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ILLINGTM
P A C K A G I N G

Product Specification Sheet

Illing Part#

3566PETA

8 OZ CLEAR PET MODERN ROUND 24-410 NECK 27 GRAMS

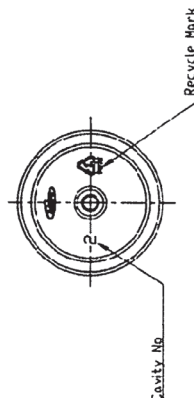
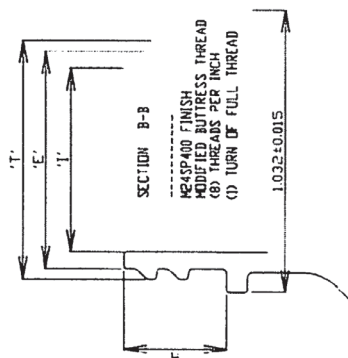
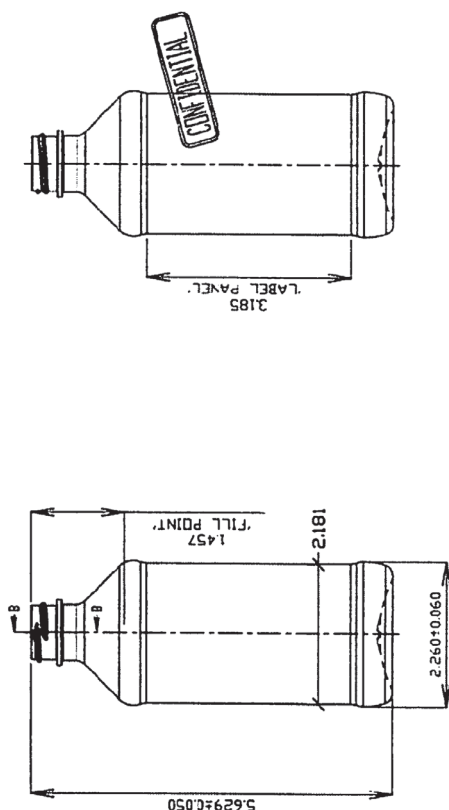
Part #: 3566PETA

Size:	8 OZ
Color:	CLEAR
Material:	PET
Style:	MODERN ROUND
Additional Info:	24-410 NECK; 27GRAMS
Case Pack:	250 / EACH
Pallet Pack:	3,750 / EACH



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	REV	DATE	DESCRIPTION
1	1/06/2012		Translated dwg to a new template
2	4/10/2012		Changed "I" spec, Height Tol., Width Tol. and Overlap Tol. ## per SPI std.
3	7/15/2014		Added EPBES-V to the product list
4	06/01/2015		Added corresponding Item Arch 11 ogel Product ID's
5	03/21/2016		Added additional Product ID's as applicable Mold-Cavitation z.
6	06/25/2016		Added additional Arm Product ID's
7	09/08/2016		Renamed Arm Product ID Ref. & Connected 7 Gently roll ref. #
8	10/14/2021		Changed Arch Drawing #
9	3/27/2022		Added Band Dia.



NOTE: ALL DIMENSIONS ARE IN INCHES

NECK FINISH:	M24SP400
MIN WALL:	0.008 (label parts)
	$\frac{t_{min}}{t_{nom}}$ $\frac{t_{min}}{t_{nom}}$ $\frac{t_{min}}{t_{nom}}$
	U.F.I.L.X.: < 2° 34'
MINIMUM	0.924 0.840 0.365 0.516
MAXIMUM	0.940 0.856 0.475 -
AVER.	0.932 0.848 0.400 -
HILL POINT CAPACITY:	237 +/- 4 ml
OVERFLOW CAPACITY:	263 +/- 7 ml
GRAM WEIGHT:	27 +/- 1 g
PRODUCT MATERIAL:	BET.

Applicable Molds:
N91077 - 3 cavities (#1 to #3)
K61291 - 7 cavities (#4 to #10)



ARCH PRODUCT NAME: 8oz PET MODERN ROUND

ARCH DWG #: 8PE05-MR

REVISION: 0	DATE: 02/25/2022	SCALE: NTS	AL
DESIGNED BY: 	REVIEWED BY: HAMA	APPROVED BY: HALL	



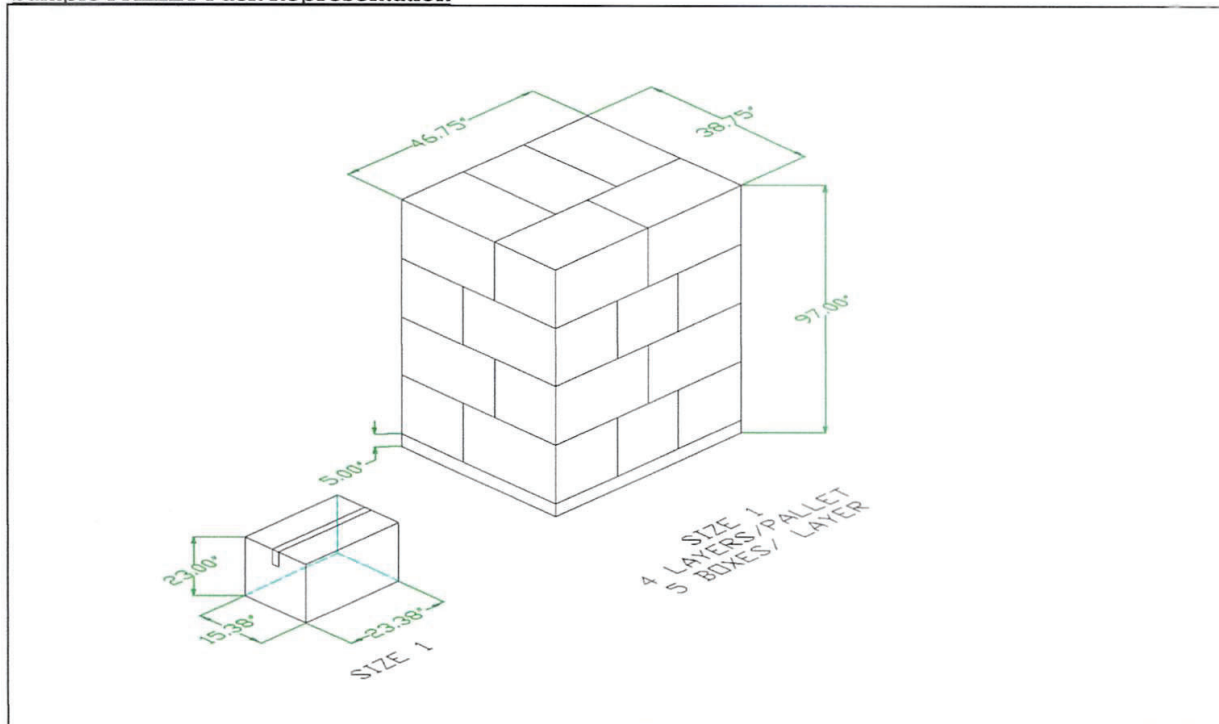
Packaging Spec Attachment



Attachment #

8PE05-4L-TRevision # **0**Product Description: **8oz PET Modern Round Bottles**Product Weight (g): **27**
Tray Pack Style:

Carton Type:	Size 1	Packing Pattern:	TUMBLE
Case Count:	250		
# of Cases/Layer:	5	Pallet Dimensions:	40"L x 48"W x 97"H
# of Layers/Pallet:	4	Approx. Pallet Weight, lbs	350
Bottles / Pallet:	5,000		
Total Cases per TL:	560		
# of Pallets/Truck:	28	Truck Load Quantity:	140,000
Pallets to Use:	<u>Plastic Pallets (40"x48" Nestable Light Duty) (or)</u> <u>Grade A - Heat Treated (Recycled / New wood) Pallets</u>		

Sample PALLET Pack Representation




Bottle Specification

Arch Product Specification # 01-009 Rev # 5
 Customer Name: Arch Stock Bottle
 Product Description: 8oz PET Modern Round Clear
 Arch Product ID: 014105-2600 Neck Finish: M24 SP400
 Drawing # 8PE05-MR Packing Pattern: 8PE05-4L-T

Raw Material Specifications

Resin: FDA Compliant PET Resin
 Alternate Resin: -
 Colorant: - Recommended LDR % -
 Alternate Color: - Recommended LDR % -

Machine Platforms: Nissei - ASB-50MB Cavity Ref.: #1 to #3
Nissei - DPH-70 Cavity Ref.: #4 to #10

Retention Plan:

1. Production LOT documents are retained for 5 years from the date of Manufacturing.
2. Production LOT periodic samples are retained for 3 years from the date of manufacturing.

Shelf Life:

Empty containers supplied by Arch Plastics are to be used within 12 months from the date of shipment when stored under the following conditions:

1. Containers are recommended to be stored at a room temperature between 50F to 90F and a relative humidity between 25% to 70% at all times.
2. Containers should be protected from moisture, freezing, and excessive heat, and, where necessary, from light during shipping and distribution.
3. No double stacking of finished pallets are allowed.

<u>Special Instructions:</u>	In the Arch Product ID, #26 indicates - FDA Compliant PET Resin; This bottle specification supercedes # 01-012.
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Bottle Specification



Arch Product Specification #

01-009

Rev #

5

Quality Plan:

1. Arch Plastics uses ISO2859/ASQ Z1.4 table as a reference standard for Sampling Plan.
2. AQL Level S-2 will be considered for the measurement of container attributes.
3. AQL Level II will be considered for the visual attributes with the following acceptance and rejection criteria of defect classification from the below reference standard table.

Critical Defects (0.15%)	<u>Defects related to safety issues or a violation of law.</u>
	Holes causing leakage; Incorrect neck finish; Use of incorrect raw materials; Insect contamination in finished product; A foreign substance or loose particles on the inside of a container exceeding 1mm, which may render the product unsafe or contaminated.
Major Defects (1.00%)	<u>Defects which make product unfit to use based on appearance.</u>
	Neck finish defects likely to result in an inadequate seal which includes unfinished neck, choked neck, uneven land area, neck flash which affects cap assembly or functionality; Bubbles, Strings; Foreign component or article mixed in the case; Dimensional variation exceeding tolerances on specifications; Uneven wall distribution, resulting in soft areas on the bottle which will not run on the packaging line; Parting line mismatch which adversely affects label application; OFC & gram weight are outside the specified tolerances; Rocker bottoms, short shots.
Minor Defects (2.50%)	<u>Defects that are not likely to affect the products functionality.</u>
	More than 2 embeded resin particles per container over 1mm or more than 5 per container 1mm or less; Excessive/unusual surface marks like orange peel, scuff marks, etc., that is noticeable at 2'; More than 5 loose particles per container, 1mm or less that does not render the product unsafe (like corrugation fiber, clothing fiber); Uneven color dispersion; Missing molded raised design or lettering; Bubbles, embeded strings; strings extending outside the pushup area of the bottle.

Attachments:

1	Product Drawing	8PE05-MR
2	Packaging Specification	8PE05-4L-T
3	Sample Arch COC	

Revision:

5	1/26/2024	Updated the bottle specification format and BS Ref #
4	6/2/2017	Deleted Drawing revision per document rev. control procedure.
3	8/18/2016	Updated Dwg Revision; Added Shelf life & Quality Plan; Changed Alternate PET Resin
2	12/1/2015	Added Plastic Pallets under Pallets to Use
1	11/4/2015	Added Alternate Resin & corresponding Arch product ID details.
0	6/22/2015	Original

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Illing Part#

3566PETA

Bottle Specification



Arch Product Specification #

01-009

Rev #

5

Approved By:

Plant QA Incharge:

[Signature]
Rama Etekallapalli

Date:

1/26/2024

Facility Manager:

[Signature]
Shital Rali

Date:

1/26/2024