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

GB/T 13508.1-1992

Replacing GB/T 13508-2011

**Polyethylene blow-molded containers
(English Translation)**

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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 13058-2011 "Polyethylene Blow Molded Containers". Compared with GB/T 13508-2011, except for structural adjustments and revisions...

Aside from the logical changes, the main technical changes are as follows.

- The scope has been changed (see Chapter 1, Chapter 1 of the 2011 edition);
- Added terms and definitions (see Chapter 3);
- Change the product structure to categories (see Chapter 4, Chapter 3 of the 2011 edition);
- The specifications have been removed (see Chapter 4 of the 2011 edition);
- The classification of nominal capacity specifications has been changed (see Tables 1-12, Tables 1-8 in the 2011 edition);
- Appearance requirements have been changed (see 5.1, 5.4 in the 2011 version);
- The quality deviation requirements have been changed (see 5.2, 2011 version 5.2);
- The full-mouth capacity tolerance requirement has been changed (see 5.3, 5.1 in the 2011 version);
- Dimensional and tolerance requirements have been changed (see 5.4, 5.3 in the 2011 version);
- The minimum wall thickness and wall thickness ratio requirements for symmetrical parts

have been changed (see 5.5, 2011 version 5.5);

---The liquid level requirements have been changed (see 5.6, 2011 version 5.6);

---The physical and mechanical properties have been changed (see Table 7, Table 6 in the 2011 edition);

---The number of test samples has been changed (see 6.1.2, 2011 version of 6.1.2);

---Added requirements for sample conditioning (see 6.1.3);

---The test method for full-mouth volume deviation has been modified (see 6.4, 6.2 in the 2011 version);

---The dimensional deviation test method has been changed (see 6.5, 6.4 in the 2011 edition);

---The test method for the wall thickness ratio of symmetrical parts has been modified (see 6.6.3, 6.6.2 in the 2011 version);

---Added a schematic diagram of the symmetrical parts of the cylindrical container (see Figure 3, Figure 1 in the 2011 version);

---The test method for liquid level calibration capacity deviation has been modified (see 6.7.2, 2011 version of 6.7.2);

---The test methods for sealing, drop resistance, stackability, and hangability have been revised (see 6.8~6.11, 2011 edition of 6.8~6.11);

---The test method for resistance to internal liquid loading has been modified (see 6.12, 6.13 in the 2011 edition);

---A barrier test method has been added (see 6.14);

---The inspection rules have been changed (see Chapter 7, Chapter 7 of the 2011 edition);

---The requirements for marking, packaging, transportation, use, and storage have been changed (see 8.1, 8.2, 8.4, Chapter 8 of the 2011 edition);

---Added requirements for the nominal diameter of closed containers (see Appendix A);

---A water temperature correction factor has been added (see Appendix B).

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 Plastic Products (SAC/TC48).

1 Scope

This document specifies the classification, requirements, inspection rules, marking, packaging, transportation, use, and other aspects of polyethylene blow-molded containers (hereinafter referred to as "containers").

Storage, and the corresponding experimental methods are described.

This document applies to the production and sales of containers with a volume of 250L and below, made primarily of polyethylene using a hollow blow molding process.

Sales and inspection.

This document does not apply to containers used for packaging hazardous materials and food.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included.

For references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies.

This document.

GB/T 2035 Plastics Terminology GB/T 2828.1-2012 Sampling Procedures for Inspection by Attributes - Part 1: Lot-by-lot Inspection Sampling Indexed by Acceptable Quality Limit (AQL) plan GB/T 2918 Standard Environment for Conditioning and Testing of Plastic Specimens GB/T 16288 Marking of Plastic Products GB/T 19161-2016 Packaging Containers - Composite Medium Bulk Containers

3 Terms and Definitions

The terms and definitions defined in GB/T 2035 apply to this document.

4 Classification

4.1

According to the inlet diameter, they are divided into open type and closed type. Open type has an inlet diameter greater than 70mm, while closed type has an inlet diameter not greater than 70mm.

The type is closed.

4.2

Based on their permeability, they are divided into sealed and permeable types. Containers with a sealed opening and lid structure are classified as sealed, while those with a sealed opening and lid structure are classified as permeable.

A device that has both liquid sealing and air permeability is called a breathable type.

4.3

Containers are classified into conventional containers and high-barrier containers based on their barrier properties. Conventional containers are made of a single polyethylene material; high-barrier containers are made by adding high-barrier materials.

Materials with multi-layered composite structures and high barrier properties are high-barrier containers.

5.1 Appearance

The appearance should meet the requirements of Table 1.