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

GB/T 6547-2026

Replacing GB/T 6547-1998

Corrugated fibreboard - Determination of thickness

瓦楞纸板 厚度的测定

(English Translation)

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Foreword

This document complies with the provisions of GB/T 1.1-2020 "Standardization Work Guidelines Part 1: Structure and Drafting Rules of Standardization Documents".

Drafting.

This document replaces GB/T 6547-1998 "Determination of Corrugated Board Thickness". Compared with GB/T 6547-1998, except for structural adjustments...

Aside from integration and editorial changes, the main technical changes are as follows.

- a) Added terms and definitions (see Chapter 3);
- b) Increased requirements for thickness gauge reading error and repeatability (see 5.1);
- c) A sample cutting device was added (see 5.2);
- d) The sample preparation was modified (see Chapter 8, 5.3 of the 1998 edition);
- e) The distance between the test position and the edge of the specimen and the moving speed of the measuring surface were changed (see 9.2, Chapter 6, 1998 edition);
- f) Added result representation (see Chapter 10);
- g) The test report was amended (see Chapter 11, Chapter 7 of the 1998 edition);
- h) Added calibration of the thickness gauge (see Appendix A).

This document is modified to adopt ISO 3034:2011 "Determination of the thickness of a single layer of corrugated board".

This document has undergone the following structural adjustments compared to ISO 3034:2011.

- a) Chapter 7 corresponds to the standard atmospheric conditions requirements for specimen preparation and testing in Chapters 7 and 8 of ISO 3034:2011;
- b) Appendix A.1 corresponds to 9.2 in ISO 3034:2011 and Appendix A.1;
- c) Appendix A.2 corresponds to 5.2 in ISO 3034:2011.

The technical differences between this document and ISO 3034:2011, and the reasons therefor, are as follows.

- a) The scope has been changed (see Chapter 1) to suit my country's technological conditions;
- b) The thickness terminology has been changed (see 3.2) to suit the industry practices in our country;
- c) The requirements for thickness gauge reading error and parallelism error have been modified (see Table 1) to adapt to my country's technical conditions;
- d) A sample preparation cutting device (see 5.2) has been added to meet my country's testing requirements;
- e) Sampling requirements have been changed, and ISO 186 (see Chapter 6) has been replaced with the normatively referenced GB/T 450 to adapt to my country's technical standards.

Technical conditions;

- f) The temperature and humidity treatment requirements have been changed, and ISO 187 (see Chapter 7) has been replaced with the normatively referenced GB/T 10739 to suit our needs.

The country's technological conditions;

- g) Increased requirements for the cut specimens (see Chapter 8) to improve the accuracy of test results.

The following editorial changes have been made to this document.

---The standard title has been changed to "Determination of Corrugated Cardboard Thickness";

---Added supplementary descriptions of precision in Chapter 10.

Please note that some content in this document may involve patents. The issuing organization of this document assumes no responsibility for identifying patents.

This document was proposed by the China National Light Industry Council.

This document is under the jurisdiction of the National Technical Committee on Standardization of Paper Industry (SAC/TC141).

1 Scope

This document describes the method for determining the thickness of corrugated cardboard.

This document applies to the determination of the thickness of various types of corrugated cardboard.

2 Normative references

The contents of the following documents, through normative references within the text, constitute essential provisions of this document. Dated citations are not included.

For references to documents, only the version corresponding to that date applies to this document; for undated references, the latest version (including all amendments) applies.

This document.

GB/T 450 Paper and paperboard specimen collection and determination of longitudinal and transverse directions, front and back sides of specimens (GB/T 450-2008, ISO 186.

2002, MOD)

GB/T 10739 Standard atmospheric conditions for the treatment and testing of paper, paperboard and pulp specimens (GB/T 10739-2023, ISO 187.

2022, MOD)

3 Terms and Definitions

The following terms and definitions apply to this document.

Corrugated fiberboard A composite paperboard made by bonding one or more layers of corrugated paper between several layers of paper or cardboard.

[Source. GB/T 6544-2026, 3.2, with modifications] 3.2 thickness A static load is applied between the two surfaces of the corrugated cardboard (3.1), and the distance between the two surfaces of the corrugated cardboard is [not specified].

4 Principles

Under the specified static load, the thickness of the corrugated cardboard is measured according to the test requirements using a qualified thickness gauge (3.2).

5.1 Thickness gauge

The thickness gauge has two parallel circular measuring surfaces. Corrugated cardboard is placed between the two measuring surfaces for measurement.

The pressure applied between the two measuring surfaces when measuring the thickness should be (20.0 ± 0.5) kPa.

Note: Other pressure methods exist, but different loading pressures may lead to different measurement results.

The thickness gauge consists of two measuring surfaces. One measuring surface is fixed, while the other can move smoothly at a speed of 2 mm/s along its perpendicular direction.

The measuring surface moves at a speed of 3 mm/s. One measuring surface should have a diameter of (35.7 ± 0.3) mm, and the diameter of the other measuring surface should not be less than this value.