

# Test Procedure Guidelines

## Test Method: **STORAGE & HANDLING CONDITIONS FOR IN-MOLD**

### PURPOSE OF PROCEDURE:

To outline recommendations of storage and handling conditions for In-Mold substrates in all forms (sheets, rolls, labels, printed and unprinted).

### SCOPE:

Applies to all In-Mold substrates in any format.

### DEFINITION OF TERMS:

N/A

### EQUIPMENT/MATERIALS NEEDED:

As required.

### TEST PROCEDURE:

Storage of materials should be maintained within the following guidelines:

1. Ambient Conditions:
  - a. Temperature: Maintain storage at 72E F plus or minus 5 degrees (22°C +/- 2°C).
  - b. Humidity: 50% R.H. plus or minus 10%.
  - c. Temperatures that exceed these limits will have a detrimental effect on the material.
  - d. Effects worsen with higher temperature, humidity, and longer periods.
  - e. Materials stored under conditions other than these are suspect.
2. General Handling:
  - a. Do not double tier pallets or rolls.
  - b. Ship rolls in a poker chip fashion (laying flat), not in a rolled position.
  - c. Store supplied materials in a clean and moisture free environment. Follow instructions supplied by the manufacturers.
  - d. When ambient temperatures exceed limits listed above, refrigerated trucks are preferred for shipping.
  - e. Maintain the lowest amount of tension in rolls, but still achieve a constant stable roll.
3. Inks and Coatings:

Follow manufacturer's guidelines for temperature, exposure and shelf life.

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#### 4. Stock Rotation:

First In, First Out (FIFO) should be practiced on all materials. Always follow suppliers' guidelines and recommendations for shelf storage life and usage of material.

### **DOCUMENTATION:**

Consistent with good manufacturing practice.

### **REFERENCES:**

1. These procedures are guidelines and recommendations to achieve optimum performance of all materials associated with In-Mold labeling.
2. These recommendations were compiled from material suppliers, ink and coating manufacturers, converters, and blow molders.