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

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Replacing GB/T 13023-2008

Corrugating medium

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part

1. Structure and Drafting Rules of Standardization Documents". Drafting. This document replaces GB/T 13023-2008 "Corrugated Core (Base) Paper". Compared with GB/T 13023-2008, the only changes are structural adjustments and editing. Aside from the gender changes, the main technical changes are as follows:

- a) The classification has been changed, and Grade AA and Grade A of superior products have been removed (see Chapter 4, Chapter 4 of the.2008 edition);
- b) Increased raw material requirements (see Chapter 5);
- c) Modified the quantitative, compactness, ring crush strength index (transverse), flat crush strength index, breaking length (longitudinal), and water absorption (both sides) indices. Standard requirements (see Table 1,.2008 edition of Table 1);
- d) Increased requirements for heavy metals (lead, mercury, cadmium, chromium, and the total amount of the four heavy metals) and adsorbable organic halogens (AOX) (see Table 1) and test methods (see
- e) The requirements for roll width tolerances and the number of joints per roll for first-class products have been changed (see 6.2,
- 5.6 in the.2008 edition);
- f) Added test methods for serrated and uneven surfaces (see 7.11);
- g) The inspection rules have been changed (see Chapter 8, Chapter 7 of the.2008 edition);

h) Packaging requirements have been changed (see Chapter 9, Chapter 8 of the 2008 edition). Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents. This document was proposed by the China National Light Industry Council. This document is under the jurisdiction of the National Technical Committee on Standardization of Paper Industry (SAC/TC141). This document was drafted by: China Pulp and Paper Research Institute Co., Ltd., Shanying South China Paper Co., Ltd., and Golden Phoenix Paper (Xiaogan) Co., Ltd. The company, Qilu University of Technology (Shandong Academy of Sciences), Wuhan Golden Phoenix Paper Co., Ltd., China Light Industry Paper Products Inspection and Certification Co., Ltd., Shanghai Futures Exchange Exchanges and the China Paper Association. The main drafters of this document are: Wang Xinting, Liu Junjie, Zhang Yue, Wen Xuefen, Cheng Jun, Zhang Kai, Chen Jiachuan, Zhou Weidong, Gao Kuan, Liu Yagang, and Yang Zhenpeng. Wang Mengyao, Zhang Tingbo, Yuan Taojing, Feng Yafang. The release history of this document and the document it replaces is as follows:

---First published as GB 13023-1991 in 1991, and first revised as GB/T 13023-2008 in 2008;

---This is the second revision. Corrugated core (raw) paper

1. Scope This document defines the terminology for corrugated core (base) paper, provides classification information, and specifies the requirements, inspection rules, and procedures for corrugated core (base) paper. The labeling, packaging, transportation, and storage sections describe the testing methods. This document applies to the production, inspection, and sale of corrugated core (raw) paper used in the manufacture of corrugated board core layers.

6 Requirements

6.1 Physical and chemical properties The physical and chemical properties of corrugated core (raw) paper should meet the requirements specified in Table 1.

6.2 Dimensional deviations and number of joints

6.2.1 The diameter of the corrugated core (raw) paper roll is 1100mm~1300mm, or as specified in the order contract. The roll width deviation should be within [specific range missing]. The nominal value is within the range of 0mm to 10mm.

6.2.2 The corrugated core (raw) paper in rolls should be rewound neatly, with flat ends, and the resulting serrations and uneven surfaces should not exceed 10mm. Superior grade per roll The number of joints should not exceed 1; for first-class products, the number of joints per roll should not exceed 2; and for qualified products, the number of joints per roll should not exceed

3. Joints should be treated with... The tape should be firmly attached, with no layers sticking

together, and the joints should be clearly marked.

6.3 Appearance Quality

6.3.1 The surface of the corrugated core (base) paper should be flat, and the edges should be neat and clean, free from creases, defects, tears, holes, hard lumps, missing edges, and so on. Defects such as debris affecting usability.

6.3.2 The corrugated core (base) paper should not have delamination.

7 Test Methods

7.1 Sample Collection and Processing Sample collection shall be carried out in accordance with GB/T 450, including quantitative analysis, quantitative deviation, tightness, ring crush strength index (transverse), flat crush strength index, and fracture length. When determining the longitudinal and water absorption (both sides), the sample should be treated under the temperature and humidity conditions specified in GB/T 10739, and under these conditions... Conduct the experiment.

7.2 Quantitative Analysis and Quantitative Bias The determination shall be carried out in accordance with GB/T 451.2.

7.3 Tightness The determination shall be carried out in accordance with GB/T 451.3.

7.4 Ring crush strength index (transverse) The determination shall be carried out in accordance with GB/T 2679.8.

7.5 Flat compressive strength index The compressive strength index was determined according to GB/T 2679.6, using A-type corrugation, followed by a 30-minute temperature and humidity treatment before compression. test.

7.6 Fracture length (longitudinal) The determination shall be carried out in accordance with GB/T 12914.

7.7 Absorbency (both sides) The water absorption time was determined according to GB/T 1540, and was 60 seconds.

7.8 Delivery moisture content The determination shall be carried out in accordance with GB/T 462.

7.9 Heavy metals Lead shall be determined according to GB/T 24991; mercury according to GB/T 22804; cadmium according to GB/T 24997; and chromium according to GB/T 24990. The determination shall be performed. Alternatively, the sample may be microwave-digested using a high-pressure system, and lead, mercury, cadmium, and chromium shall be determined according to GB/T 37837. Arbitration shall be conducted according to... Compliance with GB/T 37837. The sum of the measured values of the four heavy metals is the total amount of heavy metals (lead, mercury, cadmium, and chromium).

7.10 Adsorbs organic halogens (AOX) The determination shall be carried out according to GB/T 34845, and the product of the determination result (mg/kg) and the sample quantification (g/m²) shall be converted to units and then used. (mg/m²) is used to express the result, which is retained to two significant figures.

7.11 Dimensional Deviation The test shall be conducted according to GB/T 451.1. Specifically, the serrations and irregularities formed on the end faces of the corrugated core (base) paper roll shall use a graduation value not lower than [value missing]. Use a 1mm steel ruler or tape measure for measurement.

7.12 Number of connectors and appearance quality Visual inspection was used.

8.1 Inspection Classification

8.1.1 Factory Inspection Products should be inspected batch by batch according to the requirements of this document before leaving the factory, and only those that meet the requirements of this document can be shipped out.

8.1.2 Type Testing Products of the same type using the same raw materials and processes should undergo type testing at least once every two years. Type testing should also be conducted under any of the following circumstances. Type testing.

- a) When there are significant changes in raw materials or processes;
- b) When a product is first put into production or when production resumes after a shutdown of more than 6 months;
- c) When the production site changes;
- d) When the factory inspection results differ significantly from the previous type inspection results.

8.2 Inspection Items The factory inspection items are routine inspection items, and the type inspection items are all technical requirements except for the number of joints. The corrugated core (raw) paper inspection... The test items shall be carried out in accordance with the provisions of Table 2.

8.3 Batching Rules and Sampling Plan

8.3.1 Batch Rules A batch consists of products made from the same raw materials, of the same type, and delivered in one batch. Each batch of products should be accompanied by a certificate of conformity upon delivery.

8.3.2 Sampling Plan Physicochemical properties [excluding heavy metals and adsorbable organic halogens (AOX)], dimensional deviations, and appearance quality shall be determined according to the secondary sampling method in GB/T 2828.1. The sampling procedure is as specified, and the sample unit is rolls. Acceptance Quality Limits (AQL).