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Material	Sodium- calcium- silicate, clear	
Production Type	Individual station BB, IS PB	
Certyfikate	ISO 9001:2015 ISO 28000:2007 ISO 50001:2018 Atest PZH EcoVadis Sedex	
Coatings	TegoGlas T5	
Internal test performance	ASTM C148-17 Standard Test Methods for Polariscopic Examination of Glass Containers	
Quality assurance	<p>Directive 2001/95/EC of the European Parliament and of council of 3 December 2001 on general product safety</p> <p>European Parliament and council Directive 94/62/EC of 20 December 1994 on packaging and packaging waste</p> <p>Regulation (EC) No 1935/2004 of the European Parliament and of the council of 27 October 2004 on materials and articles intended to come into contact with food and repealing Directives 80/590/EEC and 89/109/EEC</p> <p>Regulation (EC) No 1907/2006 of the European Parliament and of the council of 18 December 2006 concerning the Registration, Evaluation, Authorisation and Restriction of Chemicals (REACH), establishing a European Chemicals Agency, amending Directive 1999/45/EC and repealing Council Regulation (EEC) No 793/93 and Commission Regulation (EC) No 1488/94 as well as Council Directive 76/769/EEC and Commission Directives 91/155/EEC, 93/67/EEC, 93/105/EC and 2000/21/EC</p>	
Glass composition	SiO ₂ Na ₂ O K ₂ O Li ₂ O CaO MgO Al ₂ O ₃ Fe ₂ O ₃ B ₂ O ₃ SO ₃ BaO PCR	69 – 75 % 12-15 % 0-3% 0-0,4% 7-11% 0-4% 1-3% Max 0,04% 0-2% 0,1-0,3% 0 – 2% ~3%
Inspection level ¹	I	
Quality criteria	Glass control is made in proper condition: 1. Distance (50 cm from the field of view) 2. Lighting (d65 light cabin) 3. Similar to glass exposure on shelf .	
Use condition	Not for hot drinks Safety for dishwasher Wash before first use Safety for fridge (temp. above 4 Not for microwave Can be freeze with alcohol liquid above 38% alcohol concentration ² Glass can't be freeze with water based liquid.	

¹ ISO 2859-1:1999 Sampling procedures for inspection by attributes. Part 1. Sampling schemes indexed by acceptance Quality Limit (AQL) for lot-by-lot inspection

² Test made by Client

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Quality classification

AQL	Definition	Deviations
Limit OK	Deviation, which cannot be eliminated due to technological reason	Buffle mark High buffle (less than 2 cm at walls) Uneven distribution (wall thickness more than 1 mm) Wedged bottom Dust from conveyor Not permanent contamination Wavy Glass colour deviation (spectrophotometer methodology) Marks in labels area without impact on labelling Readable marks Marks in mould connection Rolled finish
Minor (AQL 4.0)	Cosmetic deviation, which can appear during production process but due to slightly visible of deviation- rejection are burdened high defect ratio. Deviation do not have impact on final customer decision.	Bubble in glass mass bigger than 2 mm Brush mark Shear marks Black dots, not grouped less than 2 mm Neck matt Prominent seam Oil marks Cold marks Wrinkles
Major (AQL 1.5)	Average deviation, which was observed during production process. Deviation can be visible for final customer. Safety for usage. Deviation classified as a visuals effect.	Touchable optic in label area Hot blank mark Lack flatness in labels area Neck curve Black dots, more than 2 mm
Critical (AQL 0,65)	Deviation, which was observed during production process and rejected during sorting. Defect which determine safety.	Overpress Glass inside Oval neck (undeformed) Broken Sharp edges Stuck Rocky bottom Nonconformity with technical drawing Deformed Birdcage Plached neck Checks Light or thin wave (less than 1 mm)

Sampling plan

Batch quantity	Inspection level	Sample size	Critical	Major	Minor
			Ac 0,65	Ac. 1,5	Ac 4.0
1201-3200	H	50	1	2	5
3201- 10000	J	80	1	3	7
10001- 35000	K	125	2	5	10
35001-150000	L	200	3	7	14
Powyżej 150000	M	315	5	10	21

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