

## ANNEXES TO THE GENERAL SALES CONDITIONS

**Annex No. 1.** Allowed deviations for flexographic print quality by printing flexible packages

### GENERAL TECHNICAL DATA

Package type	Flexible package
Material	<ul style="list-style-type: none"> <li>• Polypropylene PP (BOPP, OPP, CPP; Properties: transparent, matte, metalized, white, white pearl);</li> <li>• Polyethylene PE (Properties: transparent, matte, high barrier (EVOH), with PA (PE/EVOH/PA); Additional properties: antifog AF, easy peel EP, reclosable RC, for pasteurization and sterilization, metallocene);</li> <li>• Polyethylene terephthalate PET (Properties: corona treated, chemical treated, transparent, matte, metalized);</li> <li>• Oriented Polyamide OPA (Properties: transparent);</li> <li>• Others (Aluminium foil, laminates (KP+PE+AL+PE and others), polyphane twist (metalized, transparent, white).</li> </ul>
Printing type	Flexography
Number of colors + postpress jobs	CMYK + Pantone + varnishing or CMYK + OGV + varnishing
Printing plate	<p>Polymer material is used for manufacturing of printing plates. Formed raster elements are gradually wearing due the contact between printing plate and surface of material during printing process. In order to maintain the same printing quality, JSC "Aurika" changes the set of printing plates to a new one after each 80 ÷ 120 km of printed volume (depending on a design of package).</p> <p>The gap of 1 mm between rows of printing plates is possible, sometimes it is impossible to avoid it due the peculiarities of flexography and it is not considered as printing defect</p>
Color standard for first volume and print proof confirmation	<p>Color standard could be:</p> <ul style="list-style-type: none"> <li>• color number in Pantone palette;</li> <li>• numerical value of color in the Lab coordinates;</li> <li>• printed sample provided by the customer.</li> </ul> <p>If the customer provides printed example as the original color standard, when minimal area of it should be not less than 5x5 mm. Such minimal area is necessary for spectrophotometric measurements.</p> <p>Customer`s sample should be printed on the same material as purchased package.</p> <p>If the package is manufactured according to the digitally printed proof:</p> <p>For CMYK colors – digitally printed proof agreed between customer and JSC Aurika.</p> <p>For Pantone colors – Pantone palette or Lab numerical value.</p> <p>Separately agreed with the customer, Pantone colors matching could be compared with the digital proof.</p> <p>If customer participates in the print confirmation then the original for repeated volumes is considered the print sheet signed by customer.</p>
Color standard for repeated volumes and print proof confirmation	<p>For CMYK colors – digitally printed proof agreed between customer and JSC Aurika.</p> <p>For Pantone colors – Pantone palette or Lab numerical value.</p> <p>If customer participates in the print confirmation, then the original for repeated volumes is considered the print sheet signed by customer.</p>

### ALLOWED DEVIATIONS

Indicator name	Tolerance (limits)	Control method	Defect level* beyond tolerance limits
<b>1. Color rendering accuracy</b>	<p><b>For CMYK colors:</b> <math>\Delta E &lt; 3</math></p> <p><b>For Pantone colors (not gradient):</b> <math>\Delta E &lt; 3</math></p>	<p><b>For CMYK colors:</b> <i>Visually, under viewing conditions according to ISO 3664:2009 standard</i></p> <p><b>For CMYK colors:</b> <i>Measuring with spectrophotometer (according to <math>\Delta E</math> 2000 equation), reading Lab values of 100% color patch from control bar</i></p> <p><b>For Pantone colors:</b> <i>Measuring with spectrophotometer</i></p>	Major

		<p>(according to <math>\Delta E</math> 2000 equation), reading Lab values of 100% color patch from control bar. The package must be placed on a white paper sheet during the measurement</p> <p><b>Rendering of glossy color</b> Measured from glossy material and proof printed with a color profile used for glossy material</p> <p><b>Rendering of matte color</b> Measured from matte material or material coated with matte varnish and proof printed with color profile used for matte material</p>	
<b>2. Dots/dashes in the print</b>	Dots greater than 2 mm diameter and dashes that area is greater than 2 mm <sup>2</sup> are not allowed if they damage general view of front side of package or clarity of text	Visually + magnifier with a 0.1 mm scale	<p><b>Major</b> if damages the view of front side of package</p> <p><b>Minor</b> if dots/dashes are on the back side of package</p>
<b>3. Color register accuracy</b>	Max deviation $\pm 0.15$ mm	Visually + magnifier with a 0.1 mm scale	Major
<b>4. Incomplete printing of image elements</b>	Not allowed if it damages the front side of package or clarity of text or customer's logo	Visually	<p><b>Major</b> if visible at the distance of extended arm (~70 cm)</p> <p><b>Minor</b> if visible at the distance closer than 70 cm or the view of package is enlarged</p>
<b>5. Incomplete printing of text elements</b>	Should not damage text readability	Visually	Critical
<b>6. Barcode readability</b>	The barcode size, direction, color and place should match with approved softproof. The barcode verification could be carried out upon customers' request. In this case customer must indicate preferred grade of barcode readability	Visually or with barcode verifier	Critical
<b>7. Ghosting</b>	Not allowed in the front side of package design	Visually	Major
<b>8. Displacement of package image center during printing, slitting</b>	General allowed tolerance of displacement of package image during printing, slitting - max 1.0 mm	Ruler and/or magnifier with a 0.1 mm scale	Major
<b>9. Package width deviation during slitting</b>	Possible deviation of approved package width during slitting: $\pm 1.0$ mm	Ruler and/or magnifier with a 0.1 mm scale	Major
<b>10. „Marble“ effect</b>	Laminating defects, when emitted CO <sub>2</sub> gases form bubbles between to laminating materials, are not allowed	Visually	<b>Major</b> if visible at the distance of extended arm (~70 cm)

			<i>cm)</i> <b>Minor</b> if visible at the distance closer than 70 cm or the view of package is enlarged
<b>11. Wrinkles in roll</b>	<i>Tolerated amount of wrinkled film is 3% of total amount (location of wrinkles – near the core) or not more than 2 cm from the outer edge of core</i>	<i>Visually and/or ruler</i>	<i>Major</i>

\*The description of defects significance levels is given in Annex No.2

**Annex No. 2.** Description of defects significance levels**DEFECTS SIGNIFICANCE LEVELS**

Defect is a discrepancy that exceed the tolerance limits determined in technical requirements. Defects are divided into **critical**, **major** and **minor**:

- **critical** defects include defects that prevent the product for being used for intended purpose. Also defects that may lead to a damage in the functionality of the products being packed by customer (unacceptable view of the product in the shelf, there is a serious risk to the image of the brand that represent the package)
- **major** defects – such defects that significantly damage the view of the package and cause certain difficulties using the products but do not affect their functionality and do not cause serious risk to the image of the brand
- **minor** defects are those that do not affect the functional properties packed products of customer and do not cause problems using products.

The level of defect for the package is assigned according to the level of the most complicated defect found in it.

For determination of defect level, customer must to answer the following questions (by marking „x“ appropriate box):

Visual assessment		Functionality assessment	
<input type="checkbox"/>	<b>Do not cause problems using product</b>	<input type="checkbox"/>	<b>Do not cause the functional properties of packed products</b>
<input type="checkbox"/>	<b>Significantly worsen the view of package</b>	<input type="checkbox"/>	<b>Cause difficulties using products but do not damage their functionality</b>
<input type="checkbox"/>	<b>The package could not be used for its purpose</b>	<input type="checkbox"/>	<b>Damage the functionality of packed products</b>

	- minor defect
	- major defect
	- critical defect

If its determined that defect is minor, JSC Aurika accept the note from customer.

If its determined that defect is major, the negotiations between JSC Aurika and customer are carried out.

If its determined that defect is critical, JSC Aurika compensates the losses of customer according the conditions of the agreement.

In case of major and critical defects, the customer must provide to JSC Aurika all necessary documentation and/or factual information that would allow to solve the claim.

**Annex No. 3.** Qualitative requirements for conditions of packaging, labelling, storing and transportation procedures of flexible packages**1. Packaging procedure**

- 1.1. The packaging procedure of production is carried out according to the requirements provided by customer. If the customer does not provide any special requirements, the packaging procedure is carried out according to the below described internal standard.
- 1.2. Ready-made roll of packages is wrapped in a plastic bag suitable for food contact. The size of plastic bag is from 1.5 to 2 times bigger than the size of roll.
- 1.3. The top part of packaging bags is packed inside the core of roll to protect against microbiological contamination.
- 1.4. The roll is placed on a wooden palette. The palette from packaging bags is separated with a sheet of paperboard.
- 1.5. The palette is wrapped with stretch film.
- 1.6. The products in rolls without a plastic bag are placed in the corrugated paperboard box of „Eurobox“ type. The palette with products is tightly closed with a paperboard closure and reinforced with a bandaging tape.

**2. Products labeling procedure**

- 2.1. If the customer has special requirements for production labeling, they should be provided during purchase. If the customer does not provide any special requirements, the production labeling procedure is carried out according to the below described internal standard.
- 2.2. Each roll is labeled with a special label with all necessary product information: product name, batch and purchase numbers for product traceability, roll weight (brutto, netto), roll length in meter or units, storage conditions.
- 2.3. If roll is joined, the number of joints is provided on a special label.

**3. Recommendations, storage and validity**

- 3.1 Recommended storage conditions: store covered, in a dry room with constant temperature ranging from +5 °C to +30 °C and 40 to 65% relative air humidity. Avoid sudden temperature changes.
- 3.2 If the package was stored below +15 °C temperature (for the package with cold seal it is recommend not exceed +25 °C), package must be kept in working environment for not less than 24 hours before use.
- 3.3 Avoid direct sunlight. The package cannot be stored near heating appliances.
- 3.4 It is advised to rotate the inventory according to the delivery date (first in – first out).
- 3.5 The package is suitable for use up to 24 months from the date of manufacturing if kept in original packaging. Except the package containing AntiFog additive and with cold seal. Such package is suitable for use up to 6 months from the date of manufacturing if kept in original packaging.

**4. Transportation procedure**

- 4.1. The delivery is carried out with covered vehicles. The palettes with products are additional covered with a plastic film to protect against humidity.
- 4.2. The vehicle must meet the requirements of hygiene for flexible food package transportation. There cannot be any outside odors that can affect the production, excessive dust and humidity, pests, molds.
- 4.3. The flexible packages cannot be loaded in the vehicles with cargo that are dangerous to ensure the protection of transported packages rolls against cross-contamination (examples of prohibited cargo: any smell emitting products, hazardous chemical materials, waste).
- 4.4. When loading, transporting, unloading and storing it is prohibited to repack the products from original packaging.
- 4.5. Before loading the production into a vehicle, it is mandatory to check that the cargo is safely packed, reinforced, not tilted, undamaged and protected against damages.
- 4.6. The cargo is loaded into a vehicle in such way that it will not be mechanically affected (for example: crushed, damaged package) get dirty or wet.

