

**DESCRIPTION of the manufactured COMPONENTS
And their manufacturing PROCESS**

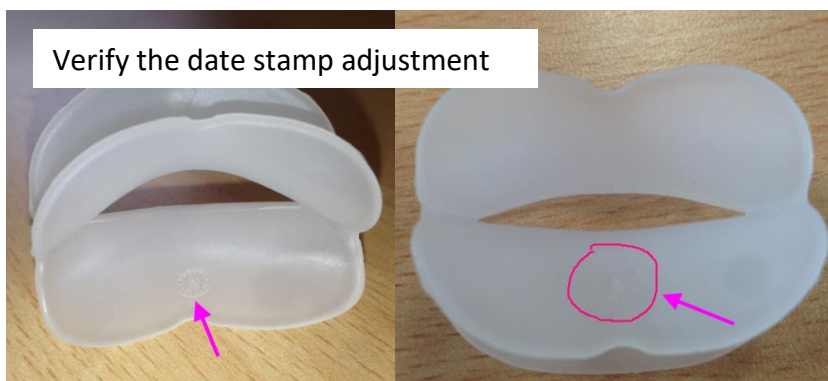
THE FROGGY MOUTH

MATERIAL : TPE 80SH - Pharmaco

COLORS : Natural - translucent

Preparation and Mold assembly Ref : 4349

- Assembly of the versions in the frame.
- Assembly on the press
- Verify the date stamp adjustment (cf photos below)
- Greasing and Protection of the Imprint/slide versions to the PJ before closing the mold at the end of the production before disassembly on the press



Injection process :

- Heating of the press / Purge of the screw with an adapted cleaning product
- First Injection/item production
- Control and side-lining of the 30 first injections
 - Visual quality control at the production start-up and every 1000 cycles:
 - No deformation
 - No flow stain
 - No bubble
- drop off by gravity on the mat for temporary packaging

The BOX

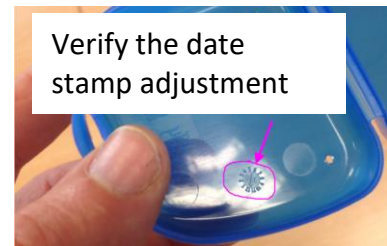
MATERIAL (box): PPR 10232 come from France food contact conformity

COLORS: M219426 blue 2%, M219427 red 2%, M219428 purple 2% food contact conformity



Preparation and Mold assembly Réf/ 3017:

- Assembly on the press
- Verify the date stamp adjustment
- Greasing and Protection of the Imprint to the PJ before the mold closes at the end of the production



Injection Process :

- Heating of the press / Purge of the screw with the cleaning product
- First Injection/Item production
- Control and side-lining of the 30 first injections.

Visual quality control at the production start-up and at the end of the cycle:

- The colour with the standard sample
- Flexibility and deformation of the hinge and its clip with a 10 boxes test
- No flow stain



- drop off the items on the mat for temporary packaging



TECHNICAL FORM FROGGY MOUTH 2017

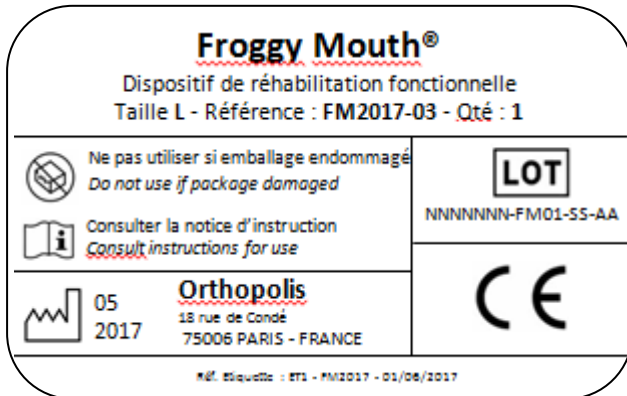
DQDESCRIPTION of the bought COMPONENTS:

The SMALL PACKET

PE clad – width of 80 Ep 30 or 50MI food contact conformity
1 side weld or not – weldable by thermal bar

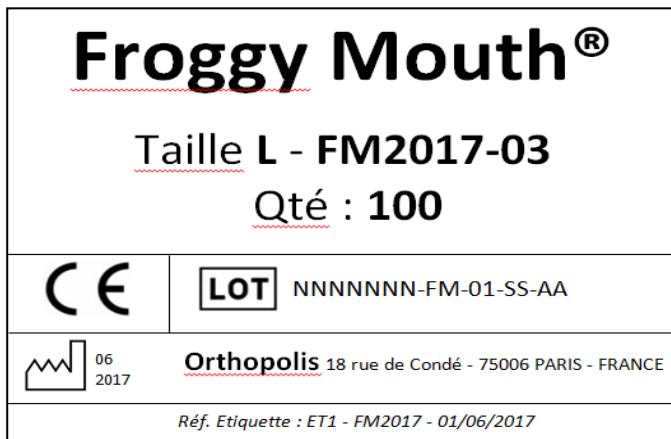
LABEL of the BOX

Dimension: 45x30 with curved angles



The LABEL of the CARDBOARD BOX

Dimension: 99,1 x 139 mm without curved angles





TECHNICAL FORM FROGGY MOUTH 2017

The INSTRUCTIONS

XXXXXXX

FABRICATION RANGE of the 2017 FROGGYMOUTH

The BAGGING :



The LABELLING on the box:





TECHNICAL FORM FROGGY MOUTH 2017

The PACKAGING:





TECHNICAL FORM FROGGY MOUTH 2017



The PACKING :

The packaging is planned by 100 in 1 SIMPLE CARDBOARD BOX with 39 x 29 x 18 cm dimension



The CARDBOARD BOX LABELLING:



ORTHOPOLIS - 18 Rue de Condé - 75000 PARIS France
Tél : xx xx xx xx xx - Fax : xx xx xx xx xx - Messagerie : xxx@xxxx