

HOLISTA	HOLISTA TRANZWORLD PRIVATE LIMITED						Doc>No:HTPL-RD-QC-02			
	Food Safety and Quality Management system						Iss/Rev No: 1.1			
	Quality plan-Packing materials						Date:10.08.2023			
<b>Lid</b>										
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record			
Lid Type	(EOE/ HOE)	Pass/fail		Every lot	Visual	10 per lot	HTPL-QR-QC-05-A			
Internal Lacquer	BPA-NI /Normal	Pass/fail		Every lot	Visual					
Curl Diameter (mm)	82.02-82.26	82.02	82.26	Every lot	Vernier					
Curl Height (mm)	1.85-2.05	1.85	2.05	Every lot	Vernier					
Countersink Depth (mm)	4.12-4.28	4.12	4.28	Every lot						
<b>Tin can</b>										
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record			
Dimension	D73 x H113 ±0.2mm	72.8x112.8	73x113.2	Every lot	Visual	10 per lot	HTPL-QR-QC-05-E			
Internal Lacquer	BPA-NI /Normal	Pass/fail		Every lot	Visual					
Internal strip coating	White Powder	Pass/fail		Every lot	Visual					
End Plate Thickness (EPT)	0.20 mm	Pass/fail		Every lot						
Body Plate Thickness (BPT)	0.18 mm	0.17mm	0.19mm	Every lot	Micrometer					
Seam thickness (T)	1.30+0.10/-0.20 mm	1.28	1.32	Every lot						
Seam length(SL)	2.75-3.0 mm	2.75	3	Every lot						
Seam width	2.80±0.20 mm	2.78	2.82	Every lot	Vernier					
Body Hook (BH)	1.95±0.20 mm	1.93	1.97	Every lot						
Cover Hook (CH)	1.95±0.20 mm	1.93	1.97	Every lot						
Tightness Rating	Greater than 50 %	50	55	Every lot						
Overlap (OL)	Greater than 1.0	1	1.5	Every lot						
AOL	Greater than 50 %	50	55	Every lot						
<b>Carton Box-24 cans</b>										
Parameter	Specification	Min	Max	Min	Max	Test plan	Test Method	Sample Size		
Weight	320 ± 1 (gm)	319	321	319	321	Every lot	Weighing balance	10 per lot		
Length	44.5 ±0.5 (cm)	44	45	44	45	Every lot				
Width	30±0.05 (cm)	29.5	30.5	29.5	30.5	Every lot	Scale measurement			
Height	12±0.5 (cm)	11.5	12.5	11.5	12.5	Every lot				
GSM	120-180 (g/m <sup>2</sup> )	120	180	120	180	Every lot	Weighing balance			
Bursting Strength	Kg/cm <sup>2</sup>	9	12	12	16	Every lot				
Moisture	8-12%	8	12	8	12	Every lot	Loss on drying			
Printing Mater	As per Approved artwork	Pass/fail		Pass/fail		Every lot	Visual			
<b>Carton Box-12 cans</b>										
Parameter	Specification	Min	Max	Min	Max	Test plan	Test Method	Sample Size		
Weight	220 ± 1(gm)	219	221	219	221	Every lot	Weight	10 per lot		
Length	30±0.5 (cm)	29.5	30.5	29.5	30.5	Every lot				
Width	22.5±0.5 (cm)	22	23	22	23	Every lot	Scale measurement			
Height 400ml/200ml	12±0.5 (cm)/13±0.5 (cm)	11.5	12.5	11.5	12.5	Every lot				
GSM	120-180 (g/m <sup>2</sup> )	120	180	120	180	Every lot	Weighing balance			
Bursting Strength	Kg/cm <sup>2</sup>	9	12	12	16	Every lot				
Moisture	8-12%	8	12	8	12	Every lot	Loss on drying			
Printing Mater	As per Approved artwork	Pass/fail		Pass/fail		Every lot	Visual			
<b>Beverage Box</b>										
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record			
Weight	330 ± 2(gm)	328	332	Every lot	Weight	10 per lot	HTPL-QR-QC-05-C			
Length	34.0±0.5 (cm)	33	34	Every lot						
Width	23 ±0.05 (cm)	22	23	Every lot	Scale measurement					
Height	14 ±0.5 (cm)	13.9	14.9	Every lot						
Ply	3	Pass/fail		Every lot	Visual					
GSM	120-180 (g/m <sup>2</sup> )	120	180	Every lot	Weighing balance					
Bursting Strength	Kg/cm <sup>2</sup>	9	12	Every lot						
Moisture	8-12%	8	12	8	Every lot					
Printing Mater	As per Approved artwork	Pass/fail		Every lot	Visual					
<b>Plain Carton Box-coconut milk powder</b>										
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record			
Weight	1300 ±5(gm)	1955	1205	Every lot	Weight	10 per lot	HTPL-QR-QC-05-C			
Length	50 ±0.5 (cm)	49.5	50.5	Every lot						
Width	40 ±0.5 (cm)	39.5	40.5	Every lot	Scale measurement					
Height	21 ±0.5 (cm)	20.5	21.5	Every lot						
Ply	7	Pass/fail		Every lot	Visual					
GSM	120-180 (g/m <sup>2</sup> )	120	180	Every lot	Weighing balance					
Bursting Strength	Kg/cm <sup>2</sup>	16	22	Every lot						
Moisture	8-12%	8	12	Every lot	Loss on drying					

Tray							
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record
Length	32 ±0.5 (cm)	31.5	32.5	Every lot	Scale measurement	10 per lot	HTPL-QR-QC-05-D
Width	23 ±0.5 (cm)	22.5	23.5	Every lot			
Height	5 ±0.5 (cm)	4.5	5.5	Every lot			
Weight	100 ±0.5(gm)	99.5	100.5	Every lot			
Printing matter	As per Approved sample		Pass/fail	Every lot	Weight		
					Visual		
Label							
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record
length	24 ±0.1(cm)	24	24.2	Every lot	Scale measurement	10 per lot	HTPL-QR-QC-05-B
width	10.2 ±0.1 (cm)	10.2	10.4	Every lot			
Brand name	As per approved Label						
No.of colour used	7			Every lot			
Net weight ( 2 Places)	As per approved Label			Every lot			
Veg logo	As per approved Label			Every lot			
MRP (Incl Tax)	As per approved Label			Every lot	Visual		
Batch No	As per approved Label			Every lot			
Date of Manufacturing	As per approved Label			Every lot			
Use by	As per approved Label			Every lot			
Ingredients	As per approved Label			Every lot			
Nutritional information with format	As per approved Label			Every lot			
Clean your city logo	As per approved Label			Every lot			
Manufactured by/ Address	As per approved Label			Every lot			
FSSAI No with logo	As per approved Label			Every lot			
Marketed by /Distributed by/Address	As per approved Label			Every lot			
Storage	As per approved Label			Every lot			
Feedback	As per approved Label			Every lot			
Bar code	As per approved Label			Every lot			
Product of India	As per approved Label			Every lot			
Aluminum Pouch-(1 kg)							
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record
Height	30.5 ± 0.5 (cm)	29.5	35.5	Every lot	Scale measurement	10 per lot	HTPL-QR-QC-05-F
Width	25.4 ± 0.5 (cm)	25.5	26.5	Every lot			
Weight	24 ± 0.5(gm)	21.5	22.5	Every lot			
Aluminum Pouch-(25 kg)							
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record
Height	40 ± 0.5 inches	39.5	40.5	Every lot	Scale measurement	10 per lot	HTPL-QR-QC-05-F
Width	24 ± 0.5 inches	23.5	24.5	Every lot			
Weight	170-190 gm	170	190	Every lot			
Kraft bag -(25 kg)							
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record
Height	40 ± 0.5 inches	39.5	40.5	Every lot	Scale measurement	10 per lot	HTPL-QR-QC-05-F
Width	24 ± 0.5 inches	23.5	24.5	Every lot			
Weight	360-380 gm	360	380	Every lot			
Poly Bag (25Kg)							
Parameter	Specification	Min	Max	Test plan	Test Method	Sample Size	Related Record
Length	111 ± 1.0 (cm)	110	112	Every lot	Scale measurement	10 per lot	HTPL-QR-QC-05-G
Width	66 ± 1.0 (cm)	65	67	Every lot			
Weight	130 ± 0.5(gm)	129.5	130.5	Every lot			