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

GB/T 39415.1-2020

**Packaging sacks. Method of specifications for characteristics -
Part 1: Paper sacks**

包装袋 特征性能规范方法 第1部分：纸袋

(English Translation)

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1 Scope

This Part of GB/T 39415 specifies the method of specifications for characteristics in ordering documents of paper sacks, covering the characteristic performance description of the paper sack but does not include the quantitative index requirements.

This Part is applicable to the paper sacks specified in GB/T 17858.1. It may refer to this Part when formulating standards for various paper sacks.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

GB/T 17858.1, Packaging sacks - Vocabulary and types - Part 1: Paper sacks (GB/T 17858.1-2008, ISO 6590-1:1983, MOD)

GB/T 31556.1, Packaging sacks - Description and method of measurement for dimension - Part 1: Paper sacks (GB/T 31556.1-2015, ISO 6591-1:1984, MOD)

3.1 General

When drafting the ordering documents for the paper sacks, both the supplier and the purchaser shall negotiate and select the appropriate content from the following options to be included in the order document.

The format of the order document shall be negotiated between the supplier and the purchaser.

3.2 Characteristic performance

- Sack bottom width, c;
- Valve port width, g;
- Valve port length, f;
- Valve sleeve length, i;
- Flip pasting length, p;
- Seam margin, n: the distance from the lateral edge of the sack on the closer side;
- Valve sleeve position, l: the distance between the outermost edge of the sack and the outermost edge of the valve sleeve, measured parallel to the bottom.

3.2.4 Material

It shall specify the type, quantitative [in grams per square meter (g/m²)] or thickness [in micron (μm)] of each layer of material, surface treatment (such as coating type and quantitative, non-slip type and method of use, direction of treatment facing inward or outward).

The thermoplastic film layer, generally used for the inner layer, shall specify the following requirements:

- Separable or integral;
- Film types, such as: low density polyethylene (PE-LD), linear low-density polyethylene (PE-LLD), high density polyethylene (PEHD), polyvinylidene chloride (PVDC), ethylene-vinyl acetate copolymer (E/VAC);
- Film state (flat film or tube film);
- Film thickness, in micrometers (μm);
- Melt flow index of film, in grams per 10 minutes (g/10min);
- Length, in millimeters (mm), when it is different from other layers (usually seen in separable or integrated tube membranes);
- Frill width, in millimeters (mm), when it is different from other layers (usually seen in a separable or integrated tube film);
- Width, in millimeters (mm), when it is different from other layers (usually seen in separable or integrated tube membranes);
- Heat sealing margin, in millimeters (mm), the distance from the lateral edge
- Position: valve port end, no valve port end;

- Material: type and quantity;
- Dimensions: length and width, in millimeters (mm).

3.2.10 Bottom cover

Bottom cover requirements include:

- Position: valve port end, no valve port end;
- Material: type and quantity;
- Dimensions: length and width, in millimeters (mm);
- Surround: yes/no.

3.2.11 Bottom direction

The bottom direction requirements include:

- Fold to the front of the sack;
- Fold to the back of the sack.

3.2.12 Suture closure/stitching

3.2.12.1

Types of suture closure include:

- Simple stitching;
- Strap-suture (the strap is under the suture);
- Suture-strap (the strap is above the suture);
- Belt-stitching-belt (enhanced);
- Heat sealing-stitching-tape.

3.2.12.2

Sewing types include:

- Single chain sewing: with/without lining rope;
- Double lock sewing: with/without lining cord.

3.2.12.3

Line types include:

- Natural;

carboxymethyl cellulose (CMC);

- Longitudinal seam pasting;
- Horizontal pasting;
- Bottom pasting;
- Bottom liner and bottom cover pasting.
- Special requirements, such as waterproof performance, thermal stability.

3.2.15 Printing

Printing requirements include:

- Ink type, such as water-soluble acrylic, organic pigment;
- Ink color, such as Pantone color card color number;
- Print a complete description of the requirements and positions of the main elements, such as front, back, frills, valve port ends, and non-valve port ends.

3.2.16 Packaging

Packaging requirements include:

- Bundles of sacks: tied/untied/folded;
- Bundled into packages: the total number of bags per package;
- Bundled into pallet units: the total number of bags per unit;
- Bundle stacking method;
- Tile reel: diameter and lap size, in millimeters (mm), number of sacks;
- Pallet size and type (four-way feeder/two-way feeder);
- Maximum unit height, in millimeters (mm);
- Special requirements for automatic baler;
- Pallet packaging: plastic, paper, shrink packaging, stretch packaging, wooden frames or fiberboard on pallets;
- Pallet straps: steel, plastic;
- Strapping protection;

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