

## QC SPECIFICATION FOR ZIPPER BAG

**Date** : 20/06/2022

**Customer** : All

**Description** : LDPE reclosable zipperbag

**Thickness** : 0.050 mm

| Checking point                         |                            | Testing method  | Range                                     | SPEC.                                |
|--|----------------------------|---|---|--------------------------------------|
| Dimension (mm)                         | Width /Length              | Ruler   | 50-130                                    | ± 3                                  |
|  | Thickness                  | Dial gauge  | upper 131                                 | ± 5                                  |
| Zipper strength (kgf)                  | Outside                    | Push -Pull gauge  | Zipper thickness 1.20 mm                  | 0.5-1.0 kgs/cm <sup>2</sup>          |
|  | Inside                     |   |   | ≥1.8 kgs/cm <sup>2</sup>             |
| Bottom strength                        |                            | Drop steel 150 grams shake 3 tims                         | 0.10 (2 page)                             | No tear "Passed"                     |
| Seal strength                          | Testing by Tensile M/C (N) | Testing by LLOYD Tensile testing machine speed 500 mm/min | left and right Side                       | Lip : 8-10                           |
|  | Testing by manual          | Pull along side seal left and right side                  |   | Bag : 10-15                          |
| Tensile strength (N/mm <sup>2</sup> )  |                            | Testing by LLOYD Tensile testing machine speed 500 mm/min | TD  | 8-10                                 |
| % Elongation (%)                       |                            |   | sample size 20x100 mm gripper space 50 mm | MD                                   |
| Freezer test (for freezer zipper bag ) |                            | Put zipper bag into refrigerator at -8 ± 2 °C             | TD  | 150-400                              |
| Printing                               |                            |   | MD  | 100-200                              |
| Printing                               | Color                      | Sample approved / Pantone                                 | 0.10 (2 page)                             | No crack and good zipper is "Passed" |
|  | Printing position          | Sample approved / Art eork                                | Up to customer                            | MAX-MIN                              |
|  | Apperance                  | visual /spec max-min                                      | Up to customer                            | ± 5                                  |
| Packing                                |                            | Counting  | Up to customer                            | No blur/within limited               |
|  |                            |   | Up to customer                            | Up to customer                       |

