



Appendix 3: Test Guidelines

Criterion – machine tests.

The third criterion for selecting the machine will be tests carried out by the bidder on a machine corresponding to the subject of the inquiry and consisting of:

Test No. 1. - Print Test

Task: Print the template shown in Annex 4 in the following configuration:

Material: white foil PP60 CAVIT TOP WHITE-S692N-BG40WH FSC or equivalent in width 430 mm,

Print repeat: 304.8 mm (96Z)

Colors: CMYK + Pantone 3537C + Pantone 7545C

Flexo plate screen ruling : 175 Lpi

Anilox volumes:

CMYK – 3 cm³/m²

Pantone 3537C – 8 cm³/m²

Pantone 7545C – 6 cm³/m²

The test must include the following steps performed one after the other:

1. Print setup – there is unprinted material on the machine and the printing cylinders are not mounted, the operator mounts the printing cylinders in a random rotational position and starts printing and registering colours in the following order:

1. Cyan
2. Magenta
3. Yellow
4. Black
5. Pantone 3537C
6. Pantone 7545C

using the automated registration system to the marker printed at the first station (Cyan). The print will be considered registered when the registration mark meets the guidelines shown in Appendix 7 – Print Registration. After confirming that the print is registered correctly, proceed to the next stage without stopping the machine.



2. Speeding up printing

a) the operator accelerates the machine to 30 m/min and after reaching this speed, he sticks a color marker (color blue) onto the roll at the winding point. Then maintains the printing speed for one minute and during this time operator can make additional registration corrections.

b) Without stopping the machine, the operator accelerates to 60 m/min and repeats the steps from point a. and sticks marker of the appropriate color. Keeps printing 60 m/min again for 1 minute.

c) Operator accelerates to 120 m/min, inserts another marker and again maintains the printing speed for 1 minute, corrects the registration if necessary.

Marker colors:

30 m/min – blue marker

60 m/min – green marker

120 m/min – yellow marker

3. Start-Stop Test

At the end of stage 2, the machine prints at 120 m/min. The operator stops the printing by pressing the STOP button. Once the machine stops, the operator applies a red marker to the roll at the winding point and restarts the machine by pressing the START button without changing the set speed. The machine must accelerate back to 120 m/min and print at this speed for 30 seconds. During this time, the operator can correct the registration to minimize material waste. After 30 seconds of printing, the operator proceeds to the final stage without stopping the machine.

4. Maximum speed

In the final stage, the operator accelerates from 120 m/min to the maximum print speed. Once this speed is reached, the operator maintains this speed for 30 seconds. After this time, the machine should be stopped, the printed roll cut, and sent for evaluation. While printing at maximum speed, a close-up of the machine panel should be filmed to show the speed achieved. The print test must include one continuous roll without cutouts, on which a test consisting of the steps listed above has been printed in sequence, as well as a video showing the test execution, including the moment of inserting the markers referred to in the guidelines above. The video must be produced continuously as a single recording of all test elements. The submitted printout and video will be analyzed, and the measurements will be recorded in Appendix 6 – Print and Die-Cutting Test Analysis Report (Parameters 1-5).

Test No. 2 – Die cutting Test

Task: Cutting labels with a rotary die-cutter in a shape consistent with the drawing in Appendix No. 5 at the maximum possible speed that the machine can maintain without breaking the matrix for 1 minute.

Material: **MC PRIMECOAT FSC-S2045N-PET23** or equivalent (Coated paper with rubber adhesive on a 23 micron PET backing)

Maximum material width: **320 mm**

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A video must be submitted of the die-cutting test, showing the operator tearing the material by hand before starting the test (proving the material is paper). Then, without stopping the recording, the operator proceeds to die-cutting the labels, accelerating the machine to its maximum possible speed, at which the machine can die-cut labels without any problems for at least one minute. The entire minute of operation must be recorded, including a close-up of the machine speed display panel. The submitted video will be analyzed, and the results will be recorded in Appendix 6 – Print and die-cutting test analysis report (parameter 6).