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PEOPLE'S REPUBLIC OF CHINA**

BB/T 0045-2021

**Molded fiber product. Commerce packaging
(English Translation)**

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Table of Contents

Preface
1 Scope
2 Normative references
3 Definition of terms
4 Product Category
5 Technical Requirements
6 Test method
7 Inspection Rules
8 Marking, packaging, transportation and storage

Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for Standardization Work Part 1: Structure and Drafting Rules of Standardization Documents" drafted.

This document replaces BB/T 0045-2007 "Industrial Packaging of Pulp Molded Products". Compared with BB/T 0045-2007, except for the structure in addition to adjustments and editorial changes, the main technical changes are as follows.

- Changed the definition of pulp molded products (see 3.1, 3.1 of the 2007 edition);
- Deleted the terms and definitions of key dimensions (see 3.2 of the 2007 edition);
- Added hot-pressing main mold, hot-pressing auxiliary mold, wet blank, front side, back side, cavity, wool, paste hanging, wrinkle, R angle camber, grid printing, There are 13 terms and definitions for watermark and halo (see 3.2, 3.3, 3.4, 3.5, 3.6, 3.7, 3.8, 3.9, 3.10, 3.11, 3.12, 3.13, 3.14);
- Changed the product classification method and content (see Chapter 4, Chapter 4 of the 2007 edition);
- Added foreign matter impurities, hanging pulp, wrinkles, rough R angle camber, bump points, grid printing, deformation, cutting, watermarking, halo, graphic icon Record a total of 11 appearance requirements (see 5.1);
- Changed the requirements for different color spots and cracks (see 5.1, 5.1.2 of the 2007 edition);
- Changed the requirements for length tolerance, width tolerance, and height tolerance in

the specifications and dimensions (see 5.2, 5.1.1 of the 2007 edition);

--- Increased the requirements for flatness and straightness in the specifications and dimensions (see 5.2);

--- Changed the requirements for quality tolerance, moisture content, and pressure resistance in physical and mechanical properties, and changed the requirements for water absorption to those for water resistance (see 5.3, 5.2 of the 2007 edition);

--- Changed the requirements for chromatic aberration, moving chromatic aberration from appearance to physical and mechanical properties (see 5.3, 5.1.2 of the 2007 edition);

--- Changed the requirements for visual inspection (see 6.1.1, 6.2 of the 2007 edition);

--- Added foreign matter impurities, concave and convex points, watermarks, paste hanging, wrinkles, rough R angle camber, grid printing, deformation, cutting, halo, graphic icon Record a total of 11 appearance test methods (see 6.1.2, 6.1.3, 6.1.4, 6.1.5, 6.1.7);

--- Changed the test methods for the appearance of dissimilar color spots and cracking (see 6.1.3, 6.1.6, 6.2 of the 2007 edition);

--- Changed the test methods for length, width and height (see 6.2.1, 6.2.2, 6.3 of the 2007 edition);

--- Added test methods for flatness and straightness (see 6.2.3);

--- Changed the corresponding range of sample state adjustment and test in standard environment, only physical and mechanical properties test adopts (see 6.3.1, 6.1 of the 2007 edition);

--- Changed the test methods for quality tolerance, water resistance, color difference, and pressure resistance (see 6.3.2, 6.3.4, 6.3.5, 6.3.6, 6.2, 2007 edition) 6.4, 6.6, 6.7);

--- Changed the content of the inspection rules (see Chapter 7, 7 of the 2007 edition);

--- Changed the requirements for marking, and changed storage to storage (see Chapter 8, Chapter 8 of the 2007 edition).

1 Scope

This document specifies the product classification, technical requirements and tests of pulp molded products for industrial packaging (hereinafter referred to as "pulp molded products").

Methods, inspection rules and marking, packaging, transportation and storage.

This document applies to the design, production and inspection of wet-formed pulp molded products for industrial packaging.

2 Normative references

The contents of the following documents constitute essential provisions of this document through normative reference in the text. Among them, the dated reference documents, Only the edition corresponding to that date applies to this document; for undated references, the latest edition (including all amendments) applies to this document.

GB/T 191 Graphical signs of packaging, storage and transportation GB/T 462 Determination of Moisture in Analysis Samples of Paper, Cardboard and Pulp GB/T 1541-2013 Determination of dustiness of paper and cardboard GB/T 2828.1-2012 Counting Sampling Inspection Procedures Part 1: Lot-by-Lot Inspection Sampling Retrieved by Acceptance Quality Limit (AQL) plan GB/T 4857.4-2008 Basic tests for packaging and transport packages - Part 4: Compression and stacking using a pressure testing machine code test method GB/T 10739 Standard atmospheric conditions for handling and testing of paper, paperboard and pulp samples GB/T 12807-1991 Laboratory glass instrument indexing pipette GB/T 19437 Spectral Measurement and Chromaticity Calculation of Printing Images in Printing Technology GB/T 24635.3 Product Geometry Specifications (GPS) Coordinate Measuring Machines (CMM) Techniques for Determining Measurement Uncertainty Part 3: Applying calibrated workpieces or standards GB/T 34690.2-2017 Printing Technology Offset Printing Digital Process Control Part 2: Operating Environment

3 Definition of terms

The following terms and definitions apply to this document.

Pulp Molded Products molded fiber product the plant fiber is processed into the proposed structural shape using a mold, and the product is made by finishing and functional processing.

hot pressing main mold main heat pressing mold A mold for pressurizing and heating the wet blank (3.4) to impart the main specifications and quality characteristics of the pulp molded article (3.1).

A mold that pressurizes, heats and exhausts the wet blank (3.4), and is matched with the concave-convex of the hot-pressing main mold (3.2).