

		Technical Department of Packaging TECHNICAL SPECIFICATION AQL CLOSURE
TYPE OF DEFECT	AQL	DEFECT
Critical	0,1	Rests of blow moulding castings Any breakage or tear on the surface edges that may eventually harm the user Cuts, cracks, breakages or tears Excess of process additives (i.e. demoulders) that can eventually impede a final proper labelling or silk screening Strange shape, not according to the bottle design Caps or lids with improper finish, lack of material or simply not filled out. In case of disk-top caps: open of bad assembled plug In case of flip top caps: broken, partially broken or deformed hinge In case of caps (or lids) purchased to be used with containers coming from the standard range of a supplier: leakiness test no OK In case of caps made up of two or more pieces: bad assembling affecting functionality Lack of liner (when it is required on the technical specification) Non specified finish Wrong color Wrong decoration colors (when required) Wrong color for the metal overshell (when required)
Major A	1	Off specification dimensions (height, diameter, etc.) Off specification neck dimensions Off specification wall thickness Off specification wheight Thread badly finished, causing friction while screwing and a plastic britteling (plastic particles come off) Deformed thread Neck and body with very visible seams Unproper material distribution Bad adhesiveness of the overmoulded piece (when required) Off specification liner thickness Unproperly assembled liner, broken liner or liner that tends to fall from its correct position Delaminated or torn liner In case of caps made up of two or more pieces: play or movement in between the pieces, in axial or rotational direction. In case of caps or lids with metal overshell: corrosion of decolouring In case of caps or lids with metal overshell: warps, dents or plies. In case of caps or lids with metal overshell: lack of protective varnish (there where is needed according to specification) Unproperly assembled metal overshell or metal overshell that tends to fall from its correct position Incorrect decoration, lack of ink, unreadability or printing breakage
Major B	2,5	Uneven surface, rugosity, spots or flecks Presence of scratches or scuffings Surface unproper definition after the manufacturing process Panneling Unproper masterbatch scattering In case of transparent or translucent bottles: blurry, unclear material In case of plastic pieces: embedded foreign matter incorporated during manufacturing process Dust, hair, foreign bodies or particles spread on the jar surface Breakage or lack of decoration Out of register affecting the inks of the decoration Breakage or lack of foil Faded decoration Overload decoration Rests of the adhesive used for the metal overshell assembling Failure of the Scotch 508 test Failure of the resistance to the product abrasion Failure of the resistance to the abrasion when the bottle is rubbed on other surface
Minor	4	Cap or lid deviation comparing to the color card approved Hot foil shade deviation comparing to the color card approved Metal overshell shade of finish deviation In case of embossing elements: lack of relief Decoration position slightly deviated Incorrect identification of the component, or simply lack of it.

AQL LIST UPDATING

Manager	Data	Change