

Prelaminated card Inlays with transparent window for ID1 cards

Specification of quality inspection

ANNEX 3 to the Framework agreement for production and
supply of prelaminated card inlays with windows for ID1 cards
No. 052/OS/2023

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1 General description

The technical specification of the prelaminated card inlay with transparent window is included in the Annex_1 of the Framework agreement. Transparent windows are placed on prelaminated polycarbonate sheet 295x330 mm, with 15 positions of ID1 card (arrangement 3x5). The tolerance of the transparent window position is ± 1 mm in x and y axis (tolerance of the center of the window to the right registration mark, closer to the reference sheet corner). Deliveries of the sheets cannot start before the approval of Pilot sheets by the Client.

1.1 Nominal, Limit and Quality Samples

For the purpose of this Annex_3 the terms “Nominal Sample”, “Limit Sample” and “Quality Sample” shall have the following meaning:

Nominal, Limit and Quality Sample are laminated samples of sheets with whole card composition and printed design to do quality tests. The Contractor will provide to the Client sheets for preparing Nominal and Limit Samples. During the First Delivery both Contracting parties shall jointly approve sheet samples, Nominal and Limit samples for a Defect catalogue, which will be used as the basis for evaluation of possible claim. These samples will be used as a standard to compare the quality of the delivered Sheets.

“Nominal Sample(s)” shall mean the standard for the DL cards production (nominal quality reference).

“Limit Sample(s)” shall mean the quality reference for still acceptable defects. These samples will be agreed upon by both Parties. „Limit Sample“ will be established according to the Limit values for stated parametres, listed in the table below.

“Quality Sample(s)” shall mean samples which are produced from each production batch by the Client and is compared to the Nominal and Limit sample.

“Limit values” shall mean the degree of acceptability of deviations from the perfect condition (nominal quality reference). If the controlled parameter extends the Limit value, then it is a defect that by its nature impairs the appearance or functionality of the DL card.

Table of Limit values:

No.	Evaluated parametr	Method of evaluation	Limit value of acceptability
1	Sheet size	Measuring device	must correspond to the Technical drawing*
2	Position and design of transparent windows and registration marks on the sheet	Measuring device	15 ± 0 pcs of transparent window on the sheet, must correspond to the Technical drawing
3	Partly or fully missing transparent window	Visually with the naked eye/machine reading	Not acceptable
4	Contamination	Visually with the naked eye /machine reading (evaluated on non laminated sheet)	No impurities in the card photo area is acceptable. Impurities in the rest of card: max 1 loose particle ≤ 1 mm ² for each sheet.
5	Negative flaking**	Visually with the naked eye /machine reading	≤ 0.1 mm
6	Positive flaking ***	Visually with the naked eye /machine reading	≥ 0.1 mm
7	Lamination defects	Visually with the naked eye /machine reading	Single defects ≤ 0.5 mm ² , no lamination defects in the photo area is acceptable

*Technical Drawing is included in Technical specification - Annex No. 1 of the Framework agreement

** Negative flaking – missing parts of the transparent window in relation to the defined shape

*** Positive flaking – parts of the transparent window, which are over to the defined shape

Measuring device is a transparent control film with printed sheet edges, register marks, transparent window positions and according the Technical Drawing. The measuring device will be made by the Contractor and provided to the Client before the first delivery.

The table of limit values can be supplemented/modified only after the agreement of both parties, regarding the production technology and its limits.

1.2 Defects and Defects catalogue

Defect catalogue will be used to store agreed Nominal and Limit samples and non-laminated sheet samples used for Nominal and Limit samples preparation.

If any new defect arises during the production of sheets, the Contractor has to notify the Client without any delay. The new defect will be add to the Defect catalogue and the Contracting Authority will evaluate, if the new defect and to what extend is acceptable or unacceptable. If a new quality limit will be approved, the defect catalogue has to be supplemented by the new Limit samples. The validity date for the new quality limit must be mutually agreed by the Parties.

2 Acceptance of deliveries and test procedures

2.1 Outgoing Inspection Contractor

The Contractor will provide the quality control for each production batch in minimum scope of controlled parameters according to the table of Limit values stated in the Article 1.1 above. The Contracting Authority does not require a lamination test to be performed.

As proof that the delivered products has been duly tested and declaration that the delivered products meets all stated parameters, the Contractor fill the Certificate of Conformance and send to the Client with each production batch.

2.2 Incoming control at the Client

After each delivery the Client will perform the receiving inspection test (standard AQL quality inspection). The nonlaminated sheets will be controlled according conditions stated bellow and also the Quality samples will be prepared and compared with the Nominal and the Limit Sample. Then the Certificate of Conformance will be filled, if some of limit values will be exceeded, so such material will be considered insufficient and and will not be released for production. The sheets for receiving inspection are performed by the ISO 2859-1, the single sampling plans for normal inspection, general inspection level II. The sheets are controlled according to parameters (defect description/test methods and limit values) specified in the Certificate of Conformance. The result of each inspection test shall be supplied to Contractor on request.

2.3 Procedure for defects

If the actual results during the Client incoming quality control or production of DL card, deviate from the Limit values, stated in the Article 1.1 above (the limit values will be exceeded) or a new defect appear, the Client will immediately inform the Contractor without any delay. In such a case, information regarding type of defect, the control number (label with detailed batch number) and photos of the defects will be electronically sent to Contractor and the Complaint is initiated.

The Client shall send back defective Sheets, as well as laminated Quality Samples on request by Contractor. The material will tread according the security rules and limited people do have access to the material from the Client.

Control Numbers, subject to a notice of defect, will not be released for production, and will be stored separately until the Complaint is closed.

3 Attachment No. 1 – Draft of Certificate of Conformance, AQL report

CERTIFICATE OF CONFORMANCE – AQL protocol

Prelaminated cards inlays for ID1 cards with transparent window/ Protocol number:

Project:

Number of production batch:

Delivered quantity:

Code of selection/ Volume of controlled sheets:

Delivery date:

We confirm that the above product has been properly tested according to our internal testing procedures and declare under our sole responsibility that the results meet the standard that has been defined for this project.

The AQL value for all deliveries is according to DIN ISO 2859-1 as **0.65 normal test method, level II**, for all tests except the test method regarding the number of elements per sheet and the completeness of the design.

Test method	Limit values	Number Y / N	Y / N
Product dimensions + presence of registration marks	According the Technical drawing/control film		
Position of transparent window	± 1 mm /control film		
Lamination test	Limit sample		
Contamination/Impurities	max.1 loose particle ≤ 1,0 mm ² per sheet		
Negative flakings	≤ 0,1 mm		
Positive flakings	≤ 0,1 mm		
Lamination defects	Single defects ≤ 0.5 mm ² , no lamination defects in the photo area is acceptable		

The AQL value for the test method regarding the number of elements and the completeness of the design for supplies are according to DIN ISO 2859-1 as **0.025 normal test method, level II**.

Test method	Limit values	Test result
Number of transparent windows on the sheet	15 ± 0	
Missing, incomplete design	According aproved design/ technical drawing	

Delivery accepted : yes

Delivery accepted: no

The inspection was performed by:

Date: