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

GB/T 19787-2025

Replacing GB/T 19787-2005

Packaging materials - Heat-shrinkable polyolefine films

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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 for standardization documents" Drafting.

This document replaces GB/T 19787-2005 "Polyolefin heat shrinkable film for packaging materials". Compared with GB/T 19787-2005, In addition to structural adjustments and editorial changes, the main technical changes are as follows.

- Changed the scope (see Chapter 1, Chapter 1 of the 2005 edition);
- Deleted product specifications (see Chapter 3 of the 2005 edition);
- Added classification (see Chapter 4);
- Changed the technical requirements for width deviation (see 5.2.1, 4.1 of the 2005 edition);
- Added relevant requirements for polyolefin heat shrinkable films with nominal thickness of $8\mu\text{m} \leq e < 12\mu\text{m}$, $30\mu\text{m} \leq e \leq 52\mu\text{m}$ (see 5.2.2, 5.3 and Table 3);
- Deleted product grade (see 4.2 and 4.3 of the 2005 edition);
- Changed the physical and mechanical properties requirements (see 5.3, 4.4 of the 2005 edition);
- Added gloss item (see 5.3);
- Changed the right-angle tear load to tear resistance (see 5.3, 4.4 of the 2005 edition);
- Changed the coefficient of kinetic friction (film to film) (see 5.3, 4.4 of the 2005 edition);
- Deleted the hygienic performance (see 4.5 of the 2005 edition);

- Changed the test method for thickness deviation (see 6.4, 5.3 of the 2005 edition);
- Changed the test method and test temperature for thermal shrinkage (see 6.8, 5.8 of the 2005 edition).

Please note that some of the contents of this document may involve patents. The issuing organization of this document does not assume the responsibility for identifying patents.

This document is proposed and coordinated by the National Technical Committee for Packaging Standardization (SAC/TC49).

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The previous versions of this document and the documents it replaces are as follows.

- First published in 2005 as GB/T 19787-2005;
- This is the first revision.

1 Scope

This document specifies the requirements for polyolefin heat shrinkable films (hereinafter referred to as films), describes the corresponding test methods, and specifies the inspection specifications.

It specifies the rules, marking, packaging, transportation and storage, and gives the product classification.

This document is applicable to the use of polyethylene, polypropylene and other resins as the main raw materials, through the tube film method multi-layer co-extrusion cooling to make the film embryo, and then Film with heat shrinkage function made by biaxial synchronous stretching, etc.

2 Normative references

GB/T 1040.3

GB/T 2410

GB/T 2828.1

GB/T 2918

GB/T 6672

GB/T 6673

GB/T 8807

GB/T 10006

GB/T 16578.2

3 Terms and Definitions

There are no terms or definitions that require definition in this document.

4 Categories

According to the process, it is divided into ordinary type and cross-linked type.

- Ordinary type refers to the polyolefin heat shrinkable film produced by the tubular film method and synchronous biaxial stretching process.
- Cross-linked type refers to a polyolefin that is cross-linked in its molecular chain by electron irradiation based on the synchronous biaxial stretching process of the tubular film method. Hydrocarbon heat shrink film.

5.1 Appearance

The product appearance should comply with the requirements of Table 1.

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