

Certificate of Analysis

Customer Mat.No.:	Customer Order No.:	Producer Mat. No.: 1648118103
Capacity: 1000	Material Description: SYRUP BOTTLE AMBER 1000 ML SAF HK	Colour: amber
Lot-Nr: 20160802	Production date: 02.08.2016 - 03.08.2016	Produced quantity: 64.320

Pallet nbr: 000001 to 000134 à 480

1. Material- / Article properties

	specification	result				
1.1. Particles & Germs						
Particles	HG/01	complied				
Germs	Ph.Eur.	complied				
1.2. Glass quality / Hydrolytic res.						
Moulded Glass	YES					
Glass type per last issue Ph-Eur/USP/JP	Typ 3					
Arsen content Ph.-Eur.3.2.1	<0,1ppm	complied				
Ph.EU.3.2.1 SurfaceGlassTest (A)	complied					
	Req.:	Act: x	Act: min	Act: max	Unit	
Ph.EU.3.2.1 Spect.Transmiss. MAX	+10,00	2,89			%	

2. Material specification

Drawing:78873 Vs: ChDat: 020711

2.1. Technical specification (drawing)

	Req.:	Act: x	Act: min	Act: max	Unit
Overall height	217,00 +1,30	217,25	216,67	217,78	mm
Entry of mouth Ø (BoreØ)	20,00 +0,30	20,11	20,04	20,15	mm
Core diameter Ø	24,90 +0,30 -0,35	25,11	24,99	25,20	mm
Thread Ø	27,10 +0,30 -0,35	27,07	26,90	27,20	mm
Diameter of crimp	27,70 +0,30 -0,35	27,69	27,57	27,83	mm
Finish height (Chamfer)	15,40 +0,25	15,61	15,56	15,65	mm
Body	97,50 +1,50	97,66	96,73	98,27	mm
Perpendicularity	+4,30	1,08	0,50	2,00	mm

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Glass weight	515,00	517,40	511,60	522,50	g
Brimfull capacity	1.021,00 +-8,00	1.024,28	1.020,60	1.027,70	ml

2.2. Surface treatment

Coating Hot End & Cold End	Hotend TC100/Coldend RP40LT				
	Req.:	Act: x	Act: min	Act: max	Unit
Coating thickness HG/02	30,00 +-10,00	29,50	28,00	32,00	CTU
Angle of slip HG/03	13,00 +-5,00	15,50	12,00	18,00	deg

2.3. Strength tests


Thermal shock DIN EN ISO 7459	complied
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2.4. Visual tests

Lot size N (pieces)	number of pallets (minimum number)	Numbers of shipping units to be opened (Min)	Number of individual pieces to be removed	Random sample size N
10.001 - 35.000	1	15	21	315
35.001 - 150.000	2	20	25	500
150.001 - 500.000	3	25	32	800
> 500.000	5	30	41-42	1250

Herewith we confirm that the quality of the containers mentioned above does comply with the valid testing standards in compliance with specifications and drawing detailed and the defect evaluation list for containers made from Moulded Glass, Vol. 14 (Editio Cantor Verlag, Aulendorf). The inspections have been carried out based on the current Pharm. Eur. USP and JP, the valid tolerances have not been exceeded.

Beriain, 7th April 2018

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