



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

GB/T 39415.2-2020

**Packaging sacks - Method of specifications for characteristics -
Part 2:Sacks made from thermoplastic flexible film**

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1 Scope

This Part of GB/T 39415 specifies the method of specifications for characteristics in ordering documents of sacks made from thermoplastic flexible film.

This Part is applicable to the sacks made from thermoplastic flexible film specified in GB/T 17858.2. 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 17858.2, Packaging sacks - Vocabulary and types - Part 2: Sacks made from thermoplastic flexible film (GB/T 17858.2-2010, ISO 6590-2:1986, MOD)

GB/T 31556.2, Packaging sacks - Description and method of measurement for dimension - Part 2: Sacks made from thermoplastic flexible film (GB/T 31556.2-2015, ISO 6591-2:1985, MOD)

3.1 General

When drafting the ordering documents for sacks made from thermoplastic flexible film, 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 - Sack width, b;

- Frill width, e;
- Sack bottom width, c;
- Valve port width, g;
- Valve port length, f;

- Valve sleeve length, i ;
- Valve sleeve position, l : the distance between the outermost edge of the sack and the outermost edge of the valve sleeve is measured parallel to the bottom.

3.2.4 Material

It shall specify the type, quantitative [in grams per square meter (g/m^2)] or thickness [in micron (μm)] of each layer of material, surface treatment (such as anti-slip, anti-static). If there is surface treatment, it shall be stated that the treatment surface faces inward, outward or double-sided treatment.

The material shall specify the following requirements:

- Separable or integral;
- Paper type (such as ordinary paper sack paper, stretchable paper sack paper) and basis weight;
- Film types, such as: low density polyethylene (PE-LD), linear low-density polyethylene (PE-LLD), high density polyethylene (PE-HD), polyvinylidene chloride (PVDC), ethylene-vinyl acetate Ester copolymer (E/VAC);
- Film state (flat film or tube film);
- Film thickness in micrometers (μm);
- Melt flow index of the film, in grams per 10 minutes ($\text{g}/10\text{min}$);
- Length, in millimeters (mm), when it is different from other layers (usually seen in separable or integrated tube films);
- Width of the ruffle, 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 films);

The bottom direction requirements include:

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

3.2.10 Heat seal sealing

Heat seal sealing requirements include:

- Heat sealing margin, n , in millimeters (mm);
- Heat sealing position: the top or bottom of the sack, the top and bottom are determined

according to the printed content.

3.2.11 Filling port (for open sack only)

The requirements for filling port of open sack include:

- Horizontal pasting (with/without):
- All layers;
- Innermost layer has no horizontal pasting.
- Thumb mouth, yes/no.

3.2.12 Printing

Printing requirements include:

- Color and performance requirements of the ink (such as abrasion resistance, UV resistance);
- Print a complete description of the requirements and positions of the main elements, such as the front, back, frills, valve port end, non-valve port end, and valve port end direction.

3.2.13 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;