1.0 INTRODUCTION

1.1 SCOPE

1.1.1 This document sets forth the general and detailed requirements for the acceptance of card stock which is used to produce data processing cards.

1.1.2 Objective: To clearly define the general and detailed requirements for the acceptance of card stock from a supplier who has been considered qualified by IBM.

1.2 REFERENCE

1.2.1 Engineering Specifications

894 502 DP card stock, 7 point.

1.2.2 Quality Specifications

7-02-0101 card stock, 7 point data processing

1.2.3 Standard Test Methods

IBM 9-01-0201 Basis Weight
IBM 9-01-0202 Thickness
IBM 9-01-0203 Bursting Strength
IBM 9-01-0204 Stiffness
IBM 9-01-0205 Folding Endurance
IBM 9-01-0206 Folding Endurance after Aging
IBM 9-01-0207 Tearing Resistance
IBM 9-01-0208 Air Resistance
IBM 9-01-0209 Smoothness
IBM 9-01-0210 Sizing
IBM 9-01-0211 Per Cent Ash
IBM 9-01-0212 Acidity (pH)
IBM 9-01-0213 Coefficient of Friction
IBM 9-01-0214 Curl
IBM 9-01-0215 Moisture Content
IBM 9-01-0216 Expansion and Contraction
IBM 9-01-0217 Conductive Particles
IBM 9-01-0218 Resistance to Abrasion
IBM 9-01-0219 Electrical Resistance
1.3 AUTHORIZATION

1.3.1 This document is authorized by the Managers of IR Manufacturing IBM Europe and IBM IR Quality Engineering Laboratory.

2.0 ACCEPTANCE PROCEDURE

2.1 SAMPLES FROM THE BATCHES

2.1.1 Size: Sample strips taken across the width of shipping rolls. Length according to width of shipping rolls. Width 22 – 25 cm.

2.1.2 Frequency of Sampling: One roll from the top set of each mill reel produced, starting with the front of the paper machine and moving to the back of the paper machine one roll at a time. For example: The front roll from the first mill reel, the center roll from the second mill reel, the back roll from the third mill reel and so on if the mill reel is more than 3 rolls wide.

2.1.3 Quantity: One sample strip per shipping roll, however, in cases of small production runs at least 30 samples strip per batch.

2.1.4 Finishing of Sample Strips: All roll data shall be stamped on wireside. The strips shall be wrapped moisture proof and be protected by an outer cover of strong card board or ply wood.

2.1.5 Destination of Samples: All samples shall be sent via air freight to:

IBM Germany
IR Quality Eng. Lab.
dep. 709

703 Boeblingen
Herrenberger Str. 134
2.2 RELEASE

Unless otherwise agreed, each batch shall be held at the mill until after the samples have been tested and permission given to ship the batch to the respective IBM Card Plant.

2.3 MILL DATA SHEETS

2.3.1 Copies of all mill data sheets for each batch shall be submitted with the samples to IBM IR Quality Eng. Lab.

2.4 DETAILED REQUIREMENTS

2.4.1 All samples tested shall meet the requirements listed in Quality Specification 7-02-0101.

2.5 DISCREPANCIES IN TEST RESULTS

2.5.1 Any significant discrepancies in test results between the mill and IBM must be resolved as quickly as possible.

2.6 REPORT

2.6.1 IBM will issue a report of the test results. This report will designate whether a batch can be accepted or not.

2.7 REJECTION OF PAPER

2.7.1 Unless otherwise stated all paper out of Standard Specification can be rejected by IBM.

2.7.2 Depending on the amount of defective paper IBM can reject runs/batches, rolls, reels (cheeses) and cards.

2.7.3 If the rejection is based on sample strip testing the supplier reserves the right to ask for roll testing.

In case of roll testing, all expenses are charged back to the supplier if the cards cannot be shipped to IBM customers.
2.7.4 In the event a run/batch is rejected, it will be the responsibility of the supplier to either screen (sort out) all paper or dispose of the entire batch.

If the paper mill decides to screen the paper each and every roll must be tested for the failed characteristic. Results of these tests must correlate with IBM tests. Upon satisfactory correlation, the mill test data will be accepted as certification that the screened rolls are acceptable.

2.8 CARDPLANT REJECTIONS

2.8.1 IBM reserves the right to reject any defective paper found during the card manufacturing operation.

2.8.2 No claim shall be allowed for consequential damage.

2.8.3 IBM customer complaint. Defective cards rejected by IBM customers cannot be claimed back to the supplier unless they are from a preceding shipment of cardstock which has been accepted by IR Quality Eng. Lab. with off-specification.

2.9 COMMUNICATIONS

2.9.1 All communications shall be handled through IBM IR Quality Eng. Lab.