

ICS 85-010
CCS Y 30



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

GB/T 22874-2008

**Single-faced and single-wall corrugated fibre board --
Determination of flat crush resistance**

单面和单瓦楞纸板 平压强度的测定

(English Translation)

Issued on: December 30, 2008

Implemented on: September 1, 2009

Issued by: Standardization Administration of China

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Foreword

This revised standard adopts ISO 3035. 1982 "and the single-sided corrugated board flat crush strength determination." this standard and ISO 3035. 1982 as compared to the main differences are as follows.

--- International standards in Chapter 1, "scope" and Chapter 2, "Applications" merger of this standard in Chapter 1, "scope";

--- References to normative documents substituted with International Standard reference materials, and the ISO 3035 international standard referenced into with the corresponding national standards (Chapter 2 of this standard);

--- The flat crush tester parallelism deviation is less than "1.1000" to "1.2000" (this standard 4.1);

--- Increase the chart in Appendix A and single-sided corrugated board.

Appendix A of this standard is a normative appendix.

The standard proposed by China National Light Industry Council.

This standard by the National Standardization Technical Committee of the paper industry.

This standard was drafted. Exit Inspection and Quarantine Technology Center of Guangdong, China Pulp and Paper Research Institute, the National Quality Supervision, Inspection and paper center.

1 Scope

This standard specifies the determination method of manufacturing a corrugated cardboard box flat crush strength.

This standard applies to single-sided and corrugated board, does not apply to double corrugated cardboard.

2 Normative references

The following documents contain provisions which, through reference in this standard and become the standard terms. For dated references, subsequent Amendments (not including errata content) or revisions do not apply to this standard, however, encourage the parties to the agreement are based on research Whether the latest versions of these documents. For undated reference documents, the latest versions apply to this standard.

GB/T 450 and take samples to an aspect of paper and paperboard samples, positive and negative determination (GB/T 450-2008, ISO 186.

2002, MOD)

GB/T 10739 paper, paperboard and pulp sample processing and testing standard atmospheric conditions (GB/T 10739-2002, eqv ISO 187.

1990)

Principle 3

Take a sample representative of the corrugated board, with compression tester consists of two parallel plates composed of a vertical surface of the specimen plus Pressure until the corrugated crushed so far, determine the maximum pressure per unit area of the specimen subjected to kilopascals (kPa) represented.

4.1 Flat pressure tester

4.1.1

by the motor drive pressure plate compression tester, the sample size should be larger than the size of the platen (4.2) to ensure that the sample does not exceed the platen Outside, and shall meet the following requirements.

--- Parallelism deviation should be less than 1.2000;

--- Lateral movement should not exceed 0.05mm.

NOTE: You can use very fine sandpaper wrapped plate, and should be kept flatness and parallelism of the surface of the parcel.

4.1.2

If the tester has a fixed platen, another piece of plate relative motion in the vertical direction, the movable platen lifting speed shall (12.5 ± 2.5) mm/min.

4.1.3

If the tester according to beam bending works only when the test result falls instruments span a range of 20% to 80%, only such equipment can be measured. When the movable platen into contact with the sample, the applied pressure, speed should be (110 ± 23) N/s (priority) or (67 ± 23) N/s.

4.2 CD-like device

Can cut out a sample area of \u200b\u200bnot less than 50cm² circular cut like a knife, the sample should be neat trimming and perpendicular to the corrugated board.

Note: The general use area 64.5cm² (diameter 90.6mm $\pm$ 0.5mm) and 100cm² (diameter 112.8mm $\pm$ 0.5mm). When the flat crush resistance exceeding the instrument range, smaller sample (typically 32.2cm²) may be used.

5 Sampling

Sampling by GB/T 450 performed.

6 Processing temperature and humidity

Sample Press GB/T 10739 temperature and humidity were treated.