

ICS 85.060

CCS Y 32



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

**GB/T 36392-2025**

Replacing GB/T 36392-2018

**Coated paper and board for food packaging**

食品包装用淋膜纸和纸板

**Issued on: June 30, 2025**

**Implemented on: January 1, 2026**

**Issued by: State Administration for Market Regulation;  
Standardization Administration of the PRC**

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### 1 Scope

This document specifies the requirements, inspection rules, marking, packaging, transportation and storage of coated paper and board for food packaging. It also describes the corresponding test methods and provides information regarding abbreviations and classification.

This document is applicable to the production, inspection, and sales of coated paper and board for food packaging, which is made from paper as a base material, and coated on one or both sides with PE, PP, PET, PBS, PLA, PHA or PBAT. Other coated paper and board, laminated paper and board for food packaging may take this Standard as a reference.

### 2 Normative References

GB/T 450

GB/T 451.1

GB/T 451.2

GB/T 451.3

GB/T 462

GB/T 1535

GB/T 2828.1

GB/T 6682

GB/T 7705

GB/T 7706

GB/T 7975

GB/T 10342

GB/T 10739

GB/T 14216

GB/T 17497.1

GB/T 31905

GB/T 39951

### 3 Terms and Definitions

This document does not have terms or definitions that need to be defined.

### 4 Abbreviations

The following abbreviations are applicable to this document.

PBAT. poly (butylene adipate terephthalate) PBS. poly (butylene succinate) PE. polyethylene PET. poly (ethylene terephthalate) PHA. polyhydroxyalkanoate PLA. poly (lactic acid) PP. polypropylene

### 5 Classification

5.1 The coated paper and board for food packaging are classified by use into Type I, Type II and Type III. Type I is low-weight coated paper used for packaging hamburgers and pastries, etc.; Type II is coated paper used for processing paper bags for dried fruits, drinking water or other ready-to-eat foods; Type III is high-weight coated paper and board used for processing paper cups, paper bowls and paper lunch boxes, etc.

#### 6.5.3 Ecotoxicity

The percentage of sprouts in the compost sample and the blank compost shall be greater

than or equal to 90%.

NOTE. compostability is only assessed for coated paper and board for food packaging that is explicitly stated as compostable.

## 6.6 Dimensional Deviation and Degree of Skewness

The roll width, roll diameter and flat paper dimensions of the coated paper and board for food packaging shall comply with the contract. The dimensional deviation shall not exceed 3 mm, and the degree of skewness of flat paper shall not exceed 3 mm.

## 6.7 Printing Quality

6.7.1 The images, characters and lines shall be basically clear and complete. Characters smaller than size 6 (7.5 P) shall not be difficult to recognize and read.

6.7.2 The printed surface shall be free of obvious printing quality problems, such as streaking, dirt, ghosting, water ripples, scratches, smearing or stringing.

6.7.3 Die-cutting notches shall be basically smooth, and free of stains, burrs, sticking or cracking.

### 6.7.4 For flexographic, lithographic, relief and intaglio printing, overprint error, die-cut

dimensional deviation, color difference of on-site printing within the same batch and for the same color, and ink layer abrasion resistance shall respectively comply with the requirements for GB/T 17497.1, GB/T 7705, GB/T 7706 and QB/T 3007.

NOTE. the printing quality is only assessed for coated paper and board for food packaging.

## 7.1 Specimen Collection and Handling

Specimen collection shall be conducted in accordance with GB/T 450.

When determining quantitative deviation, difference in horizontal scroll thickness, quantitative deviation of film, adhesion, grease resistance, edge permeance, wetting tension, dimensional deviation, and degree of skewness, specimen handling and the standard atmosphere conditions for testing shall be in accordance with GB/T 10739.

## 7.2 Appearance Quality

Color differences within the same batch of paper shall be determined in accordance with GB/T 7975; other items shall be visually inspected.

## 7.3 Quantitative Deviation

Conduct the determination in accordance with GB/T 451.2.

#### **7.4 Difference in Horizontal Scroll Thickness**

Conduct the determination in accordance with GB/T 451.3.

#### **7.5 Quantitative Deviation of Film**

Use a sampler to cut 3 specimens with an area of 0.01 m<sup>2</sup> along the horizontal scroll of the paper specimens. Place the specimens in a metal or glass container filled with anhydrous ethanol and make sure that the specimens are completely immersed in ethanol. After 10 minutes, take out the specimens and gently separate the film. Remove any paper fibers from the film.

After drying, respectively place the 3 films on a balance with a division value of 0.0001 g and weigh them. The difference between the average quantitative value of the 3 films and the nominal value is taken as the result, which is expressed in grams per square meter (g/m<sup>2</sup>). The result is rounded to one decimal place. For samples with films that are difficult to peel, the immersion time may be appropriately extended.

#### **7.6 Adhesion**

Conduct the determination in accordance with Appendix A.

#### **7.7 Film Perforations**

Conduct the determination in accordance with Appendix B.

#### **7.8 Grease Resistance**

Conduct the determination in accordance with Appendix C.

#### **7.9 Leakage Performance**

Conduct the determination in accordance with Appendix D.

#### **7.10 Edge Permeance**

Conduct the determination in accordance with GB/T 31905. Test conditions shall be selected based on the intended use of the product. During arbitration, the edge permeance mass shall prevail.

#### **7.11 Wetting Tension**

Conduct the determination in accordance with Appendix E or GB/T 14216. During arbitration, conduct the determination in accordance with GB/T 14216, and the test surface