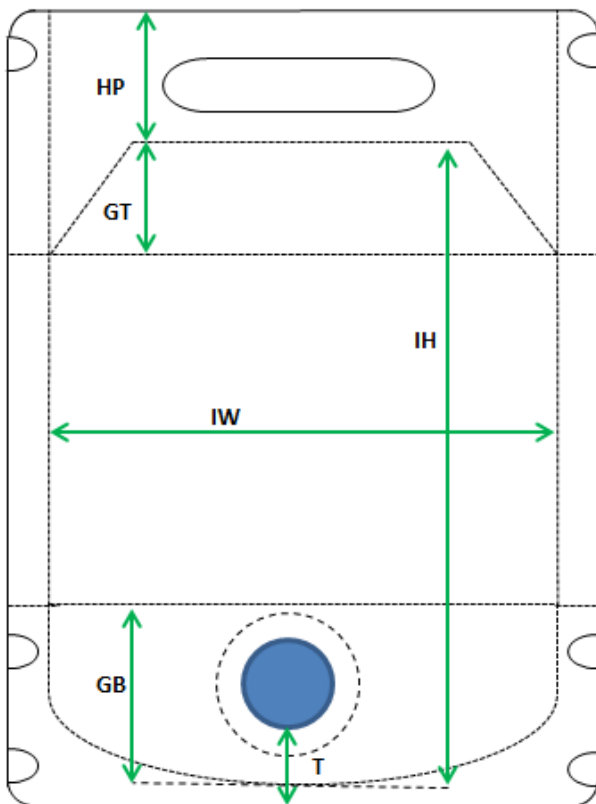


Stand-Up Pouch SPECIFICATION

1. GENERAL INFORMATION		
Name of the product	Stand-Up Pouch 1.5L	
The manufacturer’s name, address	„AZ-Pack“, UAB, Pramonės pr. 4 K, 51326	
Nominal capacity	1.5L	
Purpose adaptation	Intended for packaging of all types 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)	
IW. - Inner width	180	
IH.- Inner length	219	
Outer width	190	
Outer length	280	
GB.- Gusset bottom	49	
GT.- Gusset top	30	
HP. - Handle panel	50	
T. - Distance gland edge to bottom edge of pouch.	25	
Tolerance on all dimensions : ±5mm		
		
3. COMPLEMENTS-MATERIAL		
	TAP – ITAP Solo	GLAND
Material	PP COPOLYMER+TPE	LLDPE
Colour	Black-Red	Natural
4. Material		
Material	PET/PET/PA/EVOH/PE (164 µm)	
Colour	White	

5. Properties

Properties		Method/Test conditions	Units	Typical values	Limit values
Thickness			μm	164	-5/+10 %
Unit weight			g/m ²	184	± 10 %
Width			mm	580	± 1 mm
Coefficient of friction (dynamic, f/f)	A/A D/D	ISO 8295 / DIN 53375		0.30	± 0.15
Tensile strength	MD TD		MPa	40 45	
Breaking elongation	MD TD		%	100 70	
Bond strength		100 mm/min T-method	N/15mm	≥ 2.0	
Heat seal range*		Internal method 1sec/300kPa	°C	150-170	
Barrier properties					
Water vapour permeability (VWTR)		DIN 53122 (23 °C/85%RH)	g/m ² /24h	1	
Oxygen transmission (OTR)		ASTM D 3985-95 (23 °C/0%RH)	cm ³ /m ² /24h	< 3	

*tested in laboratory conditions. The selection of sealing temperatures depends on the characteristic of heat sealing bars and speed of the packing process.

6. PRODUCT IDENTIFICATION

Any individual Bag-in-Box bag will have the following identification in one of its sides:

„ID: Z 19031062520 10:48:25 AZ-PACK   “
19031062520 10:48:25– Product ID
AZ-PACK – name of manufacturer

 - Recycling code

 - Food use symbol

7. USAGE

Stand-up Pouch'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 pouch than it fits in the neck of the gland.
- Protect the pouchs from physical and mechanical damage. Physically or mechanically damaged layers may lose their barrier properties, which may affect oxygen ingress, fluid leakage.
- Strict adherence to the filling liquid technology is required when filling.
- **Filled pouch can not be lifted up holding by the tap!!!**
- Do not bend a gland. Any physical or mechanical damage can result in gland cracking.
- Filling temperature ranging from 4 to 100°C.

- Suitable for contact with all types of liquid, semi-liquid foods products containing water, acid and alcohol, milk and fat products.
- No weight may be placed on the top of the packaging.
- The optimum usage conditions are 10-30°C and 70-40% of relative humidity. 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.

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

8. 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 30°C and relative humidity should be from 40% to 65%. 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.

9. EXPIRY

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

10. PACKAGING

	Dimensions (mm)	Units (pcs.)	Protection
Cardboard box	800*600*230	200	Plastic bag

Kaunas
Quality specialist
2024-11-26

A handwritten signature in blue ink, appearing to be "Monika Starte".

Monika Starte