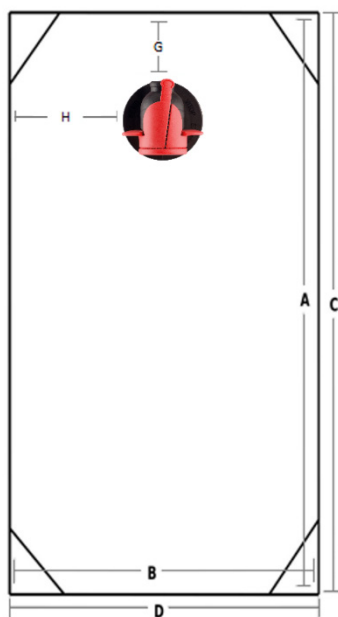


## TRANSPARENT BAG-IN-BOX SPECIFICATION

| 1. GENERAL INFORMATION                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                |                                                                                  |                                                                                      |                |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|----------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|----------------|
| Name of the product                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                | Transparent Bag-in-Box                                                           |                                                                                      |                |
| The manufacturer's name, address                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                | „AZ-Pack“, UAB,                                                                  |                                                                                      |                |
| Nominal capacity                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                | 20L                                                                              |                                                                                      |                |
| Purpose adaptation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                | Intended for packaging of various liquid and semi-liquid food industry products. |                                                                                      |                |
| Packing way (equipment, hand, etc.)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                | Hand                                                                             |                                                                                      |                |
| Manufacturer has been audited according:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                | ISO 9001:2015, ISO 14001:2015                                                    |                                                                                      |                |
| 2. DIMENSIONS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                |                                                                                  |                                                                                      |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | Dimen. (mm)    | Toler. (mm)                                                                      |  |                |
| A. - Inner length                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 580            | ±5                                                                               |                                                                                      |                |
| B.- Inner width                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 480            | ±5                                                                               |                                                                                      |                |
| C.- Outer length                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 600            | ±5                                                                               |                                                                                      |                |
| D.- Outer width                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 500            | ±5                                                                               |                                                                                      |                |
| E.- Seal width                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 4              | ±2                                                                               |                                                                                      |                |
| G.- Distance from gland edge to top edge of bag                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 50             | ±5                                                                               |                                                                                      |                |
| H. - Distance from gland edge to left edge of bag                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | 234            | ±5                                                                               |                                                                                      |                |
| F.- Tap orientation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 12 (Up)        |                                                                                  |                                                                                      |                |
| PERFORATION                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                |                                                                                  | NO                                                                                   |                |
| 3. COMPLEMENTS-MATERIAL                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                |                                                                                  |                                                                                      |                |
| ASEPTIC                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                |                                                                                  | NO                                                                                   |                |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | TAP – VITOP    | GLAND                                                                            | Outer film                                                                           | Inner film     |
| Material                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | PP/HDPE/Elast. | LLDPE                                                                            | PE-EVOH composition                                                                  | LDPE           |
| Colour                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | Black-Red      | Natural                                                                          | Transparent                                                                          | Transparent    |
| Thickness                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                |                                                                                  | 70µm                                                                                 | 50 µm          |
| Permeation properties                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                |                                                                                  | Unit                                                                                 | Typical values |
| Oxygen transmission rate (20°C/65% r.h.) ASTM F1927-98                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                |                                                                                  | cc/(m².day)                                                                          | 0,5            |
| Water vapor transmission rate (38°C/90% r.h.) ASTM E96                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                |                                                                                  | g/(m².day)                                                                           | 10             |
| 4. PRODUCT IDENTIFICATION                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                |                                                                                  |                                                                                      |                |
| <p>Any individual Bag-in-Box bag will have the following identification in one of its sides:</p> <p>„ID: M 19031062520 10:48:25 AZ-PACK   “</p> <p>19031062520 10:48:25– Product ID and time</p> <p>AZ-PACK – name of manufacturer</p> <p> -Recycling code -F  ise symbol</p> |                |                                                                                  |                                                                                      |                |
| 5. USAGE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                |                                                                                  |                                                                                      |                |

Bag-in-Box bag's usage conditions are described below:

- To preserve the properties of the liquid, the bag must be filled to its nominal capacity as specified in point 1 (Nominal capacity), so that no more air is left inside the bag than it fits in the neck of the gland.
- Bags are best suited for cold filling. When filling bags with hot filler, the customer assumes the risk of changes in the physical properties of the bag such as wrinkling.
- Protect the bags from physical and mechanical damage. Physically or mechanically damaged film layers may lose their barrier properties, which may affect oxygen ingress, fluid leakage, demetallization.
- Strict adherence to the filling liquid technology is required when filling bags.
- **Filled bag can not be lifted up holding by the tap!!!**
- Do not bend a gland. Any physical or mechanical damage can result in gland cracking.
- Bag filling temperature ranging from 4 to 100°C.
- Suitable for contact with all types of liquid and semi-liquid foods products containing water, acid, milk, fat products, denatured and undenatured ethyl alcohol.
- The optimum usage conditions are 10-25°C and 60-40% of relative humidity.

**If the rules of usage are not followed, renders the customer full responsibility for the quality of the bags.**

## 6. TRANSPORTATION AND STORAGE

Empty Bag-in-Box bags must be stored in a fresh and dry place, out of range of any heat source and kept in its original package. Temperature range should be between 10°C to 25°C and relative humidity should be from 40% to 70%. Direct exposure to sun may cause changes in the characteristics and color of the product, as well as deformation. To improve the performance of our products, it is advisable to store it, at least for 24 hours, in similar conditions (temperature and relative humidity) before filling. On very specific occasions, the bags can be stored at a temperature of 4°C and 40°C (minimum and maximum respectively). If so, it is necessary to acclimatize them to the optimum conditions 24-48h before the filling process takes place.

## 7. EXPIRY

Warranty period of bags is 12 months, but can be used for 24 months from the manufacture date. The warranty is only valid if the bags are stored and used in the conditions listed above.

## 8. PACKAGING

|     | Dimensions (mm) | Units | Protection     |
|-----|-----------------|-------|----------------|
| Box | 800*600*230     | 200   | PE plastic bag |

Kaunas  
2023-11-13  
Quality specialist



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