



Walstead
CENTRAL EUROPE

Final Product
Quality Specification
(CP)

SPOUT01

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I. GENERAL

This document defines general quality standards for final product manufactured at Walstead Central Europe.

2. DEFINITIONS

FUNCTIONALITY – ability to use according to intended or specified purpose. Considering the booklet, it is assumed that it loses its functionality if:

- The booklet is not complete – does not possess all ordered elements.
- The booklet cannot be used in the most common sense of this word – it cannot be read, looked or flicked through.

NONCONFORMITY – non-fulfillment of a requirement.

DEFECT – non-fulfillment of a requirement related to an intended or specified use.

COLOR GUIDELINE – digital or material guidelines defining color.

PROFIL ICC – a file that describes how a particular device reproduces color. The profile defines device gamut in the context of a device-independent color space.

PROOF / REFERENCE PRINTOUT – comparative printout imitating the results achievable on the real painting machine.

COLOR OK. – comparative signature chosen from printed count that best matches the proof – signed up by the Customer, Walstead CE Shift Leader or authorized Walstead CE Press Operator. Printed on the machine remains the real, achievable color guideline for the operator and is treated as reference for the rest of the count.

FORMAT OK. – comparative book, signed up by the Customer, Walstead CE Shift Leader or authorized Walstead CE Press Operator. Bound on the machine remains the real, achievable guideline and is treated as reference for the rest of the count.

ΔE – color difference between master and measured sample – value calculated as Euclidean distance in the CIE L^*a^*b color space.

CONTROL PATCHES – color patches placed on signature enabling both visual and instrumental control of print quality.

SPECTROPHOTOMETER - device that measures color

–obtained results define position of particular color in universal three-dimensional Lab color space.

JOB TICKET – main instruction (specification) of job realization - document used internally at Walstead CE, created by CSR based on information delivered by the Customer in the production order.

GLUED INSERT – insert glued on the page indicated in JBT, except the cover.

BIND INSERT – insert glued into backbone

THROWN INSERT – insert put between pages (loose)

STICHED INSERT – insert connected with the book using stitches, located between pages of the book

STRIPE – insert stitched to the book, on the cover.

ONINSERT – flat insert put on the cover during polybagging

ONINSERT 3D thrown – insert multidimensional e.g.: flip flops, purse, figurines in packs, etc

ONINSERT 3D glued - insert multidimensional, fixed to the cover with glue.

ONINSERT glued – insert glued on the cover or first page of the middle of the book

3. PROCESS COLORS

3.1. COLOR GUIDELINE

The information presented on proof is the main color guideline for process colors. Proof shall be prepared in accordance with the recommendations gathered in QMPR-I2SPIN01 Preparation of materials for printing and QMPR-I2SPIN02 External proof verification. Lack of conformance to mentioned documents may result in differences in color between final product and delivered proof.

In case no proof has been delivered or delivered proof is not conforming to Walstead CE recommendations the standard digital values are considered the color guideline. Those target values describing print parameters are defined in appropriate, used in production Walstead CE ICC profile.

The type of Walstead CE ICC profile to be used in production is agreed between Customer and Walstead CE before the production start-up. In case of no agreements Walstead CE applies standard Walstead CE ICC profile adequate for paper type, screening and product characteristics.

All Walstead CE ICC profiles were defined in order to achieve in the process the color parameters conforming to guidelines described in ISO standard ISO 12647-2:2004(E).

Based on visual and/or instrumental conformance assessment of printed page with delivered color guidelines the Color OK signature is signed.

When signed up the Color OK signature is the color guideline for the operator and is treated as reference for the rest of the count.

ATTENTION! Surface finishing (e.g. varnish, lamination) may influence the color – Walstead CE does not bear responsibility for color changes appeared due to surface finishing off painting press.

3.2. VISUAL CONTROL

The main method of color control is the visual assessment.

VISUAL CONTROL CONDITIONS:

The assessment should be conducted in standard viewing conditions according to ISO 3664:2000. Special recommendations include:

- the relative spectral distribution of the illuminant should be close to CIE illuminant D50 (corresponding color temperature of approximately 5000 K), CRI index should not be lower than 90 (recommended value < 95),
- the intensity of illumination on the viewed surface should be $2000 \text{ lx} \pm 500 \text{ lx}$,
- the surrounding area and background used for evaluation of the materials should be in neutral grey and matt.

Color OK signature as well as count signatures shall match the color guidelines

ACCEPTABLE	NOT ACCEPTABLE
Colour insignificantly different from color guideline	Color significantly different from color guideline

3.3. SPECTRAL CONTROL

All kind of measurements are considered additional method of color control. The spectral measurement becomes the main method of print quality assessment when:

- No proof has been delivered
- Delivered proof does not conform to Walstead CE recommendations

MEASUREMENT CONDITIONS:

Device:	SpectroEye (GretagMacbeth)
Substrate:	self backing
Physical filter:	UV Cut
Illumination:	D 50
Observer angle:	2 °

TOLERANCES:

L*a*b coordinates of process color solids on Color OK as well as count signature shall conform to standard target L*a*b values defined for those solids by adequate Walstead CE ICC profile.

Deviations from target values shall not exceed the tolerance range specified in ISO standard 12647-2:2004(E), chapter 4.3.2.3. Ink Set Colors (paragraph 4, note2, table 3).

Table below presents the range of acceptable deviations for process color solids.

COLOR	Black 1)	Cyan 1)	Magenta 1)	Yellow 1)
acceptable deviation from target value for Color OK signature	5	5	5	5
acceptable deviation from Color OK signature for the count 2)	4	4	4	5

1) Hue share in total difference shall not exceed 2,5
2) In specified tolerance range shall stay at least 68% of total count

3.4. DOT GAIN

Dot gain characteristic for Color OK, as well as count signatures shall conform to standard defined by curve B described in ISO standard 12647-2:2004(E). Table below presents target values and deviations acceptable on patches of different tone value.

tone value of control patch [%]	25	40	50	70	75	80
target value [%]	12	16	17	15	13	12
acceptable deviation from target value for Color OK [%]	4	4	4	3	3	3
acceptable deviation from target value for count average [%]	4	4	4	4	4	4
acceptable value of count standard deviation [%]	4	4	4	3	3	3
acceptable value of range between chromatic colors [%]	5	5	5	5	5	5

Assuring the above parameters (pt 3.2; 3.3. and 3.4.) in the case of heatset production require the count ca. 40000 rpm. Before reaching this count as acceptable product in terms of color considered is product not significantly different from color guideline by visual assessment.

3.5. INFORMATION REGARDING STOCHASTIC PRINTING STACCATO 10

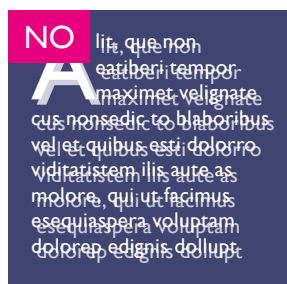
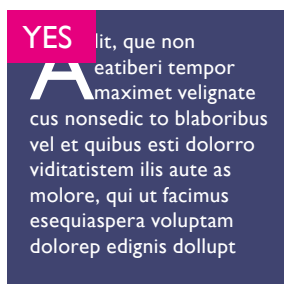
As the process of stochastic printing is more variable, acceptable degree of discrepancy between printed sheet and correctly prepared proof can be higher.

Due to technical reasons Walstead CE may change the method of screening at the last moment, while making Customer Representative the only person notify of it.

3.6. REGISTER

Relative misplacements of images printed from CMYK or PMS inks shall be within acceptable tolerance range.

ACCEPTABLE	NOT ACCEPTABLE
Register off by $\leq 0,2$ mm	Register off by $> 0,2$ mm



4. SPECIAL COLORS

4.1. COLOR GUIDELINE

The main color guideline for special color printouts are digital values describing color parameters defined based on Pantone guidelines specified in SpectroEye Colorguide Pantone 2004.

Additional guideline for special color setting, are the reference printout from Walstead CE Ink Laboratory or current paper swatchbook Pantone Special Colors.

For metallic special colors the main and only guideline is the current paper swatchbook Pantone Metallic Special Colors.

Based on visual and/or instrumental conformance assessment of printed page with delivered color guidelines the Color OK signature is signed.

When signed up the Color OK signature is the color guideline for the operator and is treated as reference for the rest of the count.

ATTENTION! Surface finishing (e.g. varnish, lamination) may influence the color – Walstead CE does not bear responsibility for color changes appeared due to surface finishing off painting press.

4.2. VISUAL CONTROL

The Visual assessment is considered additional method of color control. The visual assessment becomes the main method of print quality control in case of no digital guideline is available.

VISUAL CONTROL CONDITIONS – see point 3.2

Color OK signature as well as count signatures shall match the color guidelines.

ACCEPTABLE	NOT ACCEPTABLE
Color insignificantly different from color guideline	Color significantly different from color guideline

4.3. SPECTRAL CONTROL

The main method of color control is the spectra measurement.

MEASUREMENT CONDITIONS – see point 3.3. TOLERANCES:

L^*a^*b coordinates of special color solids on Color OK as well as count signature shall conform to standard tar-

get L*a*b values defined for those solids in SpectroEye Colorguide Pantone 2004.

Printout conformance to guidelines is verified using Best Match function available in SpectroEye device that additionally takes into consideration the print process variables (e.g. substrate/paper or surface finishing)

Deviations from target values shall not exceed the tolerance range specified in the table below.

acceptable deviation from Best Match value for Color OK	1
acceptable deviation from Color OK for the count I)	3
In specified tolerance range shall stay at least 68% of total count	

In non standard cases like:

- lack of any guideline for special color,
- overprint of process colors on special color,
- printing of double layer of special ink (from two consequent ink units),
- special color separation is not solid.

the given above tolerances are not in force any more.

In such cases the Customer is obliged to notify Walstead CE much earlier in order to both sides have enough time to prepare the print process assuring the final color effect possibly close to Customer requirements.

4.4. LIMITATIONS IN PRINTING WITH SPECIAL INKS

Using metallic inks in heatset printing

Metallic pigments may react with fountain solution (lower pH value) and go matt, which may be seen as “dull” or subdued” color.

Uncoated metallic ink surface is not resistant to rubbing and scratching under pressure.

With larger pigment particles, such inks are less suitable for printing raster surfaces and fine lines.

UV varnish on a surface heatset-printed with metallic ink visibly reduces the metallic effect (especially for metallic silver).

UV varnish adhesion to metallic ink is lower, causing a risk of chipping. A thicker metallic ink layer makes even UV varnish application difficult, which may cause an “orange peel” effect on the coating surface.

Using fluorescent inks

The light-fastness of fluorescent printing inks is very poor. Also, they are not resistant to spirit varnishes, nitro varnishes, or alkalies. The printing company assumes no responsibility for fluorescent inks changing color after exposure to light, dispersion varnishes, UV varnishes, and after film lamination.

Because of higher pigments such inks are not suitable to print halftone areas and fine line drawings (see: QM.PRI2.LI01. SPIN01 Preparation of materials for printing). Achieving the desired optical effect requires a high inking, which can cause killing delicate areas of the halftone.

5. GEOMETRY

5.1. TRIM SIZE

Trim size is understood as physical dimensions of the book (x: horizontal, y: vertical) given in millimeters and specified in Job Ticket.

When signed up the Format OK book is the trim size guideline for the operator and is treated as reference for the rest of the count.

The trim size of Format OK book deviates from target value only if it is crucial in order to keep image within the net size of the page. It is allowable within the tolerance range given below.

ACCEPTABLE	NOT ACCEPTABLE
deviation from target value ≤ 1 mm	deviation from target value > 1 mm

The trim size within the count deviates from target Format OK value due to natural process variability. It is allowable within the tolerance range given below.

PRODUCT TYPE	ACCEPTABLE	NOT ACCEPTABLE
BOUND book	deviation from Format OK. value ≤ 0,5 mm	deviation from Format OK. value > 0,5 mm
STITCHED book	deviation from Format OK. value ≤ 1 mm	deviation from Format OK. value > 1 mm
OTHER (trimming on press or finishing line)	deviation from Format OK. value ≤ 1,5 mm	deviation from Format OK. value > 1,5 mm

5.2. SQUARENESS

Trimmed, perpendicular product edges shall create 90 degrees angle. Squareness deviation is measured with

reference to backbone. Deviation shall not exceed the tolerance range given below and shall never be greater than 2mm over the longer edge of the book.

RODZAJ PRODUKTU	ACCEPTABLE	NOT ACCEPTABLE
BOUND book	deviation $\leq \pm 0,5$ mm over 100 mm	deviation $> \pm 0,5$ mm over 100 mm
STITCHED book	deviation $\leq \pm 1$ mm over 100 mm	deviation $> \pm 1$ mm over 100 mm
OTHER (trimming on press or finishing line)	deviation $\leq \pm 1,5$ mm over 100 mm	deviation $> \pm 1,5$ mm over 100 mm

5.3. IMAGE POSITION ON PAGE

Image position within net size of the page specified / visible in the production file delivered by the Customer is considered the main guideline. The proof, plotter print-out or dummy book prepared based on production file are also considered the image position guideline.

Improper image position results mainly from fold or cut failures and is visible either as vertical/horizontal shift or skew of image on the page.

Shift or skew of the image on the page is commonly measured on characteristic image elements (e.g. margins, vignettes) and the reference system create: backbone axis and perpendicular to it horizontal axis starting from the point in the middle of the backbone.

Shift or skew of the image on the page shall not exceed the tolerance range given below.

ACCEPTABLE	NOT ACCEPTABLE
shift $\leq 1,5$ mm	shift $> 1,5$ mm
skew $\leq 0,5$ mm over 100 mm and no more than 2 mm over backbone	skew $> 0,5$ mm over 100 mm or more than 2 mm over backbone

6. IMAGE AND MECHANICAL NONCONFORMITIES

Product possessing influencing functionality image and/or mechanical nonconformities is considered defective.

Product possessing not influencing functionality image and/or mechanical nonconformities of a number and intensity exceeding the tolerance range specified on the graph below is considered nonconforming.

Product possessing not influencing functionality image and/or mechanical nonconformities of a number and intensity within the tolerance range specified in tables below is considered conforming.

Existence and number of image and/or mechanical nonconformities is stated based on visual assessment.

Their influence on the quality and functionality of the image (size, influence on color) is verified using measurement methods specified in tables below.

Tolerance range for IMAGE NONCONFORMITIES shows the table below.

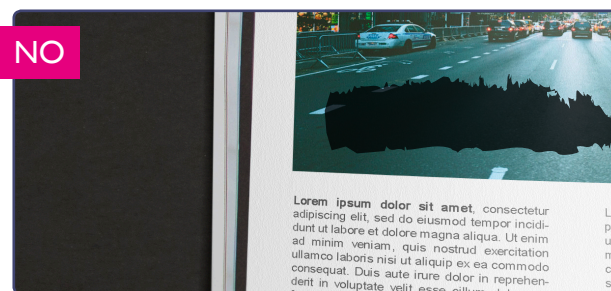
NON CONFORMITY	ASSESSMENT METHOD	PLACE	ACCEPTABLE	NOT ACCEPTABLE
LINE	Measure length	COMMERCIAL* pages	length ≤ 5 mm and $n^{**} \leq 1$	length > 5 mm or $n > 1$
		EDITORIAL pages	length ≤ 10 mm; and $n \leq 3$	length > 10 mm; or $n > 3$
SPOT	Estimate single and total coverage and check the text legibility	COMMERCIAL pages	single cov ≤ 1 mm ² and $n = 1$ total cov $\leq 1,5$ mm ² and $n \leq 3$	single cov > 1 mm ² or $n > 1$ total cov $> 1,5$ mm ² or $n \leq 3$
		EDITORIAL pages	single cov ≤ 2 mm ² and $n = 1$ total cov ≤ 3 mm ² and $n \leq 3$	single cov > 2 mm ² or $n > 1$ total cov > 3 mm ² or $n \leq 3$
DIRTY AREA, STAIN, CATCH UP	Measure dE for color difference	COMMERCIAL pages	$\Delta E \leq 2$	$\Delta E > 2$
		EDITORIAL pages	$\Delta E \leq 3$	$\Delta E > 3$

* commercial page means customer logo, cover, backbone, page or insert with a commercial

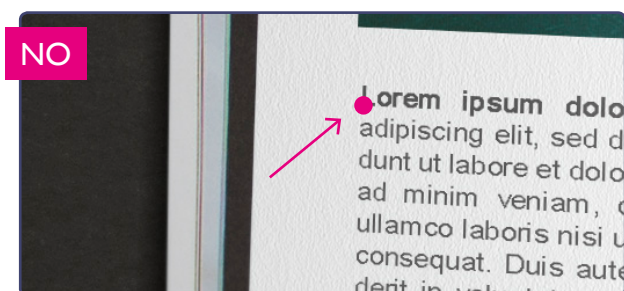
** n means acceptable quantity of one type nonconformity per page (text must be legible in all cases)



Line on the page with LOGO > 5mm



Dirty area on body pages



Spot on LOGO cov > 1 mm²



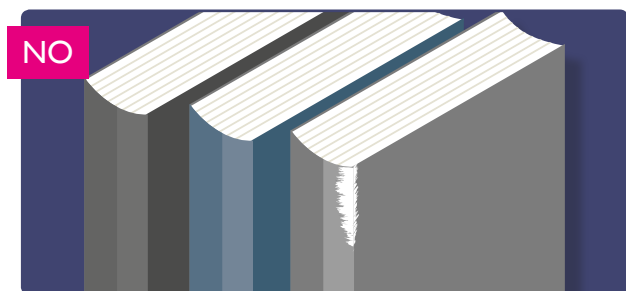
Water spot on cover

Tolerance range for mechanical nonconformities shows the table below.

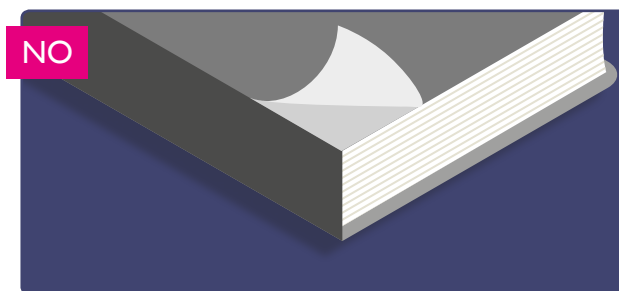
NON CONFORMITY	ASSESSMENT METHOD	PLACE	ACCEPTABLE	NOT ACCEPTABLE
TEARS, CRACKS, CHIPS	Measure length	COMMERCIAL* and EDITORIAL pages	max length <= 5 mm**	max length > 5 mm or n > 2
KNIFE SCRATCHES	Check quantity	COMMERCIAL and EDITORIAL pages	max n <= 3	n > 3
CRUMPLES, BENDS, WRINKLES	Measure length	COMMERCIAL pages	max length <= 10 mm, and n = max 10% of pages	length > 10 mm, or n > 10% of pages
		EDITORIAL pages	max length <= 30 mm, and n = max 10% of pages	length > 30 mm, or n > 10% of pages
BACKBONE WRINKLES	Measure length and width	COMMERCIAL pages	max width of single wrinkle <= 2 mm, max length of single wrinkle <= 20 mm max total length of all wrinkles <= 50mm	max width of single wrinkle > 2 mm, max length of single wrinkle > 20 mm max total length of all wrinkles > 50mm
HOLES, DOGS EARS	Check presence	COMMERCIAL pages	n = 0	n > 0

* commercial page means customer logo, cover, backbone, page or insert with a commercial

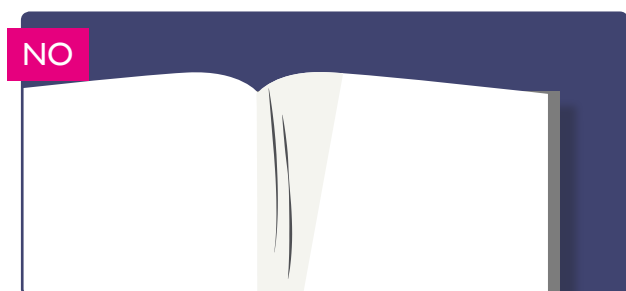
** n means acceptable quantity of one type nonconformity per page (text must be legible in all cases)



Length of both tears > 5 mm



Crack > 5 mm



Wrinkle on body page > 30 mm



Bends on the body page > 30 mm



Dog Ears



Torn cutting edges

7. COLLATION

Description of the book content specified in Job Ticket and Collation List is considered the main guideline. The book must have the collation, position and orientation of all forms and additional elements (inserts, onsets, gadgets etc...) conforming to guideline.

ACCEPTABLE	NOT ACCEPTABLE
Correct collation	Incorrect collation

8. STITCHING QUALITY

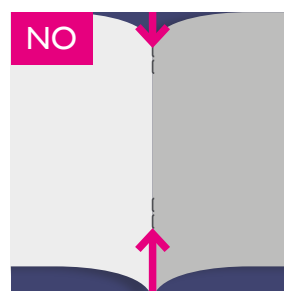
8.1. STITCHES POSITION

Description of stitches position specified in Job Ticket is considered the main guideline.

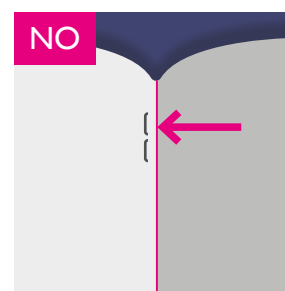
Stitches shall neither shift along backbone towards edges

nor rollover onto the back or front of the book. The tolerances for both vertical and horizontal move are given below

ACCEPTABLE	NOT ACCEPTABLE
Vertical shift ≤ 5 mm	Vertical shift > 5 mm
Horizontal shift ≤ 1 mm	Horizontal shift > 1 mm



Vertical shift > 5 mm



Horizontal shift > 1 mm

Additional STITCHING nonconformities:

- Closure too strong – cutting paper.
- Closure too weak – loosing pages.
- Stitch legs overlapping or legs' endings too much distanced.



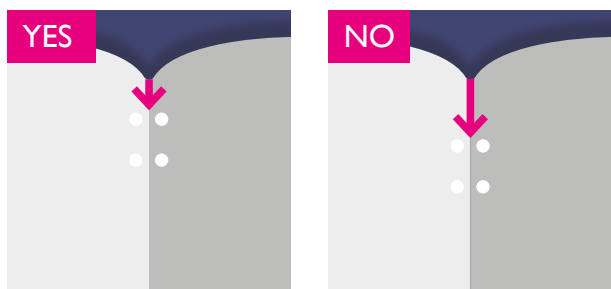
Incorrect stitch

8.2. LOOPS POSITION

Description of loops position specified in Job Ticket is considered the main guideline.

Loops shall neither shift vertically nor rollover horizontally but most critical for loops position is the ability to file the book in the binder. The tolerances for both vertical and horizontal move are given below.

ACCEPTABLE	NOT ACCEPTABLE
Vertical shift of pair of loops ≤ 3 mm	Vertical shift of pair of loops > 3 mm
Ability to file the book in the binder	Lack of ability to file the book in the binder
Horizontal shift ≤ 1 mm	Horizontal shift > 1 mm



9. STITCHING DURABILITY

9.1. INSTRUMENTAL METHOD

Instrumentally durability is verified using device called pull-tester that quantifies strength needed to pull out the page from the book.

Instrumentally stitching durability is verified in a following way:

- using pull-tester pull out from the book two central pages,
- obtained result divide by number of stitches in the book.

ACCEPTABLE	NOT ACCEPTABLE
result ≥ 2.5 N/stitch	result < 2.5 N/stitch

9.2. MANUAL METHOD

Manual method is to be applied in the absence of pull-tester.

Manually, durability is verified in a following way:

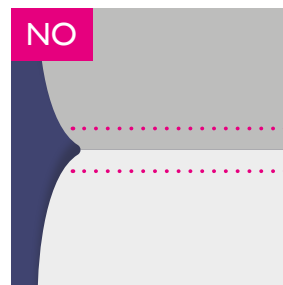
- hold the book by two central pages and shake with moderate strength,
- durability is considered appropriate if two central inside pages can bear the weight of the whole book even when shaken moderately.

10. PERFECT BOUND QUALITY

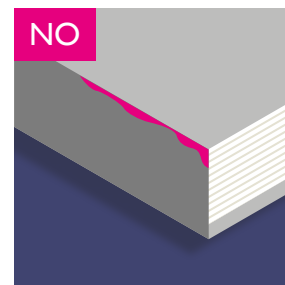
Perfect bound book shall possess properly done backbone as well as side gluing that together constitute a basic condition for fulfillment of durability requirements.

Additional PERFECT BOUND nonconformities:

- Glue layer not evenly spread onto the backbone or side strip (visible after cover tear-off).
- Glue missings visible by stronger book unfolding or along the trim line of the book.
- Glue flows out onto the page – glue drops visible onto the page.
- Lack of side gluing.
- Side gluing too wide.



Lack of cross seal



Glue flows out on the backbone



Glue flows out of the page > 1 mm

II. PERFECT BOUND DURABILITY

II.1. INSTRUMENTAL METHOD

Instrumentally, durability is verified using device called pull-tester that quantifies strength needed to pull out the page from the book.

Instrumentally, perfect bound durability is verified in a following way:

- using pull-tester pull out from the book 3 evenly spread pages for the book of backbone thickness ≤ 1 cm,
- using pull-tester pull out from the book 5 evenly spread pages for the book of backbone thickness > 1 cm,
- in the books with side gluing five the first and the last page of the book shall be excluded from pulling,
- obtained result divide by backbone length in cm.

ACCEPTABLE	NOT ACCEPTABLE
Single result ≥ 3.5 N/cm	Single result < 3.5 N/cm
Average result ≥ 4.5 N/cm	Average result < 4.5 N/cm

II.2. MANUAL METHOD

Manual method is to be applied in the absence of pull-tester.

Manually, durability is verified in a following way:

- hold the book by selected single page and shake with moderate strength,
- durability is considered appropriate if the page can bear the weight of the whole book even when shaken moderately,
- shaking repeat for 3-5 evenly spread single pages (in the books with side gluing the first and the last page of the book shall be excluded from shaking).



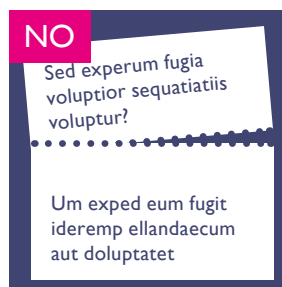
Falling pages

12. OTHER QUALITY PARAMETERS

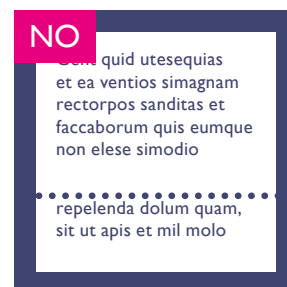
This section specifies quality guidelines for the set of most often ordered / appearing additional finishing elements. Quality parameters of any other finishing options not regulated in this section shall be separately agreed between the Customer and Walstead CE (see section Non standard production)

PERFORATION nonconformities:

- shift from specified target place by > 1 mm,
- inability to tear the element off along the perforation line,
- perforation already torn off.



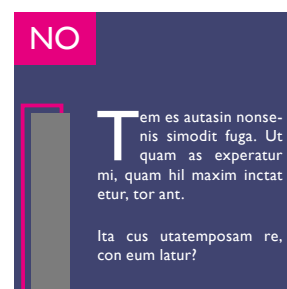
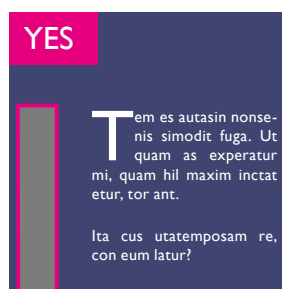
Perforation is torn off



Shift from the specified target place > 1 mm

REMOIST GLUE nonconformities:

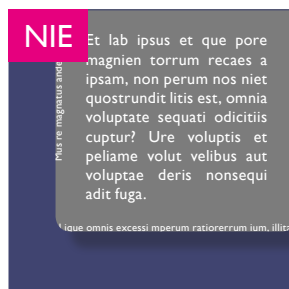
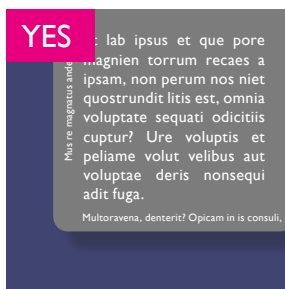
- shift from specified target place by > 1 mm,
- lack of glue strip continuity – holes, chips, missings in glue strip,
- glue after moistening does not hold the pages,
- glue before moistening hold the pages.



Shift > 1 mm

DIE CUT nonconformities:

- shift from specified target place by > 1 mm,
- element not fully cut,
- rough cutting edges.



Shift > 1 mm

INSERTING nonconformities:

- lack or excess of inserts,
- damaged inserts,
- insert location in the book different than specified,
- insert position and/or orientation on page different than specified.

Inserting on binding machines:

- shift up-down and right-left max. 5 mm; skewing max. 2 mm per 100 mm.

Sticker with liquid:

- shift up-down and right-left max. 5 mm; skewing max.

Thrown inser:

- cannot be binded,
- cannot be trimmed

Inserting on stitching machines: (machine insertion)

- insert 2pp - shift up-down and right-left max. 7,5 mm; twisting 1,15o
- insert over 2pp - shift up-down and right-left max. 10 mm; twisting 2,3o

Inserting on foil-inserting machines: sticker

- shift up-down and right-left max. 4 mm; skewing max. 4 mm

Onsert glued on machine,

- shift up-down and right-left max. 5 mm; skewing max. 1,5 mm per 100 mm.

Onsert „3D” glued on machine,

- shift up-down and right-left max. 30 mm for automatic binding; max. 10 mm in relation to the model

Onsert „3D” glued manually,

- shift up-down and right-left max. 30 mm

Thrown inser

- out of the format of a book: top down and front max. 2 mm

POLLYBAGING nonconformities:

- seam not fully holding,
- foil damages

13. PACKAGING AND SHIPPING

Packaging description specified in Job Ticket is considered the main guideline. In the absence of special Customer requirements Walstead CE applies their own internal packaging standards.

Packaging method shall be adjusted to product characteristics in order to ensure protection against potential damages while storing and transportation. The packed pallet shall be marked in the way enabling product identification.

14. NON STANDARD PRODUCTION

Non standard production mean every product or service that either is not regulated by this document or considering special requirements of the Customer cannot meet the specified in this document tolerances.

Non-standard requirements shall always be discussed and agreed separately between customer and Walstead CE.

Agreed standards shall be based on Walstead CE experience and/or performed tests and shall be clearly stated in the contract or any other quality document signed by the customer and Walstead CE prior to production.

15. ACCEPTANCE CRITERIA

The delivery is considered conforming (fulfills the requirements of the Customer) if 99.5 % of the product possesses all quality parameters within the acceptable tolerance ranges specified by this document.



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