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**General technical requirements for aseptic
blowing-filling-capping blocks**

无菌吹灌旋一体机通用技术要求

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Foreword

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1 Scope

China's national general technical requirements for aseptic blow-fill-cap blocks. It specifies

the terms and definitions, the models, the types and the basic parameters. A blow-fill-cap block combines three machines that used to be separate: the bottle is blown from a preform, filled and capped within one enclosure, without ever leaving it. The saving is not only floor space. A bottle blown moments before filling has not been handled, stored or transported, so it does not need to be washed and sterilised - it comes out of the mould effectively sterile from the heat of blowing. For aseptic filling of juices, teas and dairy drinks, which must be commercially sterile without heat treatment in the pack, that removes the largest single source of contamination. What the specification has to define is the boundary of the sterile zone and the conditions maintained within it, because the whole product's safety rests on that zone rather than on any subsequent step.

This document specifies the terms and definitions, models, types, basic parameters and working conditions, technical requirements, description The content of test methods, inspection rules, marking, packaging, transportation and storage, etc: This document is applicable to the aseptic blow-fill-spin machine (hereinafter referred to as "non- "Bacteria machine") design, manufacture, inspection and application, etc:

2 Normative references

The contents of the following documents constitute essential provisions of this document through normative references in the text: Among them, dated citations documents, only the version corresponding to that date applies to this document; for undated references, the latest edition (including all amendments) applies to this document:

GB/T 191 Graphical signs of packaging, storage and transportation

GB 2894 Safety Signs and Guidelines for their Use

GB/T 4208-2017 Protection class of enclosure (IP code) GB 4789:

2 National Food Safety Standard - Determination of the total number of bacterial colonies in food microbiological examination GB 4806:

1 National Food Safety Standard General Safety Requirements for Food Contact Materials and Products

GB 5009:226-2016 National Food Safety Standard for Determination of Hydrogen Peroxide Residues in Foods

GB/T 5226:1-2019 Mechanical and Electrical Safety Mechanical and Electrical Equipment Part 1: General Specifications

GB 5749 Hygienic Standard for Drinking Water

GB/T 7311 Packaging Machinery Classification and Model Compilation Method

GB/T 9969 General Principles of Instruction Manual for Industrial Products

GB/T 13277:1-2008 Compressed Air Part 1: Pollutant Purification Level GB/T 13306 Signs

GB/T 13384 General technical conditions for packaging of mechanical and electrical products

GB/T 14253 General technical conditions for light industrial machinery

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