

Certification program

Printing process

Keywords

PSO, ISO 12647-2, offset printing, process control, ugra.swiss, swissPSO

Related documents

U/TD 17.0	Certification system
bvdm	Handbook ProcessStandard Offset, Edition 2012/Update 2016
ISO 12647-2	Graphic technology – Process control for the production of half-tone colour separations, proof and production prints – Part 2: Offset lithographic processes

Document control

Created / Initials	Reviewed / Initials	Approved / Initials	Issue
22.02.2016 / MS	10.01.2017 / TAB	15.01.2017 / MS	V 1

Change management

Revision / Initials	Reviewed / Initials	Approved / Initials	Revised Issue
dd.mm.yyyy /	dd.mm.yyyy /	dd.mm.yyyy /	V 2

Table of Contents

[1 Scope](#)

[2 Specified requirements](#)

[3 Conformity testing](#)

[3.1 Non-conformities](#)

1 Scope

Basis of the specified requirements are the following International Standards and specifications:

- ISO 12647-2:2013 Graphic technology – Process control for the production of half-tone colour separations, proof and production prints – Part 2: Offset lithographic processes
- ISO 2846-1 Graphic technology – Colour and transparency of printing ink sets for four-colour printing – Part 1: Sheet-fed and heat-set web offset lithographic printing
- Handbook ProcessStandard Offset

Unless otherwise noted, the specified requirements of the standards apply.

2 Specified requirements

- A1. The organization shall demonstrate in a test print that they are able to produce according to ProcessStandard Offset and in accordance with the internal standard operating procedures:
- a. The test print starts with the machine preparation (replacement of printing plates after job change).
 - b. The printer works independently during the job preparation, the colour matching and the production run.
 - c. Make-ready time including the preparation of the printing press shall not be greater than 1 hour.
 - d. Three OK sheets shall be determined and set aside. The second and third OK sheet is archived by the organization.
 - e. A print run of 2000 sheets shall be printed (face printing only) .
 - f. A total of 11 printed sheets are taken from the delivery pile and set aside for the measuring evaluation: the first OK sheet and then one sheet every 200 printed sheets.
- A2. The organization shall use a semi or fully automatic measuring system (scan mode) for color control and color regulation at the printing press.
- A3. The organization shall check the materials used for the printing system and the appropriate measuring equipment shall be maintained:
- a. Printing inks according to ISO 2846-1 (certificate verification)
 - b. Dampening water (temperature, pH, conductivity, alcohol content)
 - c. Paper
 - d. Blankets (torque wrenches, relaxed)
 - e. Climatic conditions in the pressroom (temperature, relative humidity)

- A4. The working environment at the printing press should be neat and clean.
- A5. A machine journal should be compiled and kept up to date.
- A6. The measuring evaluation of the printed sheets is conducted in the Ugra accredited laboratory. The evaluation for the underlying printing condition shall comply with the requirements in accordance with the ISO 12647-2.

3 Conformity testing

The conformity testing of the specified requirements laid down in Chapter 2 shall be carried out by means of the following measures:

1. Inspection during audit
2. Interview (Q&A) during audit
3. Proof of competence by qualified person of the organization
4. Evaluation in Ugra’s laboratory

All non-conformities are logged by the auditor and documented as open requirement. The organization must remedy the the non-conformities in due time but at the latest until the next surveillance audit.

3.1 Non-conformities

Non-conformities are documented by the auditor according to the following classification:

Table 1 – Classification of non-conformities

Classification of Non-conformities (NK)	Description
Critical non-conformity	A normative requirement is not compliant. Conformity must be mandatory complied to confirm the certification.
Major non-conformity	A normative or specified requirement is not compliant and therefore leads to a non-conformity.
Minor non-conformity	A normative or specified requirement is partially not compliant and therefore leads to a non-conformity.
Recommendation	A requirement is compliant, but can be optimized by means of recommended measures.