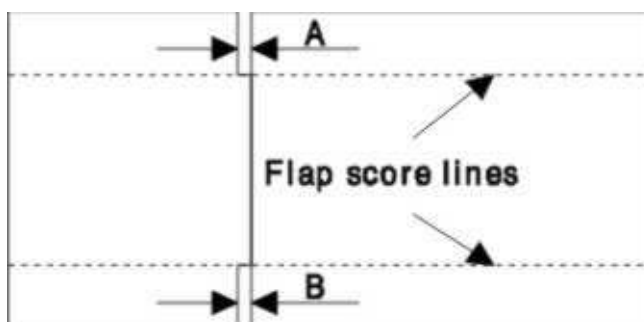
Cardboard , Corrugation	B	C	E	B/C
Allowed defectiveness level in a shipment	3%	3%	3%	3%
Maximum deviation between individual boxes. Mean value of dimensions A and B measured at the score lines	$\pm 4$ mm	$\pm 4,0$ mm	$\pm 2,0$ mm	$\pm 4,5$ mm



**3. Fishtail (max. difference between dimensions A and B):**

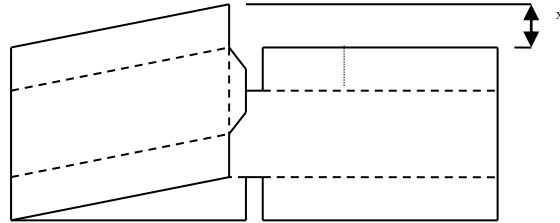
Box height	B, C, E	B/C
up to 400 mm	$\pm 4.0$ mm	$\pm 4.5$ mm
over 400 mm	$\pm 5.0$ mm	$\pm 5.5$ mm

Measured in individual boxes at the score lines - the allowed defectiveness level in a shipment: 3%.



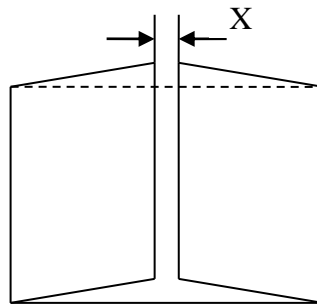
#### 4. Parallelism of glue joints

Offsetting of parallelism of glue joints of the packaging in relation to any two opposite but linking parts	$X < \pm 3 \text{ mm}$
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#### 5. Gap between the flaps

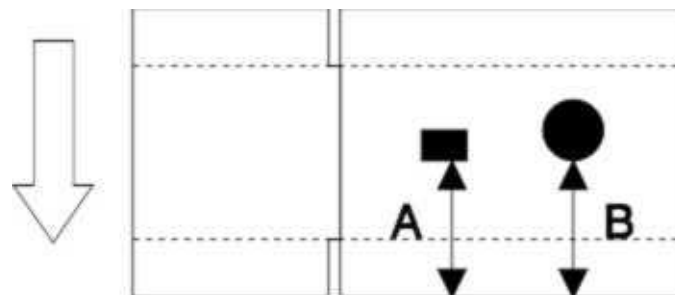
The gap which remains after closing the outside flaps in flap Packagings	$X < 4 \text{ mm}$ for Corrugation B, C, E $X < 6 \text{ mm}$ for Corrugation BC, BE
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#### 6. Adjustment of the overprints to one another

Maximum adjustment deviation between colours A-B - $\pm 2.5 \text{ mm}$
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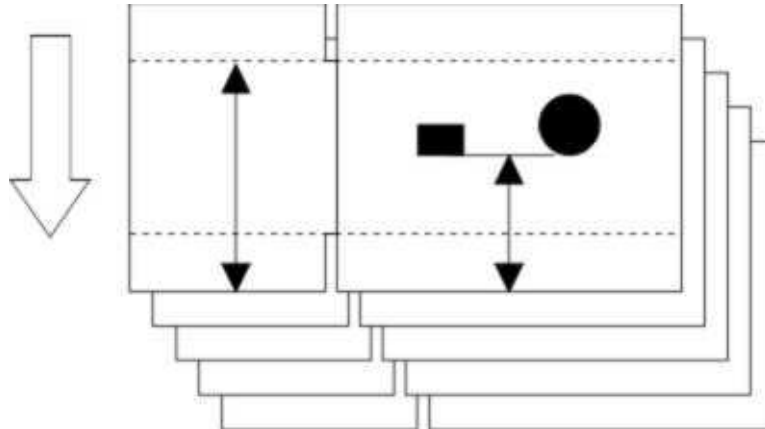
Measured in individual boxes to the leading edge of a sheet - the allowed defectiveness level in a shipment: 3%.



### 7. Adjustment of the overprints

Overprint adjustment tolerance in relation to the leading edge -  $\pm 3.5$  mm

Measured in individual boxes to the leading edge of a sheet - the allowed defectiveness level in a shipment: 3%.



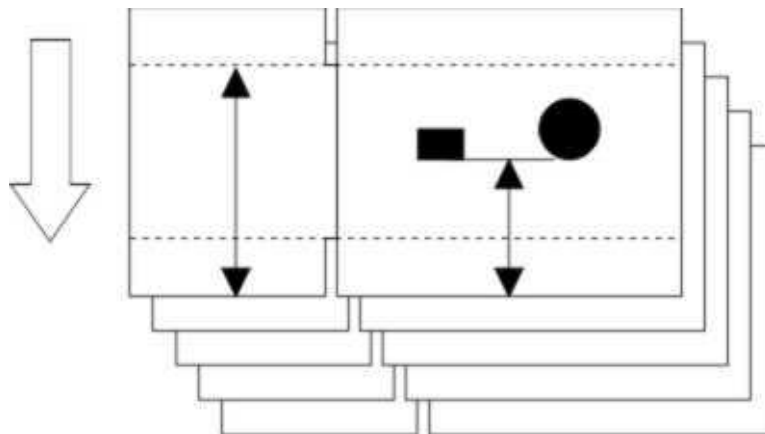
### 8. Colour deviation from the standard

Maximum deviation of a colour from the standard approved by the customer, measured with a spectrophotometer, shall amount to  $\Delta \leq 4$

### 9. Adjustment of cutouts

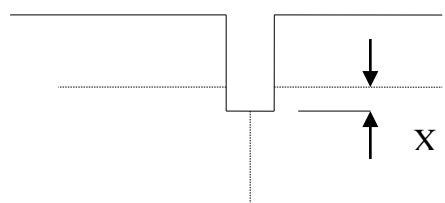
Rotary cutout adjustment tolerance in relation to the leading edge -  $\pm 2.0$  mm

Measured in individual boxes to the leading edge of a sheet - the allowed defectiveness level in a shipment: 3%.



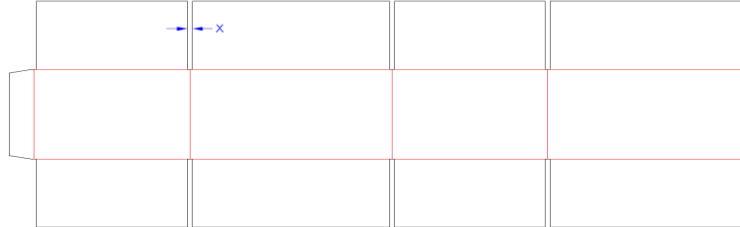
### 10. Slot depth

Depth of slotter knives penetration into the cardboard during production of flap packagings, measured from the bend	$X < + 3$ mm for corrugation E; $X < + 6$ mm for corrugations B and C $X < + 10$ mm for corrugations BC and BE
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**11. Slotter discard**

Dimension of the discard (cutting) from slotter knife operation:	8 mm ± 1.5 mm
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**12. Glued fla**

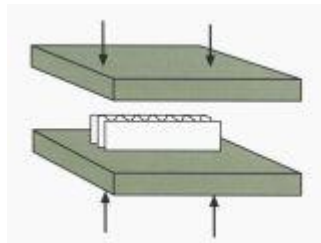
The minimum dimension of the glued flap shall be 25 mm

**13. Basis weight of raw material**

The basis weight [gsm] of raw material may differ from that indicated in the quotation by ±5% (expressed in g/m<sup>2</sup>)

**14. Resistance to edge crushing [ECT]**

The resistance to edge crushing may differ from that indicated in the quotation by ±10% (expressed in N/m)

**15. moisture content of the packagings**

The moisture content of packagings delivered to the customer shall remain within 6–9%.

**16. Quantitative deviation from the order for deliveries of one type of packaging**

up to 5000 pcs - ± 10%

5001 pcs - 10000 pcs - ± 7%

more than 10000 pcs - ± 5%

**17. Packing**

Packagings are normally stacked on EURO type returnable pallets of dimensions 1200\*800 up to the height of 2 m, bound with PP tape and protected with stretch type film. Different individual packing methods, agreed with the customer, are permitted.

**18. Labelling**

A packed pallet with Packagings is provided with a pallet label containing the following information:

- Customer name,
- Packaging code (+ barcode) and Packaging name,
- Supplier's order number,
- Customer's order number (+barcode)
- pallet number, date of production, work shift number and operator's login,
- quantity on the pallet (+barcode),
- Customer's code of the Packaging (+ barcode)

Number and location of the labels: 1 pce at the short side of the pallet or as agreed otherwise with the Customer

**19. Storage**

Packaging should be stored in well-ventilated warehouses in temperature from 5 to 30 °C and humidity from 30 to 70%. The daily/weekly fluctuations of temperature and humidity should be minimized.

Packaging should be stored: 1) on a pallet or a platform on a clean and dry surface; 2) protected against precipitation and sun light; 3) protected against dust; 4) in a condition that it was delivered – after using some of the packaging from a pallet, wrap the pallet back in foil and put back the straps; 5) avoid stacking pallets one on another; 6) keep all the identification documents until all the packaging from a batch have been used.

**20. Hazards**

Flammable product

**21. Instruction fo use**

Packaging can be in indirect contact with food

**22. Production place**

Packaging is produced in:

- A. 62-081 Przeźmierowo, ul. Nowina 20, and
- B. 62-080 Sady, ul. Za motelem 2

**23. Legal articles**

The packagings were designed for indirect contact with foodstuffs in accordance with current UE regulations.

- Ustawa o gospodarce opakowaniami i odpadami opakowaniowymi z dnia 13 czerwca 2013 roku (Dz. U. Nr 2013, poz. 888 z późn. zm.);
- Ustawa z dnia 12 grudnia 2003r o ogólnym bezpieczeństwie produktów(Dz. U. Nr 229 poz. 2275 z późn. zm.);
- Ustawa z dnia 25 sierpnia 2006 r. o bezpieczeństwie żywności i żywienia
- Rozporządzenie (WE) Nr 2023/2006 Komisji z dnia 22 grudnia 2006r. w sprawie dobrej praktyki produkcyjnej w odniesieniu do materiałów i wyrobów przeznaczonych do kontaktu z żywnością.
- Rozporządzenie Parlamentu Europejskiego i Rady (WE) Nr 1907/2006(REACH)
- Rozporządzenie ( WE) Nr 1935 /2004 Parlamentu Europejskiego i Rady z dnia 27 października 2004r. w sprawie materiałów i wyrobów przeznaczonych do kontaktu z żywnością oraz uchylające dyrektywy 80/590/EWG i 89/109/EWG.
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The articles above apply if the conditions of usage are normal and rationally predictable

#### **24. Palletization of packagings with products at Customer's plant**

The method of packing of readymade products, palletization and storage at Customer's plant shall be agreed with the Supplier to make it compliant with the quality parameters of the packagings from the quotation.

**Approved by Jacek Glowacki  
Quality Department Manager**