

PERFORMANCE SPECIFICATIONS OF PURCHASED PRODUCT

Product:	Aluminium Foil 1235-Fully Soft	Reference Number	ALF/01/01
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Sl. No	Parameter	Unit	Reference Standard	Standard Value	Tolerance
1	Application	-	-	Flexible Packaging. including Retort Packaging	-
2	Physical Appearance	-	-	Foil to be free from creases, wrinkles, folds, objectionable odour, sagging, oxidation marks, scratch marks, dust, physical contamination and stickiness	-
3	Width	mm	-	As per Purchase Order <i>OK</i>	+2, -0
4	Roll Weight	Kg	-	As per supplier's challan/packing slip <i>As per PO ± 10%</i>	+1, -0
5	Thickness	microns	<i>IS 15392: 2003</i>	As per the Purchase Order <i>± 8%</i>	± 5 %
6	GSM	-	-	Value as determined by considering the density as 2.70 for Al. Foil	Spot ± 5 % Avg. ± 3 %
7	Wettability	Dynes/cm.	ASTM D 5725	Both side 72 dyne/cm <i>72 dyne - width ≤ 1000mm 68 dyne - width ≥ 1000mm</i>	min.
8	Tensile Strength	kg/cm. Sq.	ASTM E 8	550 (For 6.5 to 9 micron thickness) <i>-OK</i> 650 (For above 9 micron thickness) <i>For above 18 mic</i>	min.
9	Elongation	%	ASTM E 8	1 % (For 6.5 to 9 micron thickness) <i>OK</i> 2 % (For above 9 micron thickness)	± 0.5
10	Alloy	-	ASTM B 479	AA 1235 <i>OK</i>	-
11	Temper	-	-	'o' (fully Soft) <i>OK</i>	-
12	Finish	-	-	Inside dull, outside bright <i>B50 - OK</i>	-
13	Pin Holes	(Nos./ Sq. meter)	ASTM B 926 <i>IS 15392: 2003</i>	600 (For 6.5 and 7.0 micron thickness) 100 (For 9 micron thickness) <i>-200</i> 50 (For 12 micron thickness) <i>-OK</i> 10 (For above 12 micron and upto 18 micron thickness) <i>25 micron - 5 20 micron - 10</i> 0 (For above 18 micron thickness) <i>30,40 micron - 0</i>	max.
14	Number of Joints	-	-	For a lot, 15% of the rolls may have 1 joint, 5% of the rolls may have 2 joints and balance 85% of the rolls to be free of joints. Joints to be welded ultrasonically and identified with red flaps	<i>OK</i>
15	Roll Diameter	mm	-	450 <i>OK</i> (Rolls of below 450 are acceptable only when required to make the quantity as per the purchase order)	+ 50
16	Core ID	mm	-	152 <i>OK</i>	± 1
17	Identification Label	-	-	Label to carry the following information: Product Description, Size, Roll Number, Gross and Net Weights, Length in Meters, Number of Joints, Date of Manufacturing , Date of Expiry/Shelf Life and Name and Address of the supplier <i>OK</i>	-
18	Packing Instructions	-	-	Aluminium core to be used with plastic core plugs inserted at both ends of the core. Primary packing of the roll to be protective plastic wrapping and bubble wrapping. The rolls to be packed in wooden box. Wooden boxes to be free of cracks and borers without any protruding nails and wood chips.	<i>wooden plugs inserted OK</i>
19	Transportation	-	-	Vehicle to be clean and free of any undesirable odour. No other material to be loaded in the vehicle which may cause physical damage or contamination. The vehicle to be securely covered with tarpaulin on top to protect the material from rain water and dust. The mode of loading of pallets to be suitable for unloading at destination by forklift truck/overhead travelling hoist	<i>OK</i>

Prepared By:

Approved By:

Signature
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