# Part 4. ACCEPTANCE CRITERIA

12. Filler—See calcium carbonate.

#### Introduction

The following acceptance criteria shall be employed to evaluate the paper's conformance to specification.

Paper that does not meet all specification values shall be accepted with no discount providing that the minimum acceptable Product Quality Index (PQI) of 70 is met.

The PQI for a specific paper is determined by assigning demerits to each deficient quality characteristic based on test results. The demerits assigned will vary with the category of deficiency. A minor defect shall be assigned 4 demerits, a major defect 12 demerits, and a critical defect 36 demerits.

#### **Definitions**

Minor Defect. Any deficiency from specified values which does not materially reduce the usability of the paper for its intended purpose; or require special procedures for printing or processing.

Major Defect. Any deficiency from specified values, other than critical, that could result in failure, or materially reduce the usability of the paper for its intended purpose; or may require special procedures for printing or processing, or is a significant deviation from specifications, established standards, or average process capability, or may materially affect the appearance of the product.

Critical Defect. Any deficiency from specified requirement that judgment and experience indicate would result in the paper being unusable for its intended purpose; or is a serious departure from specifications, established standards, or average process capability.

The equation for the calculaton of the Product Quality Index is as follows:

Product Quality Index is equal to 100 minus the sum of the assessed demerits for each paper characteristic or property.

Expressed mathematically, PQI=100 
$$\stackrel{i=N}{-\Sigma}$$
 C<sub>i</sub>  $\stackrel{i=1}{c}$ 

where C=characteristics or properties

Paper having a PQI of 70 or better shall be accepted at the contracted price as meeting the intent and requirement of the specification. That having a PQI below 70 shall be considered as critically defective, subject to outright rejection.

Criteria for establishing the category of defect and demerits are as follows unless otherwise stated in the specification standard:

1. Acidity (pH Value): a. "Precision Requirements" all stocks when so designated.

a. Frecision requirements an stocks wi	ien so desig.	nateu.
Deficiency:	Category	Demerits
Less than 0.20 pH unit	Minor	4
0.20-0.40 pH unit	Major	12
More than 0.40 pH unit	Critical	36
Example: Spec $(4.5) - 0.3 = 4.2$ ; Over	r 4.2 pH but	less than
4.5=Minor defect or 4 demerits.	_	
b. "Regular Requirements" all stocks ex	cept those	with mini-
mum pH requirements of 7.0 or 7.5 o		
solicitation.		
Deficiency:	Category	Demerits
Less than 0.40 pH unit	Minor	4
0.40-0.60 pH unit	Major	12
More than 0.60 pH unit	Critical	36
c. Papers with minimum requirements o		pH value.
Deficiency:	Category	Demerits
Not as specified	Critical	36
2. Alpha Cellulose:		
Deficiency:	Category	Demerits
Less than 5 percentage points	Minor	4
5–10 percentage points	Major	12
More than 10 percentage points	Critical	36
3. Basis Weight/Grammage:		
Deficiency:	Category	Demerits
Not as specified	Critical	36
4. Brightness:		
Deficiency:	Category	Demerits
Less than 0.5 percentage point	Minor	4
0.5–1.0 percentage point	Major	12
More than 1.0 percentage point	Critical	36
Or		
More than 2.0 percentage points		
below target value.		

5. Bursting Strength:		
a. "Precision Requirements" all stocks when Deficiency:	Category	
Less than 5 pct	Minor	4
5–10 pct	Major Critical	$\frac{12}{36}$
b. "Regular Requirements" all stock who	en so design	
no designation in solicitation.		
Deficiency: Less than 10 pct	Category	Demerits 4
10–25 pct	Major	12
More than 25 pct	Critical	36
Example: Spec (400) × 25 pct=100 than 300 Bursting Strength=cri	itical defect	or 36 de-
merits.		
6. Calcium Carbonate—Same as 3 above. 7. Cleanliness—Same as 3 above.		
8. Color Deviation (from Standard):		
a. "Precision Requirements" all stocks wh		
Deficiency: Less than 0.5 DE unit over speci-	Category	Demerits 4
fied.		-
0.5 to 1.5 DE unit over specified		12
More than 1.5 DE unit over specified.	Criticai	36
b. "Regular Requirements" all stock who	en so desigr	nated or if
no designation in solicitation.  Deficiency:	Category	Domorita
Less than 1.0 DE unit over speci-		Demerits 4
fied.		10
1.0 to 2.0 DE unit(s) over specified.	Major	12
More than 2.0 DE units over	Critical $\dots$	36
$_{ m Or}^{ m specified}.$		
If standard states another DE		
value as being critically defec- tive.		
9. Color Variation (Does not include 2-Side	dness):	
Deficiency:	Category	
Within a shipment or between shipments in an order, more	Critical	36
than 0.5 DE unit over specified.		
10. Copper Number (excess copper number a. "Precision Requirements" all stocks when the companies of the com	): aon so dosig	natod
Deficiency:	Category	Demerits
Less than 10 pct	Minor	4
10–25 pct	Major Critical	12 36
b. "Regular Requirements" all stock who	en so design	
no designation in solicitation.	C-4	D
Deficiency: Less than 25 pct	Category Minor	Demerits 4
25–50 pct	Major	12
More than 50 pct	Critical	36
a. "Precision Requirements" all stocks wh	nen so desig	nated.
Deficiency:	Category	Demerits
Less than $\pm 1$ percentage point $\pm 1$ to $\pm 2$ percentage points		$\begin{array}{c} 4 \\ 12 \end{array}$
More than $\pm 2$ percentage points	Critical	36
Example: Spec $(45 \text{ pct } \pm 5 \text{ pct}) = +5+2=52 \text{ pct}$ ; Minimum $45 \text{ pct} = -5 \text{ pct}$	±2; Maximu	m 45 pct
pct RH or under 38 pct RH=Cr	itical defect	or 36 de-
merits.		
<ul> <li>b. "Regular Requirements" all stock who no designation in solicitation.</li> </ul>	en so desigr	nated or if
Deficiency:	Category	Demerits
Less than ±3 percentage points	Minor	$\begin{array}{c} 4 \\ 12 \end{array}$
±3 to ±5 percentage points More than ±5 percentage points		36
19 Filler See calcium carbonate		

## ACCEPTANCE CRITERIA

13. Flap Adhesive Thickness:	Or
Deficiency: Category Demerits	More than 2 pct lignin conf
Less than 10 pct Minor 4	Example: Spec (100 pct) –
10–25 pct	100 pct cotton/linen fik
	(100 pct) – 3 pct unblea
*	Over 97 pct up to 100
Or	defect, 4 demerits.
Flap sticks prematurely to body	
of envelope or fails to seal	b. Other stocks required to b
under conditions described in	groundwood pulp.
_ the specifications	Presence of unbleached and/or
Example: Spec $(0.015 \text{ mm}) \times 25 \text{ pct} = 0.00375$ ; $0.015 - 0.015$	groundwood:
0.0038=0.0112; Less than 0.0112 mm=Critical defect	Less than 3 percentage poi
or 36 demerits.	3–5 percentage points
14. Fluorescence—See optical brightener.	More than 5 percentage po
15. Folding Endurance—Same as 5 above.	Or
16. Formaldehyde (melamine-formaldehyde)—Same as 3 above.	More than 2 pct lignin cont
17. Gloss—Same as 5 above.	c. Stocks required to have not mo
18. Grammage—See basis weight.	of lignin and/or groundwood.
19. Oil Holdout (of Coating)—Same as 3 above	Excess pct lignin and/or ground
20. Oil Penetration—Same as 10 above.	More than 1 percentage
21. Opacity:	from specified.
	30. Tearing Strength—Same as 5 al
Deficiency: Category Demerits Less than 1.0 percentage point Minor 4	31. Tensile Strength—Same as 5 ab
	32. Thickness:
	a. Postal Card and 100 pct Crean
More than 2.0 percentage points Critical 36	
Or	Deficiency: Not as specified
Individual specimen averaging	Not as specified
more than 0.5 percentage point	b. "Precision Requirements" all s
below minimum stated in speci-	cept "a" above.
fication.	Deficiency:
22. Optical Brighteners (fluorescence):	Less than 2 pct
a. "Precision Requirements" all stocks when so designated.	2–4 pct
Deficiency: Category Demerits	More than 4 pct
Less than 0.5 percentage point Minor 4	Example: Spec $(0.120\pm0.01)$
0.5–1.0 percentage point Major 12	Maximum 0.120+ 0.013
More than 1 percentage point Critical 36	0.120 - 0.013 - 0.0048 =
Example: Spec (2 pct) +1=3 pct; Over 3 pct Optical	than 0.1022=Critical defe
Brighteners=Critical defect or 36 demerits.	c. "Regular Requirements" all st
	no designation in solicitation ex
b. "Regular Requirements" all stock when so designated or if	Deficiency:
no designation in solicitation.	Less than 4 pct
Deficiency: Category Demerits	4–8 pct
Less than 1 percentage point Minor 4	More than 8 pct
1–2 percentage points Major 12	d. Variation on individual sheets
More than 2 percentage points Critical 36	Deficiency:
23. Pick Resistance (Wax Pick):	Less than 10 pct
Deficiency: Category Demerits	10–25 pct
Less than 1 below No. specified Minor 4	More than 25 pct
1.0–2.0 below No. specified Major 12	Example: Spec (0.011)×25
More than 2.0 below No. specified Critical 36	0.011+0.00275=0.014; V
Or	defect or 36 demerits.
Individual specimen averaging 1	33. Water Resistance—Same as 5 a
No. below minimum stated in	34. All Other Measurable Characte
specification	
24. Porosity—Same as 5 above.	transmission, reflectance drop, etc.):
25. Rosin (excess)—Same as 5 above.	Deficiency:
26. Size—Same as 3 above.	Not as specified
27. Smoothness—Same as 5 above.	
Example: Spec $(50-125)\times25$ pct; $50\times25$ pct=12.5;	35. Judgment Characteristics (suc
125×25 pct=31.25; 50 – 12.5=37.5; 125+31.25=156.25.	tion, erasing/writing qualities, water
Less than 37.5 or more than 156.25=Critical defect or	Assessment:
36 demerits.	Fair or rating "2"
28. Stiffness—Same as 5 above.	Fair minus or rating "3"
29. Stock (fiber analysis):	Unacceptable or rating "4"
a. Papers required to contain 25 pct, 50 pct, 100 pct cotton/	Other Information
linen fibers or 100 pct of specified fiber, other than cotton/	Attention is invited to the following
linen.	Code relative to the procurement of
Deficiency in specified fiber: Category Demerits	Government:
Less than 3 percentage points Minor 4	Section 500_"Standards of name
3-5 percentage points Major 12	Section 509—"Standards of pape
More than 5 percentage points Critical 36	posals; samples.
Example: Spec (100 pct) – 3=97 pct; Over 97 pct up to	The Joint Committee on Printing
100 pct cotton/linen fibers=Minor defect or 4 demerits.	paper for the different descriptions o
Presence of unbleached and/or Catgory Demerits	and the Public Printer, under their d
groundwood (other than Kraft):	newspapers or trade journals, publ
Less than 3 percentage points Minor 4	sealed proposals to furnish the Gove
3-5 percentage points Major 12	fied in the schedule to be furnished a
More than 5 percentage points Critical 36	er, setting forth in detail the quality
	, and go a second quant,

Or	
More than 2 pct lignin content.	_
Example: Spec (100 pct) - 3=97 p	oct; Over 97 pct up to
100 pct cotton/linen fibers=M (100 pct) - 3 pct unbleached o Over 97 pct up to 100 pct cot	inor defect, and spec
(100 pct) - 3 pct unbleached of	r groundwood=97 pct:
Over 97 net up to 100 net cot	ton/linen fibers-Minor
defect, 4 demerits.	ton/inten inters=willor
defect, 4 definerits.	c 11 1 1
b. Other stocks required to be free	from unbleached or
groundwood pulp.	
Presence of unbleached and/or	Category Demerits
groundwood:	
Less than 3 percentage points	. Minor 4
2 5	. Major 12
3–5 percentage points	
More than 5 percentage points	. Critical 36
Or	
More than 2 pct lignin content.	
c. Stocks required to have not more than	n specified percentages
of lignin and/or groundwood.	a specifica percentages
F	Catarana Damanita
Excess pct lignin and/or groundwood: More than 1 percentage point	Catgory Demerits
More than I percentage point	Critical 36
irom specifiea.	
30. Tearing Strength—Same as 5 above. 31. Tensile Strength—Same as 5 above.	
R1 Tensile Strength—Same as 5 above	
32. Thickness:	
a. Postal Card and 100 pct Cream-White	Inday Danon
a. Postar Card and 100 pct Cream-winte	e maex raper.
Deficiency:	Category Dements
Not as specified	. Critical 36
Deficiency: Not as specifiedb. "Precision Requirements" all stocks v	when so designated ex-
cept "a" above.	8
Deficiency:	Category Demerits
Less than 2 pct	Minor 4
0 4	Maia 10
2–4 pct	. Major 12
More than 4 pct	. Critical 36
Example: Spec $(0.120\pm0.013)\times4$ pc	ct; 0.120×4 pct=0.0048;
Example: Spec (0.120±0.013)×4 po Maximum 0.120+ 0.013+ 0.00	ct; 0.120×4 pct=0.0048; 48= 0.1378: Minimum
Example: Spec (0.120±0.013)×4 po Maximum 0.120+ 0.013+ 0.00	ct; 0.120×4 pct=0.0048; 48= 0.1378: Minimum
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Example: Spec (0.120±0.013)×4 pc Maximum 0.120+ 0.013+ 0.00 0.120 - 0.013 - 0.0048= 0.102 than 0.1022=Critical defect or 3	ct; 0.120×4 pct=0.0048; 48= 0.1378; Minimum 2; Over 0.1378 or less 6 demerits
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Example: Spec (0.120±0.013)×4 p. Maximum 0.120+ 0.013+ 0.00 0.120- 0.013- 0.0048= 0.102; than 0.1022=Critical defect or 3 c. "Regular Requirements" all stock who designation in solicitation except "solicitation except than 4 pct 4-8 pct More than 8 pct d. Variation on individual sheets from Deficiency:  Less than 10 pct 10-25 pct More than 25 pct Example: Spec (0.011)×25 pct; 0.011+0.00275=0.014; Variation	t; 0.120×4 pct=0.0048; 48= 0.1378; Minimum 2; Over 0.1378 or less 6 demerits. en so designated or if 1' above. Category Demerits Minor 4. Major 12. Critical 36 one edge to the other. Category Demerits . Minor 4. Major 4. Major 4. Critical 36 one comparity 37 on
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wing sections of Title 44 U.S. of paper for the United States

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ing shall fix upon standards of s of public printing and binding r direction, shall advertise in six ublished in different cities, for overnment with paper, as speci-d applicants by the Public Print-lity and quantities required for

## ACCEPTANCE CRITERIA

the public printing. The Public Printer shall furnish samples of the standard of papers fixed upon to applicants who desire to bid. (Pub. L. 90–620, Oct. 22, 1968, 82 Stat. 1244.)

#### HISTORICAL AND REVISION NOTES

Based on 44 U.S. Code, 1974 ed., Section 5 (Jan. 12, 1895, ch. 23, Section 3, 28 Stat. 601; Mar. 3, 1925, ch 421. Section 1, 43 Stat. 1105).

#### SECTION REFERRED TO IN OTHER SECTIONS

This section is referred to in sections 515, 1121 of this title."

# Section 513—"Comparison of paper and envelopes with standard quality.

The Public Printer shall compare every lot of paper and envelopes delivered by a contractor with the standard of quality fixed upon by the Joint Committee on Printing, and may not accept paper or envelopes which do not conform to it in every particular. A lot of delivered paper or envelopes which does not conform to the standard of quality may be accepted by the Committee at a discount that in its opinion is sufficient to protect the interests of the Government. (Pub. L. 90–620, Oct. 22, 1968, 82 Stat. 1245.)

#### HISTORICAL AND REVISION NOTES

Based on 44 U.S. Code, 1964 ed., section 9 (Jan. 12, 1895, ch. 23, section 7, 28 Stat. 602; June 20, 1936, ch. 630, title VIII, section 13, 49 Stat. 1553).

#### SECTION REFERRED TO IN OTHER SECTIONS

This section is referred to in sections 515, 1121 of this title."

## Section 514—"Determination of quality of paper.

The Joint Committee on Printing shall determine differences of opinion between the Public Printer and a contractor for paper respecting the paper's quality; and the decision of the Committee is final as to the United States. (Pub. L. 90–620, Oct. 22, 1968, 82 Stat. 1245.)

#### HISTORICAL AND REVISION NOTES

Based on 44 U.S. Code, 1964 ed., section 10 (Jan. 12, 1895, ch. 23, section 8, 28 Stat. 602; Mar. 3, 1917, ch. 163, section 6, 39 Stat. 1121).

#### SECTION REFERRED TO IN OTHER SECTIONS

This section is referred to in sections 515, 1121 of this title."