QC SPECIFICATION FOR ZIPPER BAG

Date **22/09/2025**

Customer **: All**

Description **: LDPE reclosable zipperbag**

Thickness **: 0.050 mm**

Checking point		Testing method	Range	SPEC.
Dimension (mm)	Width /Length	Ruler	50-130	± 3
			upper 131	± 5
	Thickness	Dial gauge	0.10 (2 page)	± 0.005
Zipper strength (kgf)	Outside	Push -Pull gauge	Zipper thickness 1.20 mm	0.5-1.0 kgs/cm^2
	Inside			≥1.8 kgs/cm^2
Bottom strength		Drop steel 150 grams shake 3 tims	0.10 (2 page)	No tear "Passed"
Seal strength	Testing by Tensile M/C (N)	Testing by LLOYD Tensile testing machine speed 500 mm/min	left and right Side	Lip : 8-10
				Bag : 10-15
	Testing by manual	Pull along side seal left and right side	left and right Side	No break is "Passed"
Tensile strength (N/mm^2)		Testing by LLOYD Tensile testing machine speed 500 mm/min	TD	8-10
			MD	15-20
% Elongation (%)		sample size 20x100 mm gripper space 50 mm	TD	150-400
			MD	100-200
Freezer test (for freezer zipper bag)		Put zipper bag into refrigerator at -8 ± 2 °C	0.10 (2 page)	No crack and good zipper is "Passed"
Printing	Color	Sample approved / Pantone	Up to customer	MAX-MIN
	Printing position	Sample approved / Art eork	Up to customer	± 5
	Apperance	visual /spec max-min	Up to customer	No blur/within limited
Packing		Counting	Up to customer	Completely
			Up to customer	Completely

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