

ICS 55.080
CCS A 82



**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB 9774-2010

Replacing GB/T 9774-2010

Sacks for packing cement

水泥包装袋

(English Translation)

Issued on: September 29, 2020

Implemented on: April 1, 2022

Issued by: State Administration for Market Regulation

Table of Contents

Foreword

1 Scope

2 Normative references

3 Classification, specifications, marking and layout printing

3.1 Classification

Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard replaces GB/T 9774-2010 "Cement Packaging Bags". Compared with GB/T 9774-2010, the main technical changes are as follows.

---Modified the classification and deleted the bottom bag type (see 3.1, 3.1 in the 2010 edition);

---Deleted the bottom bag code (see 3.3.2 of the 2010 edition);

--- Deleted the naming (see 3.4 in the 2010 edition);

---Modified the bag-making materials and increased the quality requirements of the laminated film (see 4.3, 4.3 in the 2010 edition);

---Added bag type requirements (see 5.2);

---Modified the physical and mechanical properties of laminated plastic woven bags and paper-plastic composite bags (see 5.3, 5.2 in the 2010 edition);

---Modified the applicable temperature (see 5.4, 5.3 of the 2010 edition);

---Revised the firmness requirements (see 5.5, 5.4 of the 2010 edition);

---Added the bag type test method (see 6.2);

---Modified the test method of mass per unit area (see 6.3, 6.2 of the 2010 edition);

--- The inspection report is deleted (see 7.6 of the 2010 edition);

---The arbitration is deleted (see 7.7 of the 2010 edition);

--- Deleted the newly developed packaging bag approval (see 7.8 in the 2010 edition);

---Modified the adaptability test of packaging bag filling process (see 9.2, 9.2 in 2010 edition);

---Modified the bottom width and allowable deviation of the bag, deleted the basic size of the bottom sewing bag (see Appendix A, Appendix A of the 2010 edition);

---Modified the method of making pouches (see D.4.1 in Appendix D, D.3.1 in Appendix D of the 2010 edition);

---Modified the pouch production method and pouch maintenance system (see E.4.1 and E.4.3 in Appendix E, and E.4.1 and E.4.1 in Appendix E of the 2010 edition.

E.4.3).

This standard was proposed and managed by the National Packaging Standardization Technical Committee (SAC/TC49).

Drafting organizations of this standard. China Building Materials Research Institute Co., Ltd., Wuhu Conch Plastic Products Co., Ltd., Huangshi Huaxin Bao Co., Ltd., Anhui Jinxiang Chi Plastic Industry Co., Ltd., Zhejiang Eric Environmental Technology Co., Ltd., Zhejiang South Cement Co., Ltd., Fujian Hongxiang Technology Co., Ltd., Anhui Guanzhong Packaging Co., Ltd., Building Materials Industry Technical Supervision and Research Center, Yunnan Province Building Material Product Quality Quality Inspection Institute, Inner Mongolia Autonomous Region Building Material Product Quality Inspection Institute, Guangdong Yingtong Paper Co., Ltd., Guizhou Boda Packaging Co., Ltd.

Zhou Nansu Packaging Co., Ltd., Wenzhou Detai Plastic Industry Co., Ltd., Shijiazhuang Boda Plastics Co., Ltd., Qingdao Chenfeng Intelligent Equipment Co., Ltd.

Company, Changzhou Yongming Machinery Manufacturing Co., Ltd., Zhejiang Miramar Printing Material Technology Co., Ltd.

1 Scope

This standard specifies the classification, specification, marking and layout printing, bag making materials, technical requirements, test methods, and inspection regulations for cement packaging bags.

Rules, signs, packaging, transportation and storage, acceptance inspection.

This standard is applicable to various types of cement packaging bags with a weight not exceeding 50kg.

2 Normative references

The following documents are indispensable for the application of this document. For dated reference documents, only the dated version applies to this article Pieces. For undated references, the latest version (including all amendments) applies to this document.

GB 175 General Portland Cement GB/T 7968 paper bag paper GB/T 8946 General

technical requirements for plastic woven bags GB/T 17671 Cement mortar strength inspection method (ISO method) GB/T 24287 Stretchable paper bag paper

3.1 Classification

3.1.1

Cement packaging bags are divided into three categories. paper bags, laminated plastic woven bags and paper-plastic composite bags according to the bag-making materials. The paper bags include three-layer stretchability.

Paper bags, three-layer stretchable paper bags (with PE plastic film inside), four-layer paper bags and paper bags; three kinds of bag types; laminated plastic woven bags include square bottom laminated plastic woven bags, square bottom There are two types of bottom laminated plastic woven bags (with paper lining); the paper-plastic composite bag is a square bottom paper-plastic composite bag.

3.1.2

Cement packaging bags are all square-bottomed valve bags according to the bag making process, including two sealing methods. bonding and heat sealing. Two square bottom valve pockets the side is flat, and the two bottoms are glued or heat-sealed to form a flat hexagonal shape. A corner of the upper bottom is provided with a valve port. The typical bag-shaped schematic diagram is shown in Figure 1.

Description.

A ---bag length;

B ---bag width;

C ---bottom width;

C'---Valve port width;

D --- length of valve port;

D'---Extend length of valve port.

Figure 1 Schematic diagram of square bottom valve bag