

# Gusset Bags

We meet industry standards ASTM D3078-94 for flexible packaging. Please contact your Inside Sales & Service Representative for further clarification.

## 1 Tin Tie Placement

**TOLERANCE OF +/- 1/8" (in all directions)**

Tin ties are not available on 2LB and 5LB sizes.

## 2 Heat Seal Area

**TOLERANCE OF +/- 1/8"**

Minor burning, cracking, discoloration and delamination may occur at heat seal areas 2a and 2b due to a higher level of heat and pressure required to fully seal the bag. ***\*Note if templates for paper-based materials are not followed, and ink is placed in ink free zones it may result in discoloration, burning and tearing of material.***

## 3 Valve Placement

**TOLERANCE OF +/- 1/8" (IN ALL DIRECTIONS)**

Valve placement must be noted within the design. Valve may be visible on bag.

## 4 Long Seal Alignment

**TOLERANCE OF +/- 1/8"**

Alignment of the edges of material as well as their proximity to bag edges.

## 5 Artwork Alignment

**TOLERANCE OF +/- 1/16" (5-8oz & 12-16oz)**

**TOLERANCE OF +/- 1/8" (2LB & 5LB)**

Ensure all artwork (logos, text) is centered according to the approved PDF.

## 6 Overall Cut Tolerance (All Edges)

**TOLERANCE OF +/- 1/16" (5-8oz & 12-16oz)**

**TOLERANCE OF +/- 1/8" (2LB & 5LB)**

May show bleed from previous print.

## 7 Color Tolerance

**TOLERANCE OF 3 DELTA E**

We use color matching software to help verify the press is calibrated for the correct color. In order to measure color accurately, we need at least .25" worth of solid area to target. We cannot measure color on patterns, gradients or metallic elements.



## 8 Storage & Fill Conditions

**40–80°F AT 30–60% RELATIVE HUMIDITY**

Storage conditions and filling temperatures outside of these ranges may affect material.

## 9 Quantity Tolerance

ORDER QTY	5-8 & 12-16oz	2 & 5lb	COMPOSTABLE
500-900 <small>(can be broken into 100 bags per design)</small>	+/- 50 BAGS PER DESIGN	N/A	N/A
1,000+ <small>(can be broken into 100 bags per design)</small>	+/- 5% PER DESIGN	+/- 5% PER DESIGN	+/- 10% PER DESIGN