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

GB/T 27591-2025

Replacing GB/T 27591-2011

Paper tableware

纸餐具

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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 is required.

This document specifies the quality-related technical requirements. For food safety-related requirements, please refer to relevant laws, regulations, policies and food safety standards. document.

This document replaces GB/T 27589-2011 "Paper lunch box" and GB/T 27591-2011 "Paper bowl".

GB/T 27591-2011 is the main version, which integrates the contents of GB/T 27589-2011.

In addition to the integration and editorial changes, the main technical changes are as follows.

The scope has been changed (see Chapter 1, Chapter 1 of GB/T 27591-2011); a) Added terms and definitions (see Chapter 3); b) Added product classification (see Chapter 4); c) The requirements for raw materials (see 3.4 of GB/T 27591-2011) have been deleted; d) Added intrinsic quality requirements (see 5.1) and dimensions for paper barrels, paper lunch boxes, paperboard boxes, paper dinner plates and paper knives (forks and spoons).

Test methods for deviation, load-bearing performance, overall stiffness, bending resistance, lid folding test and fat resistance (see 6.2, 6.4, 6.6, 6.7, 6.8 and 6.9);

e) The name of the indicator "leakage performance" was changed to "temperature resistance performance", and the test method was changed (see 5.1 and 6.1 1, 3.2 and 4.4

of GB/T 27591-2011);

f) Added requirements for water leakage, shortage of internal volume, biodegradability, compostability and compatibility (see 5.1, 5.2, 5.3, 5.4 and 5.6) and the corresponding test methods (6.10, 6.12, 6.13 and 6.14);

g) The requirements for appearance quality have been changed (see 5.5, 3.1 of GB/T 27591-2011); h) Deleted the hygiene index requirements and test methods (see 3.3 and 4.6 of GB/T 27591-2011); i) Deleted the raw material test method (see 4.7 of GB/T 27591-2011); j) The inspection rules, marking, packaging, transportation and storage have been changed (see Chapter 7 and Chapter 8, Chapter 5 and Chapter 6);

k) The bending beam compression apparatus in the compressive strength determination method (see A.1.2 of GB/T 27591-2011) has been deleted.

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 was proposed by China Light Industry Federation.

This document is under the jurisdiction of the National Technical Committee for Standardization of Materials and Articles in Direct Contact with Food (SAC/TC 397).

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

GB/T 27589, first issued in 2011;

GB/T 27591, first issued in 2011; This is the first revision. - Paper tableware

1 Scope

This document defines the relevant terms and definitions, gives product classification, and specifies the requirements, inspection rules, marking, packaging, and other aspects of paper tableware.

Packaging, transportation and storage, and the corresponding test methods are described.

This document applies to the production, inspection and sales of various paper tableware that directly contacts food.

This document does not apply to molded pulp tableware or paper straws.

2 Normative references

GB/T 2828.1

GB/T 10739

GB/T 22805.2

GB/T 39951

JJF 1070-2023

3 Terms and definitions

The following terms and definitions apply to this document.

3.1

Utensils made of paper or paperboard, intended for dining or similar purposes.

Note. Including paper bowls, paper buckets, paper lunch boxes, cardboard boxes, paper dinner plates, paper knives, paper forks, paper spoons, etc. and matching paper covers.

3.2 Paper bowl

The base paper is processed by lamination (lamination) or coating, and then goes through processes such as printing, die-cutting, forming, and externally pasting fan slices to make a bowl-shaped paper container.

Note. Printing and attaching fan blades are not necessary processes. If not necessary, the printing and attaching fan blades processes can be omitted.

3.3 Paper bucket

The barrel-shaped paper container is made by laminating (coating) or coating the base

paper and then going through processes such as printing, die-cutting, forming, and sticking fan sheets on the outside.

Note. Printing and attaching fan blades are not necessary processes. If not necessary, the printing and attaching fan blades processes can be omitted.

3.4 Paper container set for food

The base paper is processed by lamination (lamination) or coating, and then printed, die-cut, and formed to form a box-shaped paper container.

Note. Printing is not a necessary process. If printing is not required, this process can be omitted.

3.5 cardboard box

A box-shaped paper container for solid food made from cardboard or paper composite materials that is die-cut, creased, and then folded or bonded.