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

YC/T 491-2014

**Package of redried products. Inner liner bag of polyethylene
film**

(English Translation)

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Foreword

This standard was drafted in accordance with the rules given in GB/T 1.1-2009.

This standard was proposed by the State Tobacco Monopoly Bureau.

This standard is under the jurisdiction of the National Tobacco Standardization Technical

Committee Subcommittee on Tobacco Materials (SAC/TC144/SC8).

This standard is mainly drafted by. Huahuan International Tobacco Co., Ltd., China Tobacco Standardization Research Center, Tianchang International Tobacco Co., Ltd.

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1 Scope

This standard specifies the terms and definitions, technical requirements, sampling, measurement methods, and inspection rules for polyethylene film bags lined with re-baked products.

Then, packaging, marking, transportation and storage.

This standard is applicable to polyethylene film bags lined with packaging for re-roasted tobacco leaves, stems, chips, and shreds (finished products).

2 Normative references

The following documents are indispensable for the application of this document. For dated references, only dated versions apply to this article.

Pieces. For undated references, the latest edition (including all amendments) applies to this document.

Determination of tensile properties of plastics - Part 3. Test conditions for films and sheets
Standard environment for GB/T 2918 plastic sample conditioning and testing GB/T 5009.60
Analytical method for hygienic standard of polyethylene, polystyrene and polypropylene
molded products for food packaging GB/T 6672 Plastic film and sheet thickness
determination mechanical measurement GB/T 8170 Numerical Rounding Rules and
Representation and Determination of Limit Values GB 9685 Hygienic standard for the use
of additives for food containers and packaging materials QB/T 2358 plastic film packaging
bag heat sealing strength test method

3 Terms and definitions

The following terms and definitions apply to this document.

Lined with polyethylene film bag innerlinerbagofpolyethylenefilm A bag made of a polyethylene blown film that is placed in a corrugated box or sack for packaging the baked product.

4.1 Raw material requirements

The lining polyethylene film bag should be made of new polyethylene material, and the recycled material should not be used; the additive should meet the requirements of GB 9685.

4.2 Appearance and odor

The lining polyethylene film bag should have no odor; the whole bag should be colorless, transparent, free from impurities and stains; there should be no air bubbles, shrinkage holes, cracks, etc.

Defects used.

4.3 Physical indicators

The physical indicators of the polyethylene film bag lined shall comply with the requirements of Table 1.

Table 1 Physical indicators

Indicator	unit	requirement
Dimensional deviation	Length, width, height	deviation (lined bag for carton) % ≤ 3.0
Length and width deviation	(lined bag for sack)	% ≤ 2.0
thickness	Nominal value	mm 0.030~0.080
Limit deviation	mm	≤ 0.010
Average deviation rate	%	≤ 10
Heat sealing strength	N/15mm	≥ 8.0
Tensile strength	MPa	≥ 14.0
Fracture nominal strain	%	≥ 280

4.4 Health indicators

Hygienic indicators for lining polyethylene film bags shall comply with the requirements of Table 2.

Table 2 Health indicators

Indicator	requirements
Evaporation residue/(mg/L)	4% acetic acid, 60 ° C, 2 h 65% ethanol, 20 ° C, 2 h
Normal ethane, 20 ° C, 2 h	≤ 30
Potassium permanganate consumption/(mg/L)	Water, 60 ° C, 2 h ≤ 10
Heavy metal (in Pb)/(mg/L)	4% acetic acid, 60 ° C, 2 h ≤ 1

5.1 Inspection lot

The products produced in the same batch, the same specification and the same process in one delivery are one inspection lot, and the maximum batch is 10,000.

5.2 Sampling of settlement inspection

The sampling plan is determined by both the supplier and the buyer according to the quality control requirements.

5.3 Sampling of type inspection

3 packaging units were randomly selected from the inspection lot, and 5 lining polyethylene film bags were randomly selected from each packaging unit, 3 total 15 pieces, then 3 samples are separately packaged and sent to the laboratory as a laboratory sample for measuring technical indicators, of which 1 is used as a determination the sample, the other two were used as a retest sample.

The preparation of various types of index samples is carried out in accordance with the provisions of Chapter 6.

6.1 Determination conditions

In addition to appearance and odor, health indicators, other items should be balanced at temperature $(23 \pm 2) ^\circ \text{C}$ for at least 4h according to GB/T 2918, and the measurement was carried out under these conditions.

6.2 Appearance and odor test

Visually under natural light or fluorescent light and smell it. The test is carried out at the time of sampling.

6.3.1 Determination of external dimensions

Spread one sample bag flat, and measure the length, width and height of the bag with a steel ruler with a graduation value of 1 mm, at both ends of the required measurement site.

The inner side of the surface is measured 3 times, and the deviation from the nominal value is the largest.

The dimensional deviation is expressed as the ratio of the absolute value of the difference between the measured result and the nominal value to the nominal value, to the nearest 0.1%.

6.3.2 Determination of thickness and thickness limit deviation and thickness average deviation rate According to the provisions of GB/T 6672, the thickness gauge has an accuracy of 1 μm or higher.

A sample having a width of about 15 mm and a length of about 300 mm was cut from the side (or the bottom surface) of the three sample bags, and the method was divided into equal lengths.