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

GB/T 22789.1-2023

Replacing GB/T 22789.1-2008

**Plastics - Unplasticized poly (vinyl chloride) sheets - Part 1:
Types, dimensions and characteristics for sheets of thickness
not less than 1 mm**

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Standardization Administration**

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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 is Part 1 of GB/T 22789 "Rigid polyvinyl chloride sheets (sheets) for plastic products". GB/T 22789 has been released

The following sections are included.

---Part 1. Classification, dimensions and properties of plates with thickness 1mm and above;

---Part 2. Classification, size and performance of sheets with thickness below 1mm.

This document replaces GB/T 22789.1-2008 "Classification, dimensions and properties of rigid polyvinyl chloride sheets - Part 1. Thickness 1mm

"Above Plates", compared with GB/T 22789.1-2008, 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.2008 edition);

---Changed the content of the classification (see Chapter 5, Chapter 4 of the.2008 edition);

---Added A and B levels in the logo (see 5.2, Chapter 7 of the.2008 edition);

---Changed the technical requirements for appearance (see 6.1, 5.2 of the.2008 edition);

---Changed the size symbols (see Table 1, Table 1 of the.2008 edition);

---Changed the name of the diagonal difference and added an explanation of the diagonal difference formula (see 6.2.2, 5.4.2 of the.2008 version);

---Added A and B-level indicators for total light transmittance (see Table 5, Table 5 of the.2008 version);

---Deleted the technical requirements for health indicators (see 5.7.3 of the.2008 version);

---Changed the description of dimensional measurement (see 7.3.1, 6.3.1 of the.2008 version);

---Changed the sampling requirements for samples (see 7.4.5.1, 7.4.5.2, 6.5.2.1, 6.5.2.2 of the.2008 edition).

This document is modified to adopt ISO 11833-1.2019 "Plastic products rigid polyvinyl chloride sheets (sheets) Part 1.Thickness 1mm

and the classification, size and performance of the above plates.

Compared with ISO 11833-1.2019, this document has many structural adjustments. Compare the structure number changes between the two files in one column

See Appendix A for the list.

The technical differences between this document and ISO 11833-1.2019 and their reasons are as follows.

---Changed the second paragraph in the "Scope" chapter and added the applicable limits of the document (see Chapter 1) to comply with Chinese standards.

Require;

---The classification in Chapter 5 has been changed and the logo has been added (see Chapter 5) to comply with the requirements for compilation of Chinese standards;

---Deleted 6.1 packaging (see 6.1 in ISO 11833-1.2019);

---Changed the name of 6.5 (see 6.6 in ISO 11833-1.2019);

---The hygienic performance has been deleted (see 6.6.3 in ISO 11833-1.2019). my country's hygienic performance is stipulated by the national food safety standards;

--- Increased the spline size of load deformation temperature (see 7.5.2) to improve the operability of the test and eliminate ambiguity;

---Replaced ISO 1183-1 and ISO 1183-2 with normatively quoted GB/T 1033.1 and GB/T 1033.2 respectively (see

7.5.4), there is no consistent correspondence between the two documents in order to adapt to my country's technical conditions and improve operability;

--- Increased the test speed of flexural strength (see 7.5.5) to improve the operability of the test and eliminate ambiguity;

---The logo in Chapter 8 has been changed, and packaging, marking, transportation and storage (see Chapter 8) have been added to comply with the requirements for compilation of Chinese standards.

The following editorial changes have been made to this document.

---Changed the "scope" (see Chapter 1);

---Changed the description of test temperature (see 7.5.1);

---Changed the name and content of 5MPa flexural creep modulus to be consistent with Table 6 (see 7.5.3).

Please note that some content in this document may be subject to patents. The publisher of this document assumes no responsibility for identifying patents.

Introduction

With the improvement of production level and quality control requirements of rigid polyvinyl chloride sheets (sheets) for plastic products and the advancement of testing instrument technology,

Step by step, the technical indicators and results of GB/T 22789.1-2008 are no longer able to meet the current level of plastic product processing and testing technology.

develop. According to the development direction of rigid polyvinyl chloride sheets (sheets) for plastic products in my country, they are divided into the following two parts according to the thickness of the sheets.

---Part 1. Classification, dimensions and properties of plates with thickness 1mm and above. The purpose is to establish the thickness of the board with a thickness of 1mm and above

The performance requirements of the material are provided, and detection methods are provided, aiming to help plate manufacturers and users with a thickness of 1mm and above to detect and improve their products.

Product performance.

---Part 2. Classification, size and performance of sheets with thickness below 1mm. The purpose is to establish the quality of sheets with a thickness of less than 1mm

Performance requirements, and provides detection methods, aiming to help sheet manufacturers and users below 1mm detect and improve products

performance.

Plastic products rigid polyvinyl chloride board (sheet) material

Part 1. Classification of plates with thickness 1mm and above,

Size and performance

1 Scope

This document specifies the raw materials, classification and labeling of rigid polyvinyl chloride (PVC-U) extruded boards and laminates (hereinafter referred to as "boards").

Requirements and packaging, labeling, transportation and storage, test methods are described.

This document applies to the production, inspection, and sales of plates with a thickness of 1mm and above.

This document does not apply to biaxially oriented rigid polyvinyl chloride (PVC-U) sheets.

2 Normative reference documents

The contents of the following documents constitute essential provisions of this document through normative references in the text. Among them, the dated quotations

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

this document.

GB/T 1033.1 Determination of density of plastic non-foam plastics Part 1.Dip method, liquid pycnometer method and titration method

(GB/T 1033.1-2008,ISO 1183-1.2004,IDT)

GB/T 1033.2 Determination of density of plastic non-foam plastics Part 2.Density gradient column method (GB/T 1033.2-2010,

ISO 1183-2.2004,IDT)

GB/T 1040.2 Determination of tensile properties of plastics Part 2.Test conditions for molded and extruded plastics (GB/T 1040.2-

2006,ISO 527-2.1993,IDT)

GB/T 1043.1 Determination of impact properties of plastic simply supported beams Part 1.Non-instrumented impact test (GB/T 1043.1-

2008,ISO 179-1.2000,IDT)

GB/T 1634.2-2019 Determination of load deformation temperature of plastics Part 2.Plastics and hard rubber (ISO 75-2.2013,

MOD)

GB/T 2035 Plastic terms and definitions (GB/T 2035-2008, ISO 472.1999, IDT)

GB/T 2828.1 Enumeration sampling inspection procedures Part 1.Batch-by-batch inspection sampling plan retrieved by acceptance quality limit (AQL)

(GB/T 2828.1-2012,ISO 2859-1.1999,IDT)