

ICS 85.060

QB

**LIGHT INDUSTRY STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

QB/T 4379-2012

**Portable paper bags
(English Translation)**

Issued on: December 28, 2012

Implemented on: June 1, 2013

Issued by: Ministry of Industry and Information Technology of PRC

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1 Scope

This standard specifies the classification, requirements, test methods, inspection rules and signs, packaging, transportation, storage of portable paper bags.

This standard is applicable to all kinds of portable paper bags made of paper bag paper, Kraft paper, coated white paperboard, coated art printing paper (copper paper), white cardboard, etc. It is also suitable for various paper-based portable paper bags.

2 Normative references

The following documents are essential to the application of this document. For the dated documents, only the versions with the dates indicated are applicable to this document; for the undated documents, only the latest version (including all the amendments) are applicable to this standard.

GB/T 2828.1 Sampling procedures for inspection by attributes - Part 1.

Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection

GB/T 5009.60 Method for analysis of hygienic standard of products of polyethylene polystyrene and polypropylene for food packaging

GB/T 5009.78 Method for analysis of hygienic standard of papers for food packaging

GB 9685 Hygienic standards for uses of additives in food containers and packaging materials

GB 9687 Hygienic standard for polyethylene products used as food containers and table wares

GB/T 10739 Paper, board and pulps - Standard atmosphere for conditioning and testing

GB 11680 Hygienic standard of paper used for food packaging

GB/T 12914 Paper and board - Determination of tensile properties

4.5.1 The raw materials used to make the portable paper bag shall conform to the product standards of the corresponding paper materials. Portable paper bags for the food packaging shall neither use toxic and hazardous raw materials, nor use recycled materials.

4.5.2 Water-based inks, adhesives, etc. for the printing of portable hand bags

for food packaging shall comply with the provisions of GB 9685.

5.1 Standard atmospheric conditions for handling and testing of

specimen

The specimen is subjected to temperature and humidity conditioning according to GB/T 10739. The standard atmospheric conditions of the test are in accordance with GB/T 10739.

5.2 Size deviation

Flatten the bag. Use the steel ruler which has a graduation value of 1 mm to measure the length and width. Make 1 measurement at each of the two end surfaces of the part which needs measurement. Use the maximum deviation as the test result.

5.3 Appearance quality

The appearance quality is visually inspected.

5.4 Adhesive strength of sealing

The adhesion strength of sealing is measured according to the constant speed drawing method in GB/T 12914. Take two sample bags. From the bottom and side of each sample bag, respectively take 5 strips of specimens for the test.

During sampling, it should make the adhesive part locate at the middle of the specimen. When the material breaks whilst the sealing remains unbroken, the sealing strength is expressed by the tensile strength at which the material breaks. Respectively calculate the arithmetic mean of the 10 specimens from the bottom and sides. Take the lower of the two as the test result.

5.5.1 Test equipment. Bag-lifting fatigue testing machine, amplitude (30 ± 2)

mm, frequency 2 Hz ~ 3 Hz.

5.5.2 Load the granular mixture equivalent to twice the nominal mass of the

content a bag. Then hang it on the testing machine, to observe the bag and the belt for damage. Take 3 sample bags for testing. If there are no damages in the

501 ~ 3200 8 8 (16)

3201 ~ 10000 13 13 (26)

6.4 Determination of acceptability. The number of samples for the first test shall be equal to the first sample size given by the scheme. If the number of non- conforming products found in the first sample is less than or equal to the first rejection number, the batch shall be considered acceptable. If the number of non-conforming products found in the first sample is greater than or equal to the first rejection number, the batch is unacceptable. If the number of non- conforming products found in the first sample is between the first receiving number and the first rejection number, the inspection scheme shall give the second sample of the sample number and accumulate the number of non- conforming products as found in the first sample and the second sample. If the cumulative number of non-conforming products is less than or equal to the second receiving number, it is determined that the batch is acceptable. If the cumulative number of non-conforming products is greater than or equal to the second rejection number, it is determined that the batch is unacceptable.

6.5 If the purchaser disagrees with the quality of the product, it shall notify the supplier to re-inspect it within 3 months after the arrival of the goods, or entrust a mutually agreed inspection agency to conduct the re-inspection. If the result of the re-inspection does not meet the requirements of this standard or the contract, it is judged that the batch is unacceptable and the supplier is responsible for handling it; if it meets the requirements of this standard or the contract, it is judged that the batch is acceptable and the purchaser is responsible for handling it.

7 Marking, packaging, transportation and storage

7.1

Each batch of portable paper bags shall be accompanied by a certificate of conformity. The certificate shall indicate the product name, trademark, manufacturer name, site, specification, mass of nominal contents, batch number, quantity, production date, inspector's seal, etc. Food packaging shall be indicated in the sign. The outer packaging shall also have the main content of the marking.

7.2

Each bundle of portable paper bags is tightly wrapped with wrapping paper or plastic film to prevent contamination. The outer packaging material of the portable paper bag for food packaging shall reach the food grade requirements.

7.3

The transportation of portable paper bags shall avoid sun exposure, rain exposure, or in contact to sharp object.

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