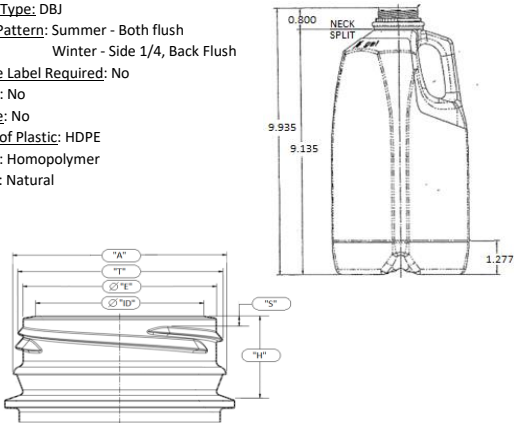

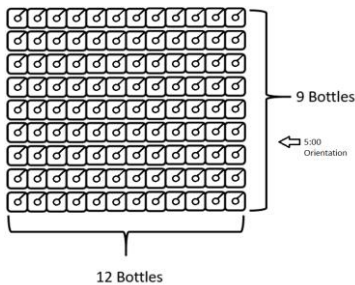




Bottle Specification (VF06404)
Version 1 Issued: 14 August 2018

Product Information: VF06404 Buyer Name: Vitco Foods Bottle Type: 64 oz DSQ Neck Type: DBJ Plug Pattern: Summer - Both flush Winter - Side 1/4, Back Flush Bottle Label Required: No UPC#: No Flame: No Type of Plastic: HDPE Resin: Homopolymer Color: Natural	
	Bottle Dimensions Weight: 45 ± 2 Grams Height: 9.935" Width: 3.299" "ID": 1.168" ± .005" "T": 1.415" ± 0.005" "E": 1.346" ± 0.005" "H": 0.5975" ± 0.0145" "S": 0.080" ± 0.005" "A": 1.48" ± 0.005"
Set Up Line Number: 6 Cavity Numbers: 1, 2, 3, 4, 5, 6 Crew Required: 0.5 Operator, 0.5 Packer, 0.25 Utility Equipment Specs: See Master Run Sheet	Neck Tooling Master: A20001 Shear Steel: AKS-13273 (1.212) Neck: AKS-32492 Blowpin Head: AKS-40008 (1.210) Blowpin Shaft: PullUp AKS-40071
Packaging Units per Bag: 108 Layers Per Pallet: 8 Units per Pallet: 864	Bill of Materials Cardboard Slip Sheets: Yes (36"x48" each layer) Shrink Wrap: No Cable Straps: No Bag: Green Film (Hand Packing), Clear Film (Bagger) Bundle with Large Cardboard: No Corner Boards: No Sleeve: No

Pallet Configuration Make sure every handle is in the correct orientation 5:00 	Layer Pattern: 9 rows of 12 bottles. 
Special Instructions Check thoroughly for defects, especially in the neck. Perform extra drop tests when necessary.	
Proper Neck: 	Defected Necks: 



Complaints and Corrective Actions		
Number	Reference	Description
(1/11/2017)	Leaking Bottom	Several instances of leaking. Check quality more thoroughly; ensure proper line clearance. Perform extra drop test if defects such as water spots,
2018018	Measurements	Small ID measurements. Check machine parameters every shift, and request adjustments from operator if checks fail.
(1/17/17)	Streaks	Ensure appropriate temperature control in production line. Check quality more thoroughly; ensure proper line clearance.
(4/21/17)	Neck Problems	Neck problems during production. Maintain bottle weights as weight affects the bottle neck. Ensure first piece inspection is in spec. Refer to blow time, exhaust time, and cycle time in spec run sheet.
Shipping Instructions		
Line 6: White tags Number of bags per stack in trailer: 10 Number of bags in trailer: 360 Pivot stacks: No Orientation in Trailer: 18 rows of 2 columns Floor loaded or on pallets: Floor		
Revision History		
Number	Date	Description
Rev 0	August 14 2018	Document Creation