



STANDARD SPECIFICATIONS

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ISO 9001:2015

BUREAU VERITAS
Certification



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1. INTRODUCTION

These Specifications define commitments and practices in terms of quality by COVERPLA Company. They therefore constitute a general framework which allows both parties to agree on the quality level as well as on control methods implemented to achieve this quality level.

These Specifications therefore define the minimum quality acceptable by the client and constitute the standard reference applicable (in case there are no specific specification).

2. SCOPE

These Specifications apply to all products and/or services.

3. TERMS AND CONDITIONS

3.1. Liability

COVERPLA Company is liable for any defects exceeding AQLs upon delivery to its client.

This liability does in no way relieve the client of his own liability when he releases his batches in order to put them on the market.

3.2. Agreement

These Specifications, which were signed by both parties, are considered as mutually agreed and represent our basis of work in terms of quality.

These Specifications can be possibly renegotiated on the initiative of either party. This renegotiation will have to be agreed again by both parties.

These Specifications may also be amended from time to time by COVERPLA. Any amendment shall result in an update of the document and this new version will then be submitted to the client for approval.

3.3. Audits

The two parties may agree to undertake audits:

- ✓ Audits carried out by the Quality Management System's client of COVERPLA,
- ✓ Audit carried out by COVERPLA of the supplier's Quality Management System,
- ✓ COVERPLA may audit the client in case it should be necessary to get information about the conditions of use of the product(s).

4. STORAGE

The products are stored on pallets or shelves in cardboard boxes in clean and dry places. It is highly recommended to respect these transport and warehousing conditions in order to make sure their characteristics are not affected. Any deviation may cause a negative effect on the latters.

- Sprayers : 5°C to 40°C
- Surlyn => maximum 50° C
- Plastic PP, PET, etc... => maximum 45°C

Note : as for glass bottles, beyond a six-month storage period from their manufacturing date, the appearance of exudation is a normal phenomenon linked with the composition of glass, without any risk of reaction with the product filled, and is not considered as a defect.

5. PACKAGING AND IDENTIFICATION OF PRODUCTS

5.1. « Stock items »

All products that do not require any operations in COVERPLA, are submitted to standard packing and labelling conditions provided by our producing factories and/or suppliers.

5.2. Special Order Items

5.2.1. Labelling

All special order items (specific colour of closure, decoration, assembling of pumps...) are identified by a box label indicating :

- ✓ Customer item ref and description
- ✓ Batch number
- ✓ The quantity per box,
- ✓ The manufacturing date,
- ✓ The client's name,
- ✓ The order number (on customer's request),
- ✓ The client reference number (on the customer's request).

A pallet label showing same information as per described in the box labels can be applied on request on the pallets (cf Appendix 7).

5.2.2. Packing

Trading items are re-packed with factory standard mode.

Products are packed in dedicated conditions to secure product integrity during transport and storage.

6. CHECKING PROCESS

6.1. Check upon Reception

The goods delivered to COVERPLA are submitted to check upon receipt through statistical sampling (based on the ISO 2859-1 standard) only for goods coming from suppliers who do not work according to quality assurance criteria ("QA"). (Cf. § 7).

However, random checks or quality controls can be operated to products under QA, in order to double check QA status conformance.

6.2. Check at the beginning of production

The start of our productions is submitted to a specific check in order to validate the implementation of production.

6.3. Check during production

Checks are continuously carried out during production. These checks are of an aesthetic and/or functional nature depending on the item's specifications. (Cf. §8).

6.4. Check before shipping

Upon customer's request, a statistical control before departure could be done according to financial modalities below:

Size of the lot to be checked	Sampling	Prize in Euros
501 to 1 200	80	120,00 €
1 201 to 3 000	125	140,00 €
3 001 to 10 000	200	170,00 €
10 001 to 35 000	315	200,00 €
35 001 to 150 000	500	240,00 €
150 001 to 500 000	800	300,00 €
≥ 500 001	1 250	350,00 €

7. STATISTICAL CONTROL

7.1. Introduction

The controls of the products which are subjected to it are carried out:

- ✓ On the basis of a wide range of defects available in-house for COVERPLA specific items,
- ✓ On the basis of suppliers' referenced systems for standard items.

Defects are assessed according to a method commonly used in our profession, i.e. according to their visual appearance and at arm's length during few seconds.

Quality samples checked are kept during a period of 2 years described as current year and the year before. After that time, samples are thrown away.

7.2. Sampling Plan and Procedure

The sampling plan used for statistical control aims to ensure the representativeness of the controlled lot.

A lot is a set of same products received by the customer at once. Control at reception must be operated by the customer for each reference, on the entire delivery (a lot cannot be splitted into several "part-lots").

The sampling taking procedure is randomly carried out at various points of the batch in a number of packages equal to the square root of the total number of packages included in the batch to be controlled (rounded up to the nearest pack size).

The control is carried out according to the sampling of the ISO 2859-1 Standard.

The control plans used are:

- ✓ As a level II simple & normal procedure for most of products,
- ✓ As a level II reduced & simple procedure for some products enjoying a favourable history (i.e. products for which no complaints and/or problems have arisen in-house for some time),
- ✓ As a level S3 simple & normal procedure for technical controls and destructive controls.

7.3. Acceptable Quality Levels (AOLs)

The AQL (NQA - *Niveau de Qualité Acceptable* – in French) is defined for each defect class. The AQL represents +/- percentage of defects which can be considered acceptable as an average characteristic of a controlled batch quality.

7.4. Quality levels for glass items

Three quality levels exist for our glass bottles: “Upgraded quality”, “Masstige” and “Mass Market”. The difference could be made by:

- ✓ the AQL for minor defects which could correspond to 4 for “Upgraded quality”, to 4 or 6.5 for “Masstige” and “Mass Market”,
- ✓ the aspect defects which are automatically considered as minor for “Masstige” and “Mass Market” whereas they could be considered as minor or major for “Upgraded quality”,
- ✓ the “OK Limit” from “Upgraded quality” might also be more restrictive than for the “Mass Market” and “Masstige”.

7.5. Defects and Associated AOLs

Super Critical defect – AQL = 0.10

These are defects that might cause any risks of danger for standard use.

Critical defect – AQL = 0.65

These are defects that may cause serious issues during filling process.

Major Defect – AQL = 1.5

Although non-critical, this defect may reduce the performance of the filling line but that does not mean that it can have notable effects on the use of the product by the user or that this defect interferes with the normal use of the item and harms the company’s brand image.

Minor Defect – AQL = 4 or 6.5

This defect does not interfere with the normal use of the product but spoils its presentation (appearance defects).

A list of these various defects and associate AQL is provided in Appendix 1 for glass bottles and jars, in Appendix 2 for plastic bottles and jars, in Appendix 3 for closing accessories and in Appendix 4 for silkscreen printing and in Appendix 5 for pumps.

7.6. Acceptability and Refusal Criteria

Sampling plans and acceptability limits are defined in the table from ISO 2859-1 standards :

Normal Control – Level II

Pack Size N	Sampling n	Super Critical defect		Critical Defect		Major Defect		Minor Defect			
		AQL = 0.10		AQL = 0.65		AQL = 1.5		AQL = 4		AQL = 6.5	
		A	R	A	R	A	R	A	R	A	R
151 à 280	G 32	0	1	0	1	1	2	3	4	5	6
281 à 500	H 50	0	1	1	2	2	3	5	6	7	8
501 à 1200	J 80	0	1	1	2	3	4	7	8	10	11
1201 à 3200	K 125	0	1	2	3	5	6	10	11	14	15
3201 à 10000	L 200	0	1	3	4	7	8	14	15	21	22
10001 à 35000	M 315	1	2	5	6	10	11	21	22	21	22
35001 à 150000	N 500	1	2	7	8	14	15	21	22	21	22
150001 à 500000	P 800	2	3	10	11	21	22	21	22	21	22
≥ à 500001	Q 1250	3	4	14	15	21	22	21	22	21	22

Table 1: Acceptability and Refusal Criteria with Normal Control – Level II

Reduced Control – Level II

Pack Size N	Sampling n	Super Critical defect		Critical Defect		Major Defect		Minor Defect			
		AQL = 0.10		AQL = 0.65		AQL = 1.5		AQL = 4		AQL = 6.5	
		A	R	A	R	A	R	A	R	A	R
151 à 280	G 13	0	1	0	1	1	2	2	3	3	4
281 à 500	H 20	0	1	1	2	1	2	3	4	5	6
501 à 1200	J 32	0	1	1	2	2	3	5	6	6	7
1201 à 3200	K 50	0	1	1	2	3	4	6	7	8	9
3201 à 10000	L 80	0	1	2	3	5	6	8	9	10	11
10001 à 35000	M 125	1	2	3	4	6	7	10	11	10	11
35001 à 150000	N 200	1	2	5	6	8	9	10	11	10	11
150001 à 500000	P 315	1	2	6	7	10	11	10	11	10	11
≥ à 500001	Q 500	2	3	8	9	10	11	10	11	10	11

Table 2: Acceptability and Refusal Criteria with Reduced Control – Level II

Normal Control – Level S3

Pack Size N	Sampling n	Super Critical defect		Critical Defect		Major Defect		Minor Defect			
		AQL = 0.10		AQL = 0.65		AQL = 1.5		AQL = 4		AQL = 6.5	
		A	R	A	R	A	R	A	R	A	R
151 à 280	D 8	0	1	0	1	0	1	1	2	1	2
281 à 500	D 8	0	1	0	1	0	1	1	2	1	2
501 à 1200	E 13	0	1	0	1	0	1	1	2	2	3
1201 à 3200	E 13	0	1	0	1	0	1	1	2	2	3
3201 à 10000	F 20	0	1	0	1	1	2	2	3	3	4
10001 à 35000	F 20	0	1	0	1	1	2	2	3	3	4
35001 à 150000	G 32	0	1	0	1	1	2	3	4	5	6
150001 à 500000	G 32	0	1	0	1	1	2	3	4	5	6
≥ à 500001	H 50	0	1	1	2	2	3	5	6	7	8

Table 3: Acceptability and Refusal Criteria with Normal Control – Level S3

8. ITEMS / SERVICES AND ASSOCIATED CONTROLS

It is best to first define two types of tests:

- ✓ Homologation tests are used to check the compatibility of the container/content. These tests are to be performed by the customer with the printed samples sent for approval and the final bulk.
- ✓ Compliance tests performed by COVERPLA (as described here under) and/or the supplier upon receipt of goods or during production, and by the customer upon receipt of goods in order to make sure about conformity of a batch number. Only provided check results as per described conditions can be taken into consideration by COVERPLA in order to status about acceptance or rejection of a batch upon receipt of goods.

8.1. Stock items and trading services

(Cf 6.1)

8.1.1. Visual control

An inspection is done in comparison to the defect range board, any colour panoply and the supplier's specification.

8.1.2. Lacquering adhesion test

Test to be done:

- ✓ Tape test

Cf. Appendix 6.

8.2. Ceramic/organic silkscreening, hot stamping and pad printing

8.2.1. Visual control

A visual control is done during production at a set frequency to check the following points:

- ✓ Deco Defects,
- ✓ Positioning,
- ✓ Skew/Shift,
- ✓ Colour.

8.2.2. Adhesion control

A deco adhesion dry inspection is done during production at a set frequency and according to 3 tests:

- ✓ Friction test,
- ✓ Scotch test,
- ✓ Water testing

These 3 tests are described in Appendix 6.

8.3. Injection

8.3.1. Visual control

A visual control is done during production at a set frequency to check the following points:

- ✓ Molding Defects, Cf. Appendix 3
- ✓ Dimensions
- ✓ Colour.

8.3.2. Functional control

A sampling is processed according to a defined period of time to check about fitting (manual methode : 24 hours after injection).

8.4. Pump assembly and semi automatic tube cutting process

Tube length is a standard measurement. We cannot be responsible for any problems occurring when cutting tubes by another operator than COVERPLA.

8.4.1. Visual control

A visual control is done during production at a set frequency to check the following points:

- ✓ Visual defects,
- ✓ Digtube length,
- ✓ Color

Cf. Appendix 5.

Digtube tolerances:

- ✓ Length under 50 mm: +/-0.5 mm
- ✓ 51 to 100 mm length: +/-1 mm
- ✓ 101 to 150 mm length: +/-1.5 mm
- ✓ Length over 151 mm: +/-2 mm

8.4.2. Functional control

A spray control is processed during and at the end of a production according to a pre –defined time period (10 sprays with water are processed, i.e. one spray per second).

8.4.3. Leaking test

A leaking test can be operated on pumps periodically and/or in case of any discordance between parties according the following modus operandi:

- ✓ Material : vacuum chamber,
- ✓ Place absorbant paper inside the device,
- ✓ Place all components laid down, crimped pump on filled bottles (fragrance or colored water),
- ✓ Empty the air : 250 mbar during 5mn,
- ✓ During or after the cycle, if the absorbant paper is wet, the product is considered as not conformed.

8.5. Caps assembly

During production and at the end of production, visual aspect and assembly fitting are processed, according a defined periodicity. Cf Appendix 3.

9. LIMITED RESPONSIBILITY OF COVERPLA

9.1. Check upon Reception by the Client

9.1.1. Acceptance

The batches which comply with the minimum quality level specified in these Specifications are accepted.

However, if the number of defective items is closed to the refusal limit, the client may, at his discretion, give notice of these defects by sending COVERPLA Company “quality remarks”.

If the number of defective items is higher than the acceptance limit and if the client considers that the checked batch can be nonetheless used, the client may accept the batch with reservations and shall give written notice of these reservations to COVERPLA Company which shall give a decision on its responsibility. In case a batch is accepted with reservations and the client fails to give notice of these reservations to COVERPLA, the latter shall relieve itself of any responsibility in case of problems.

9.1.2. Refusal

In case any batch fails to comply with the minimum quality level specified in these Specifications, this batch shall be refused and a complaint shall be sent to COVERPLA Company.

However, in case COVERPLA accepts the complaint, two cases may arise as follows:

- ✓ Either making the products comply with the aforementioned standards on site on the client's initiative. However, this requires prior estimate to be made out as well as written acceptance of this estimate by COVERPLA Company. Once this process has been completed, the defective products shall be made available to COVERPLA and the invoice (request for payment) shall be sent.
- ✓ Or replacing the defective batch at COVERPLA's expense (as quickly as possible).

In case COVERPLA delivers the goods to a principal on behalf of a client (filler...) the implementation of production of the items by the principal shall be considered as an acceptance of the goods on behalf of the client (no claim can be taken into consideration by COVERPLA once filling process has started).

Please note that we must be notified of any defects within 30 days of goods receipt. After 1 month, the batch is considered as accepted by customer.

9.2. Complaint

To consider a quality claim, the here-under elements are required (mandatory):

- ✓ Statistical control sheet upon receipt of the goods (according to ISO 2859-1 standards)
- ✓ Quantity or percentage of rejected products
- ✓ Representative samples of each defect found (minimum of 10 to 15 units)
- ✓ Pallet and/or box label
- ✓ Batch number for defect found
- ✓ Item number
- ✓ Order number
- ✓ Quantity of delivered batch
- ✓ Full description of each defect found and its consequence(s)
- ✓ Place where the defect(s) was identified (filling place, printing place etc...).

In case of dispute, COVERPLA's responsibility will exclusively be limited to delivered goods and will not cover any additional costs referring to decoration, filling, extra packing, or any other charges. Only previously accepted costs by COVERPLA will be considered.

9.3. Liability Exclusion

Customer must:

- ✓ make sure about compatibility between supplied goods/services and the fragrance/product to be,
- ✓ make sure about compatibility between supplied goods/services with the eventual special treatments, operations or handling to be done after receipt.

We strongly recommend to pre-clean/strip the glass before any lacquering, coating operation with any light and/or translucent colours (on customer duty if COVERPLA is not operating the lacquering/coating service). Our responsibility will not be engaged in case of any defect concerning these lacquering/coating, caused by an incompatibility between the container and the filled product. Our responsibility is limited to the mentioned tests on paragraph 8

APPENDIX 1 : GLASS DEFECTS

DEFECTS	Classification	AQL
Spike	C (or SC*)	0,65 (or 0,10)
Halo	m	4 (or 6,5)
Finish distortion affecting seal	C	0,65
Overpress neck finish/ Neck parting line	M	1,5
Blister	m	4 (or 6,5)
Broken blister	M	1,5
Oil blister	m	4 (or 6,5)
Capacity out of tolerance	C	0,65
Broken	C (or SC*)	0,65 (or 0,10)
Cords	m	4 (or 6,5)
Internal foreign bodies	C (or SC*)	0,65 (or 0,10)
Mold seam	m	4 (or 6,5)
Glass piece inside	C (or SC*)	0,65 (or 0,10)
Out of tolerance dimension	C	0,65
Chipped	M	1,5
Wrong bottle	C	0,65
Wrong reference / item	C	0,65
Blank	m	4 (or 6,5)
Blank seam	m	4 (or 6,5)
Wrinkle	m	4 (or 6,5)
Scratches	m	4 (or 6,5)
Breakage	M	1,5
Wavycords	m	4 (or 6,5)
Orange peel	m	4 (or 6,5)
Laps	m	4 (or 6,5)
Bad distribution of glass	m	4 (or 6,5)
Bottom distribution of glass	m	4 (or 6,5)
Stains	m	4 (or 6,5)
Bird swing	C (or SC*)	0,65 (or 0,10)

Non exhaustive list

m = minor M = Major C = Critical (*SC= Supercritical (according to the items)). Minor defects are determined in accordance with the acceptable limit of the glass manufacturer. All defects have to be considered at arm's length.

Dust, inside box particles... are not considered as defects. We cannot guarantee no dust.

Containers may be subject to risk from natural variations in raw materials. The colour tone of the containers may vary according to the characteristics of the raw materials used. The glassmakers does not guarantee the absolute constancy of the color tone of the products. The glassmakers undertakes to ensure that the glass color of the containers is within the reglementations and the specifications defined.

APPENDIX 2 : PLASTIC DEFECTS

DEFECTS	Classification	AQL
Crooked neck >5°	M	1,5
Scallops	m	4 (or 6,5)
Sharp edges	C	0,65
Overpressed neck finish = uneasy screwing > 0,15 mm	M	1,5
Bubble > 3 mm	m	4 (or 6,5)
Blocked neck	C	0,65
Non-observance of functional dimensions	M	1,5
Non-observance of functional dimensions = leakage	C	0,65
Shock	m	4 (or 6,5)
Body distortion/bottom	m	4 (or 6,5)
Mixture of bottles	C	0,65
Laps/Threads > 1,5 cm	m	4 (or 6,5)
Black points > 1 mm	m	4 (or 6,5)
Colour outside agreed tolerances	M	1,5
Scuffs, scratches > 1,5 cm	m	4 (or 6,5)
Leaker	C	0,65

Non exhaustive list

m = minor M = Major C = Critical

Minor defects are determined in accordance with the acceptable limit of the glass manufacturer.

All defects have to be considered at arm's length.

The magnifying effect, orange peel effect and material extra thickness reflect, cannot be considered as defects for plastic bottles.

Dust, inside box particles,... are not considered as defects. We cannot guarantee no dust.

APPENDIX 3 : CLOSING ACCESSORIES DEFECTS

DEFECTS	Classification	AQL
Thread or overcap missing	M	1,5
Thread or overcap missing = dysfunction	C	0,65
Missing gasket	M	1,5
Missing gasket = leakages	C	0,65
Injection point smudge	m	4 (or 6,5)
Scallops	m	4 (or 6,5)
Shock	m	4 (or 6,5)
Visible esthetics defects (scatch, bubble, fold, black points...)	m	4 (or 6,5)
Gasket defect = leakages or dysfunction	C	0,65
Gross distortion	M	1,5
Shrinkage	m	4 (or 6,5)
Out of tolerance dimension	M	1,5
Non-compliant raw material, colour	C	0,65
Incomplete thread that does not cause leakage	M	1,5
Incomplete thread that causes leakage	C	0,65
Crack	m	4 (or 6,5)
Inside dirt, marks	m	4 (or 6,5)
Raw material impurity	m	4 (or 6,5)
Incorrectly positioned inner	m	4 (or 6,5)
Missing inner	M	1,5
Lack of material	m	4 (or 6,5)
Lack of Material non functional	M	1,5
Lack of material that causes leakage	C	0,65
Mix raw material, colorant	C	0,65
Mix up of different article	C	0,65
Injection gate > 1 mm	m	4 (or 6,5)
Stung	m	4 (or 6,5)
Color out of tolerance	M	1,5

Non exhaustive list

m = minor M = Major C = Critical

Minor defects are determined in accordance with the acceptable limit of the glass manufacturer.

All defects have to be considered at arm's length.

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Dust, inside box particles, ... are not considered as defects. We cannot guarantee no dust.

APPENDIX 4 : EXTRA FINISHING DEFECTS

DEFECTS	Classification	AQL
Letter and / or text smudge	m	4 (or 6,5)
Excess of lacquering	m	4 (or 6,5)
Height shift \geq 1 mm	m	4 (or 6,5)
Lateral shift \geq 1 mm	m	4 (or 6,5)
Cracked decoration	m	4 (or 6,5)
Distorted decoration	m	4 (or 6,5)
Incorrect colour	M	1,5
Incorrect artwork	C	0,65
Decorated support error	C	0,65
Partial decoration absence (excluding legal notices)	m	4 (or 6,5)
Partial polish/ etching or frosting / lacquering	m	4 (or 6,5)
Bad letter greasing	m	4 (or 6,5)
Bad deco position between recto/verso	M	1,5
Poor deco adhesion	C	0,65
Mixture of printed bottles	M	1,5
Dust/Stain/Plush	m	4 (or 6,5)
Scratch/Buckle	m	4 (or 6,5)
Undecorated support	C	0,65
Color outside agreed tolerances	M	1,5
Blurred text / Slurred	m	4 (or 6,5)
Legal text illegible or incomplete	C	0,65
Carpet marks	m	4 (or 6,5)

Non exhaustive list

m = minor M = Major C = Critical

Minor defects are determined in accordance with the acceptable limit of the glass manufacturer.

All defects have to be considered at arm's length.

The magnifying effect, orange peel effect and material extra thickness reflect, cannot be considered as defects for plastic bottles.

Dust, inside box particles... are not considered as defects. We cannot guarantee no dust.

APPENDIX 5 : PUMP DEFECTS

DEFECTS	Classification	AQL
More gaskets as specified (double gasket)	C	0,65
Missing components / no function	C	0,65
Dip tube curvature out of tolerance	m	4 (or 6,5)
Defects of components wich cause miss-function	C	0,65
Defects of components wich do not cause miss-function	m	4 (or 6,5)
Aesthetic defects noticeable within a distance of > 60 cm (scratches, bubbles, incorrect anodizing...)	M	1,5
Aesthetic defects noticeable within a distance of ≤ 60 cm (scratches, bubbles, incorrect anodizing...)	m	4 (or 6,5)
Visual defects on gaskets that cause leakages or mis-function	C	0,65
Deformation of mounting cup / valve-fixture	C	0,65
Wrong function such as continuous sprayer, side spraying	C	0,65
Dosage out of tolerance	M	1,5
Colour-deviation, varying intensity/transparency of colour exceeding specified limits)	m	4 (or 6,5)
Shape and/or no thread	C	0,65
No function and/or leakages, e.g. due to wrong assembly of components or defects on components	C	0,65
Oil, fat, loose material residues... gets not into the contents/product	m	4 (or 6,5)
Oil, fat, loose material residues... gets into the contents/product	M	1,5
Insects, hairs, germs on valves, pumps, etc. - gets not into the contents/product	M	1,5
Insects, hairs, germs on valves, pumps, etc. - gets into the contents/product	C	0,65
Valve-stem not fully centred	C	0,65
Tolerance diptube out of tolerance	M	1,5
Marks, spots or inclusions inside/within the material ($\varnothing > 1$ mm)	M	1,5
Marks, spots or inclusions inside/within the material ($\varnothing \leq 1$ mm)	m	4 (or 6,5)
Bad retention of gasket in mounting cup	C	0,65
Mix of units / references / shipping boxes	C	0,65
Nombre de coups à amorcer non selon spécification	M	1,5
Scratches on mounting cup causing leakages	C	0,65
Dip tube retention out of tolerance	M	1,5
Valve-stem cracked	C	0,65
Missing or incomplete side hole	C	0,65
Missing side hole in valve-stem, stem is blocked	C	0,65
Dip tube squeezed causing "no function"	C	0,65
Loose or missing dip tubes	C	0,65

Non exhaustive list

m = minor M = Major C = Critical

Minor defects are determined in accordance with the acceptable limit of the glass manufacturer. All defects have to be considered at arm's length. The magnifying effect, orange peel effect and material extra thickness reflect, cannot be considered as defects for plastic bottles. Dust, inside box particles, ... are not considered as defects. We cannot guarantee no dust.

APPENDIX 6: SPECIAL FINISHING HOLDING CONTROL

I. LACQUERING AND METALLIZATION

SCOTCH TEST:

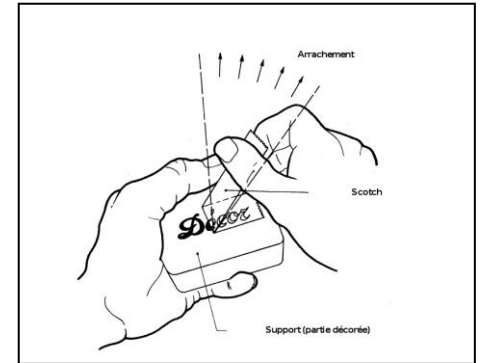
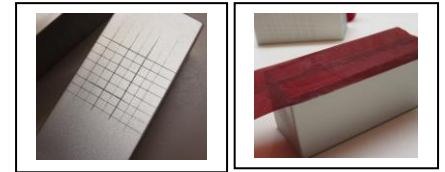
a) Material :

- Adhesive tape 3M - ref# 616
- Cutter

b) Procedure:

- Using the cutter, make a crosshatch.
- Apply the adhesive tape to the crosshatch surface while strongly pressing with your finger to ensure a good contact of the tape on the crosshatch.

- Wait one minute and then quickly tear off the adhesive tape without jolt at an approximate angle of 45 to 90°



c) Results:

Compare results to the chart below

Evaluation marks	Surface aspect after test
5	Rien
4	
3	
2	
1	
0	> 65%

Results are positive if marks are equal or superior to 3, that corresponds to a full square tearing.

II. CERAMIC and ORGANIC INK PRINTING, HOT STAMPING AND PAD PRINTING :

N.B : FOR ANY ORGANIC INK, HOT STAMPING OR PAD PRINTING, THESE TESTS ARE TO BE DONE 24 HOURS AFTER PRODUCTION.

FRICTION TEST:

a) Modus operandi :

- Slightly rub printed surface with thumb. No lack of print should be seen.
- Slightly rub 2 items one against the other. No lack of print should be seen.
- Slightly rub with carton box. No lack of print should be seen.

b) Results interpretation :

A slight removal of the print will not be considered as a defect, at the condition that text remains visible and can be read properly.

Sketching is not considered as a defect.

SCOTCH TEST :

a) Material :

Adhesive tape 3M - ref# 616

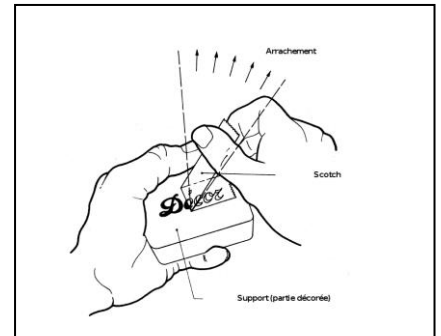
b) Procedure :

- Apply the adhesive tape to the crosshatch surface while strongly pressing with your finger to ensure a good contact of the tape on the crosshatch,

- Wait one minute and then quickly tear off the adhesive tape without jolt at an approximate angle of 45 to 90.

c) Results interpretation :

A slight removal of the print will not be considered as a defect, at the condition that text remains visible and can be read properly.



WATER TEST :

a) Material to be used:

- Glass beaker or any other container

b) Modus operandi :

- Immerse the printed item into water for 24 hours +/- 1 hour,
- Withdraw the item and slightly rub with a finger.


For testing stopping accessories such as cap, stoppers, sprayers etc.... the test duration is 1 hour +/- 15 minutes instead of 24hours +/- 1 hour.

c) Results interpretation

A slight removal of the print will not be considered as a defect, at the condition that text remains visible and can be read properly.

APPENDIX 7: PALLET LABEL OR BOX LABEL

<p>COVERPLA 301 bd de l'observatoire packaging parfumerie 06300 Nice +33(0)493767810</p>	
Client / Customer	
<p>73 ROUTE DE CANNES 06131 GRASSE CEDEX FR</p>	
Ref. Coverpla / Coverpla ref.	
361000	
CAPOT ISEO C/PPE 15 ZAMAC OR BRILLANT	
Ref. client / Customer ref.	
N° commande Coverpla / Coverpla Order	N° commande Client / Customer Order
N° palette / Palet Nb	Date / Date
1 / 1	21/04/2021
Nb de pièces / Nb of pieces	Nb de cartons / Nb of boxes
0,00 /pal	1/pal
N° lot / Batch number	Poids/Weight (kg)
Complément / Additional text	

<p>COVERPLA packaging parfumerie</p>	Date :
<p>361000 </p> <p>CAPOT ISEO C/PPE 15 ZAMAC OR BRILLANT</p> <p>Customer Ref :</p>	
<p>Longueur tube :</p> <p>Customer :</p> <p>Order N° : /</p>	<p>Batch N° :</p>
Quantity :	Box : 1 / 1 Visa :