



IR  
QUALITY ENGINEERING  
LABORATORY BÖBLINGEN

Title: CARD STOCK ACCEPTANCE  
PROCEDURE

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 5o2 DP card stock, 7 point.

1.2.2 Quality Specifications

7-o2-o1o1 card stock, 7 point data processing

1.2.3 Standard Test Methods

IBM 9-01-o2o1	Basis Weight
IBM 9-01-o2o2	Thickness
IBM 9-01-o2o3	Bursting Strength
IBM 9-01-o2o4	Stiffness
IBM 9-01-o2o5	Folding Endurance
IBM 9-01-o2o6	Folding Endurance after Aging
IBM 9-01-o2o7	Tearing Resistance
IBM 9-01-o2o8	Air Resistance
IBM 9-01-o2o9	Smoothness
IBM 9-01-o21o	Sizing
IBM 9-01-o211	Per Cent Ash
IBM 9-01-o212	Acidity (pH)
IBM 9-01-o213	Coefficient of Friction
IBM 9-01-o214	Curl
IBM 9-01-o215	Moisture Content
IBM 9-01-o216	Expansion and Contraction
IBM 9-01-o217	Conductive Particles
IBM 9-01-o218	Resistance to Abrasion
IBM 9-01-o219	Electrical Resistance

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PROCEDURE**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.  
dept. 709

703 Boeblingen  
Herrenberger Str. 134

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QUALITY ENGINEERING  
LABORATORY BÖBLINGENTitle: CARD STOCK ACCEPTANCE  
PROCEDURE

## 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.

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LABORATORY BÖBLINGENTitle: CARD STOCK ACCEPTANCE  
PROCEDURE

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.

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9-15-69  
Date

Revision Change

Page 4 of 4