



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

GB/T 15267-1994

Rigid polyvinyl chloride sheet and film for foodstuff packing

食品包装用聚氯乙烯硬片、膜

(English Translation)

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1 Subject content and scope of application

This standard specifies the technical requirements, test methods, inspection rules and marking, packaging, transportation, storage of polyvinyl chloride rigid sheets and films (hereinafter referred to as sheets and films) for food packaging.

This standard applies to sheets and films made by calendaring or extrusion using sanitary polyvinyl chloride resin as the main raw material, adding various additives that meet sanitary requirements.

2 Normative references

GB 1037 Test method for water vapor transmission of plastic film and sheet - Cup method
 GB 2410 Transparent plastics - Transmissivity and haze test GB 2828 Sampling procedures and tables for lot-by-lot inspection by attributes (Apply to inspection of successive lots or batches)
 GB 2918 Standard atmospheres for conditioning and testing of plastic specimens
 GB 5009.60 Method for analysis of hygienic standard of products of polyethylene, polystyrene and polypropylene for food packaging
 GB 5009.67 Method for analysis of hygienic standard of product of polyvinyl chloride for food packaging
 GB 6672 Determination of thickness of plastic film and sheeting by mechanical scanning
 GB 6673 Plastics - Film and sheeting - Determination of length and width
 GB 9681 Hygienic standard of products of polyvinyl chloride for food packaging
 GB 13022 Plastics - Determination of tensile properties of films
 GB/T 15043 Methods for measuring electrical and luminous parameters of incandescent lamps calculate the extension & shrinkage in the length direction and width direction.

Where.

S - Extension & shrinkage after heating, %;

L1 - Distance between the mark points before heating, mm;

L2 - Distance between the mark points after heating, mm.

5.6 Hygienic performance

It is performed according to GB 5009.60 and GB 5009.67.

6.1 Group-batching

Product inspection is carried out in batches. Products with the same formula, the same specification, the same process which are continuously produced form a batch. The quantity of each batch shall not exceed 40 t.

6.2 Sampling

The specifications and appearance of the products adopt the general inspection level II specified in GB 2828, the normal secondary sampling plan. According to the provisions of Table 6, select 1 m2 randomly from each roll for inspection. The physical and mechanical properties and hygienic properties are randomly selected from the taken samples for inspection.

6.3.1 Exit-factory inspection

The exit-factory inspection items are 4.1, 4.2, 4.3, as well as the items 5, 6, 7 in Table 4 of the technical requirements.

6.3.2 Type inspection

The type inspection items are all the items in the technical requirements. Type inspection shall be carried out in any of the following situations.

a. Trial design and type finalization of new products or old products after trans-plant production;