

ams OSRAM

Packaging Requirements

**Prepared by the ams OSRAM packaging department.
This guideline provides standards for packaging into ams OSRAM Facilities and Logistic Center.**

Objective

- The purpose of this document is to ensure safe transportation, the quality of packaging, the use of sustainable materials, and smooth and cost-optimized implementation of packaging components.
- The responsibility for ensuring the quality of the shipped product including packaging remains with the supplier during the entire supply chain.
- All local regulations must be complied with.
- The ams OSRAM Packaging Requirements replaces the previously valid documents ZQR 2146009, ZQR 2125736 and ZSP 2023688.

Scope and validity

- **Geographically**
Global
- **Organization**
OSRAM GmbH

Contacts and validity

- **Owner**
Oliver Stahl
- **Expert**

- Silke Burmeister	- Pian Guan	- Jessica Greene
- Franziska Friedrich	- Surinder Gupta	- Marjorie Sheris
- Horst Gedack	- Herman He	
- Stefanie Winter	- YanLing Mai	
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1. General

1.1. Description

As an integral part of ams OSRAM the “Global Supplier Requirements” provide the details on how to do business with ams OSRAM. The ams OSRAM Global Packaging Requirements and the “Standards for Delivery of Goods” (see chapter “Standards”) specifies the packaging /shipping standards for material being packed and shipped to ams OSRAM.

The requirements in this document are considered as an addendum to ams OSRAM Purchasing Terms & Conditions. Unless otherwise agreed in writing, in case of any conflict between this document and ams OSRAM Purchasing Terms & Conditions, the Purchasing Terms & Conditions shall prevail.

1.2. Applicability & Scope

This Standard shall apply to all worldwide activities of ams OSRAM and all deliveries to worldwide destinations of ams OSRAM. This document is part of the currently valid purchasing agreement between the supplier and ams OSRAM and states binding requirements for supply chain processes and procedures. Except otherwise explicitly specified in the currently valid purchasing agreement, the supplier shall undertake to meet the requirements stated in this standard.

If any of the provisions of this document is ineffective, the other provisions of this document shall remain in full force and effect.

These requirements apply to:

- Packaging departments at ams OSRAM,
- Other departments at ams OSRAM, which source packaging or packed products,
- External suppliers (packaging or packed products) and
- Contract packers, which source packaging or packed products.

1.3. Responsibilities

- The supplier is responsible for the quality and delivery of the products and therefore also for compliance with these packaging requirements. In order to ensure safe handling (in accordance with accident prevention and other regulations) and smooth operations, it is essential for all goods to be delivered in accordance with the requirements stated in this document.
- This document defines packaging procedures and functions. It describes the most important requirements for packaging material and the aspects to be considered when creating/ developing packaging concepts.
- It is the supplier’s responsibility to provide individual and/or collective packaging for the goods. The packaging provided by the supplier must ensure that the goods reach their destination in sufficient condition.
- The packaging must, among other things, protect the goods in transit from damage and from deterioration caused by environmental influences. The packaging must also protect personnel against hazards resulting from the goods themselves (e.g. regulations concerning the handling of hazardous goods).

2. Quality and Tolerances for Packaging Material

- For ams OSRAM packaging and packaging components certain general tolerances must be met. This is due to a variety of conditions, which may occur during the production process. The tolerances must not be taken into account when determining the internal dimensions, as the internal dimensions are defined as minimum dimensions. The supplier must set the tools/settings so that the internal dimensions are achieved taking into account his manufacturing tolerances.
- The tolerances are used only as acceptance criteria for quality control and not used for palletizing schemes. For palletizing and classification of materials the nominal values are used as before. This tolerance applies only to the outer dimensions and tooling lines, measured under standard climate (23 °C/50 % humidity).
- These tolerances apply to standard packaging. Special requirements for tolerances are described in the packaging specification. Values written in the packaging specification overrule these general tolerances. Parts made from foam or handmade parts require such special tolerance values.

2.1. Boxes made from corrugated fiberboard or corrugated plastic

- Creasing tolerances

Distance between 2 parallel lines

- up to 300 mm: ± 2 mm (*up to 11,8 inch: $\pm 0,08$ inch*)
- 301-700 mm: ± 3 mm (*11,8 inch - 27,6 inch: $\pm 0,12$ inch*)
- over 700 mm: $\pm 0,5$ % (*over 27,6 inch: $\pm 0,5$ %*)

- Gluing tolerances

Of die cut

- BC flute: - 4 mm to + 6 mm (*0,16 inch – 0,24 inch*)
- C flute: ± 4 mm (*$\pm 0,16$ inch*)
- B flute: ± 3 mm (*$\pm 0,12$ inch*)
- E flute: ± 2 mm (*$\pm 0,08$ inch*)

- Size tolerances

Of the die cut due to production method

- Flat bed die cut: ± 2 mm (*$\pm 0,08$ inch*)
- Rotary cut: ± 3 mm (*$\pm 0,12$ inch*)
- Inline (slotted): ± 3 mm (*$\pm 0,12$ inch*)

2.2. Boxes made from paperboard or solid fiberboard

In general, a tolerance of $\pm 0,5$ % applies to all thicknesses and materials, but a maximum of ± 1 mm (*$\pm 0,04$ inch*), due to gluing and production.

2.3. Parts and sheets made from plastic

Applicable for all shapes and production methods (without gluing).

All thicknesses and materials according to ISO 2768-1 Table 1: Permissible deviations for linear dimensions (tolerance classes: f, m, c, v).

2.4. Other packaging materials

According to specification defined or agreed by ams OSRAM packaging department.

3. Sustainability

3.1. General

For ams OSRAM it is important to continuously improve and harmonize the packaging material in cooperation with our suppliers. Whenever a supplier identifies an improvement opportunity to reduce and avoid packaging material, this must be brought to the attention to ams OSRAM packaging department.

- ams OSRAM tries to avoid packaging material wherever possible.
- Generally, parts must be packed in such a way that the use of packaging material is kept to a minimum while adequately protecting the product.
- ams OSRAM has clear guidelines for the design and procurement of packaging:
 - All packaging should be made of environmentally friendly materials or recycled raw materials that can be easily recycled or disposed of.
 - Whenever possible paper-based packaging should be preferred to plastic packaging.
 - Whenever possible reusable packaging should be preferred to single use packaging.
 - In general, we follow the principle of the circular economy, in which recycling is an essential component.

3.2. Packaging materials

Below overview lists the different materials used in relation to packaging.

Preferred materials, materials to be avoided and prohibited materials are listed.

Not approved materials needs special approval by the ams OSRAM packaging department.

ITEM	Approved	To avoid	Not Approved
Material in general			
Plastic	<ul style="list-style-type: none"> - Preferred from recycled material - Mono-Material 	<ul style="list-style-type: none"> - Foamed plastic - PS 	<ul style="list-style-type: none"> - PUR - PVC - EPS (2022) - Oxidatively degradable plastic - Not separable materials as PET-GAG
Paper based materials	<ul style="list-style-type: none"> - Preferred from recycled material 	<ul style="list-style-type: none"> - Virgin fiber but FSC-certified 	<ul style="list-style-type: none"> - Virgin fiber but not FSC-certified - Laminated paper/cardboard
Inks/Lacquers	<ul style="list-style-type: none"> - Vegetables based inks 		<ul style="list-style-type: none"> - Solvent inks/lacquers - Lead containing inks - Mineral oil based inks

ITEM	Approved	To avoid	Not Approved
Packaging types			
Boxes (folding boxes, shipping boxes)	<ul style="list-style-type: none"> - GD/GT paperboard - Corrugated fiberboard - Reusable shipping boxes made from plastic (PP) 	<ul style="list-style-type: none"> - Virgin fiber but FSC-certified 	<ul style="list-style-type: none"> - Virgin fiber but not FSC-certified - Not water-soluble coatings or adhesives - Laminated paper
Blister	<ul style="list-style-type: none"> - PET - Preferred from recycled material 	<ul style="list-style-type: none"> - Composites are to be avoided in general 	<ul style="list-style-type: none"> - Not separable materials need special approval by the packaging department
Trays	<ul style="list-style-type: none"> - PS, PP, PET - Paperboard/ corrugated fiberboard - Paper Pulp 	<ul style="list-style-type: none"> - EPE - EPP 	<ul style="list-style-type: none"> - PUR - PVC - EPS (2022) - See "<i>plastic</i>"
Shrink/stretch wrapping	<ul style="list-style-type: none"> - PE - PP 		<ul style="list-style-type: none"> - PVC
Bags/sacks	<ul style="list-style-type: none"> - PE, PP, paper 		<ul style="list-style-type: none"> - Labelling made from foreign materials as the substrate
Labels, adhesive tapes	<ul style="list-style-type: none"> - Paper removable acc. QT504 "Glue-Separation Test" - PE, PP, PET, PS same material as product 	<ul style="list-style-type: none"> - PE/PP or PET - not same material as product but easily removable 	<ul style="list-style-type: none"> - PE/PP/PET/paper not easily removable stickers and adhesive tape made from foreign material
Cushion/ Inlays	<ul style="list-style-type: none"> - Paperboard / corrugated fiberboard - Paper Pulp 	<ul style="list-style-type: none"> - EPE, EPP 	<ul style="list-style-type: none"> - PUR - EPS (2022)
Straps	<ul style="list-style-type: none"> - PP 		<ul style="list-style-type: none"> - Steel straps
Cushioning material	<ul style="list-style-type: none"> - Paper-chips - Paper-cushion 		<ul style="list-style-type: none"> - EPS-Chips - Air-bubble foils - Organic cushioning material (beside paper fibers)
Wire	Only with approval from ams OSRAM packaging department (e.g. for labels, etc.)		
Clamps/ staples	Only with approval from ams OSRAM packaging department		

3.3. Recycling Marking

- This section deals with the mandatory labelling of the packaging/components. For product related labelling there are additional requirements (see e.g. WEEE).
- The supplier must fulfill all requirements according to packaging directives 94/62/EC and (EU) 2018/852 “on packaging and packaging waste”.
- Each packaging component must be identified by the recycling code. The symbol consists of a triangular circuit logo, the alphanumeric code and the corresponding material abbreviation.



- This helps the consumer in separate waste and thus contributes to proper return to the recycling cycle.

3.4. REACH Regulation/SVHC (Substance of Very High Concern)

- REACH is the acronym for Registration, Evaluation and Authorization of Chemicals.
- Under REACH, all chemicals which are produced, placed on the market and used in the EU must be examined in detail and must be registered at the European Chemicals Agency (ECHA) in Helsinki.
- Packaging materials belongs to/are part of the REACH regulation.
- It is not allowed to use packaging materials containing substances listed in Annex XIV of REACH-regulation or SVHC (Substance of Very High Concern). If such a substance is included in any packaging material, the supplier has to find a substitution immediately and is obliged to inform CA REACH coordinators immediately in written form.

3.5 RoHS (Restriction of certain Hazardous Substances)

- According to the European directive on packaging and packaging waste, packaging suppliers must ensure that the sum of concentration levels of lead, cadmium, mercury and hexavalent chromium in packaging or packaging components does not exceed 100 ppm by weight.
- This applies to any kind of packaging material regardless of the packaging level (primary, secondary, tertiary level).

4. Primary Packaging

- The packaging that comes into closest contact with the product is often referred to as "retail packaging". Its main purpose is to protect the product and inform or attract a customer.
- In most cases, the primary packaging is a folding box or blister packaging.

4.1. Construction

- The material and construction must meet the requirements of the ams OSRAM specifications.
- The ECMA standard (European Carton Makers Association; www.ecma.org) should be used, in this case no further drawings must be provided in the specification.
- In case the ECMA standard can't be used, the drawings must be provided in the specification and as a dxf-file. Unless otherwise specified, the drawings always show the print side.

4.2. Printing (Offset)

Printing of packaging, particularly primary packaging (e.g. boxes and blister packs) is an important part of ams OSRAM's brand communication. This also applies to our customers and their customer brands. For this reason, the quality of printing (color quality and color consistency) is extremely important.

To avoid errors or to detect any errors early in the supply chain, ams OSRAM relies on a trusting cooperation with its suppliers and on the effectiveness of the quality assurance system. The term supplier refers here to the supplier of the printed packaging material.

Depending on the brand or product, the packaging is printed in only spot color or four-color (CMYK) or in a combination of spot color(s) and four-color (see table below).

Note: The measures described apply only to offset printing.

To ensure print quality with other print technologies (e.g. flexographic or gravure printing) the measures must be defined individually depending on the respective layout and the machinery available at the supplier.

If ams OSRAM purchases finished products from external suppliers, these suppliers must ensure that the measures described here are also followed by their packaging suppliers.

4.2.1. Actions to be taken by printer

The following measures are intended to ensure that the quality of the printing by packaging suppliers meets ams OSRAM standards: Each supplier is provided with a set of tolerance cards for PMS 021 C (distributed by ams OSRAM packaging department).

Before printing a motif for the first time the supplier will receive the following:

- The ams OSRAM specification describing the material to be used and the technical definition of the corresponding die-cuts, (alternatively, if finished products are procured from external suppliers the use of existing packaging/die-cuts can be agreed).
- The print files in the form of files (PDF/X-4).
- Reference PDF files with low resolution.
- For packaging with the ams OSRAM or customer brand that is printed in four colors (CMYK) in addition to the usual spot colors (e.g. luminaire packaging), ams OSRAM or the agencies will provide a binding digital color proof (ISO 12647) or offset proof for checking the color quality.
- If customer brands are printed in four colors (CMYK) a machine proof of a product representative of the customer's range (provided it has the same color distribution) will be created for the respective brand and provided to the supplier.

If neither color cards nor offset proofs or digital proofs are available for customer brands in spot colors, color books (Pantone, HKS) should be used.

	OSRAM brand		Other brands	
	PMS 021 C	PMS 021 C + CMYK	CMYK	Spot colours
High-resolution printing pdf (PDF/X-4)	X	X	X	X
Low-resolution reference pdf files	X	X	X	X
Tolerance cards	X	X		
Digital proofs or offset proofs	-	X	X	optional
Colour panel spot colour (Pantone or HKS)	-	-	-	X*
Colour reference from OSRAM if available	-	-	-	X*

*) Supplier must make sure to use current versions of Pantone and HKS panels and store them properly

Quality control:

- The supplier must use the low-resolution PDF file to check whether the contents of the printout (texts, pictograms, symbols, lamp images, brand elements, barcodes, etc.) meet the specifications. Colours and surfaces (coatings) must be checked with the aid of colour cards, proofs or colour books.
- In cases of doubt, ams OSRAM packaging department or the agency submitting the artwork must be contacted.

4.2.2. Legibility of barcodes on packaging components

Barcodes on printed packaging components from suppliers must meet EN ISO/IEC 15416 and the European Standard of the relevant symbology (see chapter "Standards").

The required degree of quality is "good" (EN Grade 3, ANSI Grade B).

5. Distribution packaging/transport packaging

The distribution packaging is designed to contain one or more articles or packages, or bulk material, for the purposes of transport, handling and/or distribution.

5.1. General

The packaging must meet at least the following requirements:

- The weight (incl. content) of the shipping box shall not exceed 12 kg in case the single product weight allows that.
- The packaging (incl. content) has to withstand the transport to the end customer. This should be verified by appropriate tests, minimum standard should be drop test, vibration test or simulated transport test (see chapter “Standards”).
- Double stacking of pallets for transport and storage must be ensured (see document “ams OSRAM standards for delivery of goods to Global Supply Center”).
- For further tests the ams OSRAM packaging department must be contacted.

5.2. Construction

- In most cases, the distribution packaging is a shipping box made from corrugated fiberboard, so this chapter is focusing on this.
- The material and construction must meet the requirements of the ams OSRAM specifications.
- The FEFCO standard (FEFCO is the European Federation of Corrugated Board Manufacturers) should be used, in this case no further drawings must be provided in the specifications. If the FEFCO standard can't be used the drawings have to be provided in the specification and as dxf-file.
- Unless otherwise specified, shipping boxes are made from corrugated fiberboard with appropriate ECT values (Edge Crush Test grading). The composite of the corrugated fiberboard must meet the requested value.
- Guide to carton strength:
To ensure that outer cartons provide adequate support throughout the entire supply chain, the recommended strength parameters given here as a guide should be followed. For packaged products, size and weight usually determine the material specifications and whether paperboard or corrugated fiberboard is used.

Filling weight	Bursting strength (BCT) ¹ (min)	Edge crush test (ECT) ² (min)
0,5 kg – 5 kg 1,1 lbs – 11 lbs	650 – 1.150 kPa US: 125 PSI	2,5 (kN/m) US: 23 ECT
5 kg – 10 kg 11 lbs – 22 lbs	1.000 – 1.723 kPa US: 150 PSI	3,5 (kN/m) US: 26 ECT
10 kg – 25 kg 11 lbs – 55 lbs	1.450 – 2.253 kPa US: 200 PSI	6,5 (kN/m) US: 32 ECT
25 kg – 30 kg 55 lbs – 66 lbs	2.000 kPa US: 275 PSI	11 (kN/m) US: 44 ECT
> 30 kg > 66 lbs	to be defined	special approval

1) Indicates the ability of the carton to withstand external or internal forces and whether the carton will hold the contents intact during rough handling.

(see chapter “Standards”)

2) Indicates the stacking strength of corrugated board cartons.

(see chapter “Standards”)



5.3. Printing of shipping boxes

- The printing is defined in an artwork or in the specification.
- Unless otherwise specified, flexographic printing is used. A good contrast of ink and print-surface is needed; black, dark brown, dark blue or dark green are the preferred colors.

Recycling Code

- A recycling logo must be printed based on the raw material (see chapter “*Recycling Marking*”).

Supplier Code

- The manufacturer of the packaging may optionally print a symbol or a code of the company on an inner flap of the box.
- China: For shipping boxes sourced and produced in China the supplier code is mandatory. This code is provided by ams OSRAM China.

Production Date

- A date code for the production date of the shipping box is desired.
- Preferably the format should be month/year (mm/yy).

RESY Symbol

- In case “RESY” symbol shall be used as a certificate of the manufacturer’s partnership in the German recycling-cooperation and if the position and size is not defined in the related specification the maximum height of the symbol is 40 mm and of the production code and date 24 pt.

5.4. Closing of shipping boxes

In shelf-ready packaging, no printing or perforation line may be covered by adhesive tape. Paper tape or hot melt are preferred for closing.

5.5. Content label

- The content label must be designed according the ams OSRAM requirements.
- The content label must adhere to the front side of the shipping box (broadside as per FEFCO description).
- In case the front is too small, change side of the shipping box or place it on top.
- The content label must not be applied to printed surfaces or perforated surfaces (if covered, this must be approved by the packaging department).

6. Standards

The metric system must be used, other systems can only be used additionally.
An overview of used standards can be found in the table below:

Area	Title	Link
General	Packaging – Vocabulary	ISO 21067
	Paper, board, pulps, and related terms – Vocabulary Part 1: Alphabetical index	ISO 4046-1
	General tolerances – Part 1: Tolerances for linear and angular dimensions without individual tolerance indications	ISO 2768-1
	GS1 Package Measurement Rules Standard	www.gs1.org
Paper and board	Paper and board – Determination of grammage	ISO 536
	Paper and board – Determination of bending stiffness	ISO 5628
	Testing of paper and board – Determination of the bending stiffness by the beam method	DIN 53121:2014-08
	Determination of tearing resistance	ISO 1974
	Corrugated fiberboard – Determination of edgewise crush resistance	ISO 3037:2013-12
	Testing of board – Puncture test	DIN 53142-1
	Board – Determination of bursting strength	ISO 2759
	Corrugated board – Part 1: Requirements, testing	DIN 55468-1
Box construction	FEFCO International Case Code	www.fefco.org
	ECMA CODE of folding carton	www.ecma.org
	Vertical Drop test	ISO 2248
	Vertical random vibration test	ISO 13355:2016
	Environmental testing: Shock	IEC 60068-2-27:2008
Recycling	Material recycling codes	https://en.wikipedia.org
	QT-504-glue-separation	www.epbp.org
	RecyClass – Recycling-Tool for plastic packaging	www.recyclclass.eu
	Directive 94/62/EC on packaging and packaging waste	http://eur-lex.europa.eu/
Printing and Barcodes	Automatic identification and data capture techniques – Barcode print quality test specification: Linear Symbols	EN ISO / IEC 15416
	Generation of artworks for packaging, quality and legibility of barcodes”	PC 44-701-1-145
	Bar coding – Symbology specifications - Interleaved 2 of 5 - Code 39 - Code 128 - EAN/UPC	ISO/IEC 16390 ISO/ IEC 16388 ISO/IEC 15417 ISO/IEC 15420
ams OSRAM	ams OSRAM standards for delivery of goods to Global Supply Center	www.osram.de/cb/einkaufsp ortal/join-as- supplier/index.jsp