



Customer object specification

Specifications for shrink-wrapped packs



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1 General information

The standard quality defined below is accepted as agreed unless a differing agreement exists for the quality of the shrink-wrapped packs.

The descriptions apply to all container types such as PET, glass, cans and to the pack types shrink pack, shrink tray and shrink pad.

Adjustments to the machine or retrofitting of equipment in order to achieve pack features that differ from those described below do not form part of the service to be provided.

The visual appearance of the packs is not specified.

The definition of the quality is largely based on the specifications of the ABMI (Association of the Beverage Machinery Industry).



2 Sampling

Sampling after > 15 minutes of continuous production under standard conditions for the relevant pack.
The samples must be taken downstream of the tunnel following the principles of random sampling and must be measured after they have cooled down.
For example, monthly sampling of a pack at a defined position.



3 Compliance with the specifications

The test is classed as having been passed if more than 80% of 100 samples are within the tolerance and satisfy the additional requirements set out below.

(The number of samples can be reduced by mutual consent.)

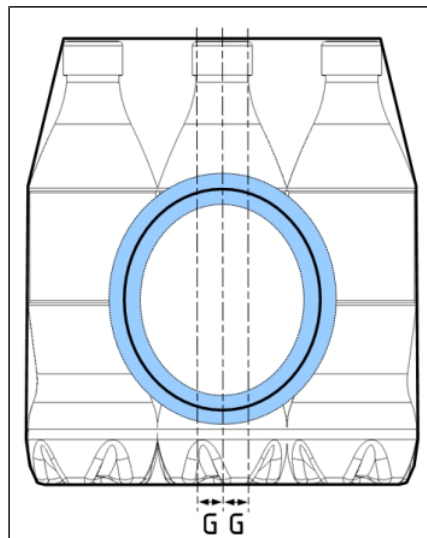
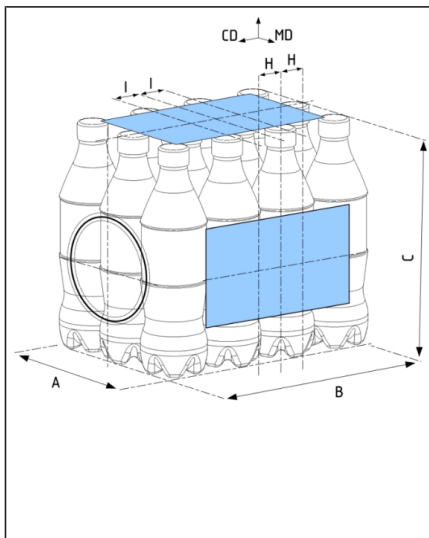
4 Test values and tolerances

A	Pack length in MD
B	Pack width in CD
C	Pack height
D	Container offset tolerance
E	Angle tolerance in CD
F	Angle tolerance in MD
G	Tolerance for the centricity of the film eye
H	Tolerance for the centricity of the film in MD, front and rear
I	Tolerance for the centricity of the film at the top

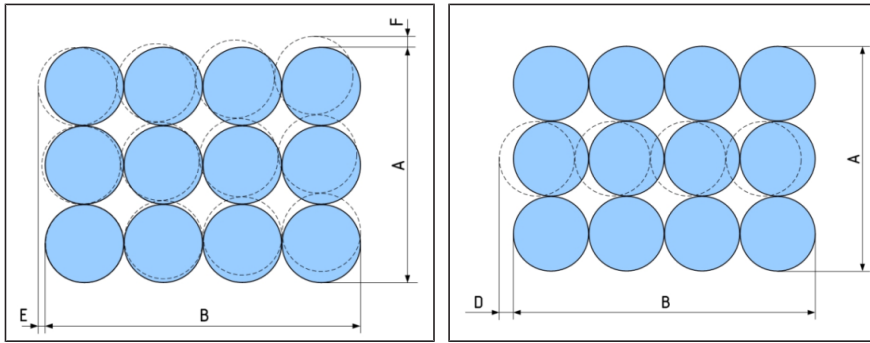
Independently of the calculation, the minimum tolerance in each case is 5 mm.

The tolerances apply exclusively to operation of the machine within the specification in connection with customer objects that comply with the KRONES specification. In particular, they apply exclusively to film that complies with the KRONES film specification and the KRONES film drawing.

Variable	D	E	F	G	H	I
Tolerance	$A \times 0.025$	$A \times 0.025$	$B \times 0.025$	$A \times 0.1$	$C \times 0.1$	$A \times 0.1$



MD = Machine direction, CD = cross-wise to the machine direction



In addition, the following also applies:

- The packages are sturdy enough to ensure that no containers are lost when the package is carried by the designated carrying aids.
- The stability and geometry of the packages are such that they can be handled in the further processing chain (transport, accumulation conveyors, palletising).

Failure rate as contractually agreed.