
International Standard 6591 / 1

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Packaging — Sacks — Description and method of measurement — Part 1 : Empty paper sacks

Emballages — Sacs — Description et méthode de mesurage — Partie 1 : Sacs vides en papier

First edition — 1984-08-15

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UDC 621.798.15

Ref. No. ISO 6591/1-1984 (E)

Descriptors : packing, paper packaging, bags, description, dimensions, dimensional measurements.

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been authorized has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 6591/1 was developed by Technical Committee ISO/TC 122, *Packaging*, and was circulated to the member bodies in July 1983.

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It has been approved by the member bodies of the following countries :

Australia	Germany, F.R.	Romania
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Belgium	India	Sweden
Bulgaria	Iraq	Switzerland
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Czechoslovakia	Jamaica	Turkey
Denmark	Japan	United Kingdom
Egypt, Arab Rep. of	Malaysia	USSR
Finland	Netherlands	Yugoslavia
France	Poland	

No member body expressed disapproval of the document.

Packaging — Sacks — Description and method of measurement —

Part 1 : Empty paper sacks

1 Scope and field of application

This part of ISO 6591 fixes the description and the dimensional designation of empty paper sacks and specifies the method of measuring those dimensions. It is primarily intended for application to paper sacks as specified in ISO 6590/1.

2 References

ISO 6590/1, *Packaging — Sacks — Vocabulary and types* — Part 1 : Paper sacks.

ISO 6599/1, *Packaging — Sacks — Conditioning for testing* — Part 1 : Paper sacks.

ISO 7023, *Packaging — Sacks — Method of sampling empty sacks for testing*.

3 Definitions

NOTE — Unless otherwise stated, all dimensions in this clause are external. They shall be expressed in millimetres, to the nearest 1 mm.

For the purpose of this International Standard the following symbols and definitions apply.

3.1 length of sack, a : Distance between the transverse edges of the flat sack, measured at the centre, perpendicular to the bottom.

3.2 width of sack, b : Distance between the longitudinal edges of the flat sack, measured at the centre, parallel to the bottom.

3.3 width of gusset, e : Distance between the external creases of the opened out gusset.

3.4 width of end, c : Distance between the two bottom edge-folds, measured at the centre, parallel to the sack length.

3.5 width of valve, g : Internal dimension of the valve between the valve edge-folds or, in the case of a sewn sack, between the valve edge-fold and the adjacent stitch line.

3.6 length of valve, f , for

3.6.1 sewn sack : Distance between the outermost edge of the sack and the innermost edge of the valve/sleeve, measured parallel to the bottom.

3.6.2 pasted hexagonal bottom sack : Distance between the outermost edge of the sack and the innermost edge of the valve/sleeve minus half of bottom width, measured at the centre parallel to the bottom.

3.7 length of valve sleeve, i : Longitudinal dimension of internal or external sleeve, parallel to the bottom.

3.8 width of valve sleeve, v : Inner measurement of the sleeve across the bottom, or in the case of a sewn sack between the inner edge of the sleeve and the adjacent stitch line.

3.9 sewing line distance, n : Distance of the sewn closure from the sack edge, measured perpendicular to the closure.

3.10 length of closure turn over, p : Length of the open flap on a turn over bottom sack, measured at the centre, perpendicular to closure.

4 Description and dimensional designation

Sacks are described by an indication of their type (open-mouth sewn flat sack, valved sewn flat sack, etc.), followed by the dimensions as indicated in 4.1 and 4.2.

NOTE — All figures shown in 4.1 and 4.2 are of completed sacks with the manufacturer's closure.

4.1 Open-mouth sack

4.1.1 Open-mouth sewn flat sack

Sack width b / sack length a (see figure 1).

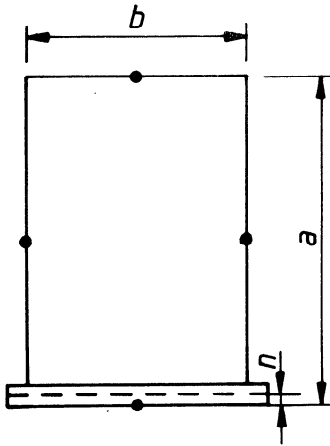


Figure 1

4.1.3 Open-mouth pasted flat hexagonal bottom sack

Sack width b / sack length a / width of bottom c (see figure 3).

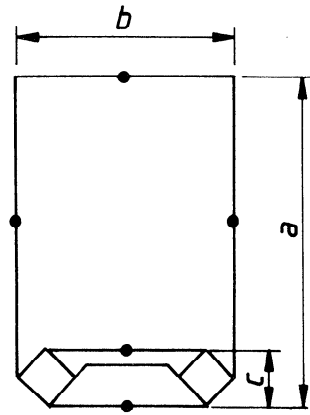


Figure 3

4.1.2 Open-mouth sewn gusseted sack

Sack width b / width of gusset e / sack length a (see figure 2).

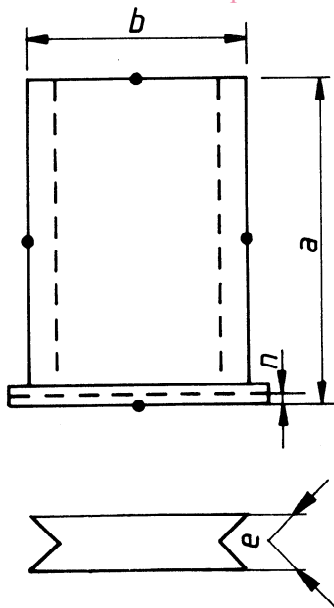


Figure 2

NOTE — Gusset diagram also applies to figures 5, 6 and 8.

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4.1.4 Open-mouth pasted flat turn over bottom sack

Sack width b / sack length a / length of closure turn over, p (see figure 4).

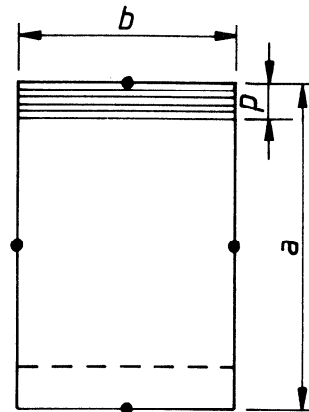
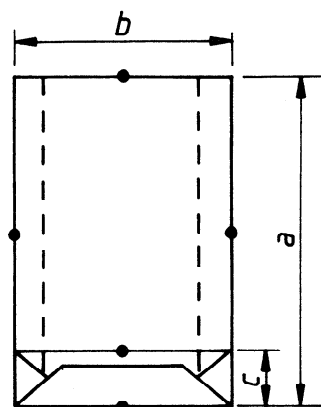


Figure 4

4.1.5 Open-mouth pasted gusseted rectangular bottom sack

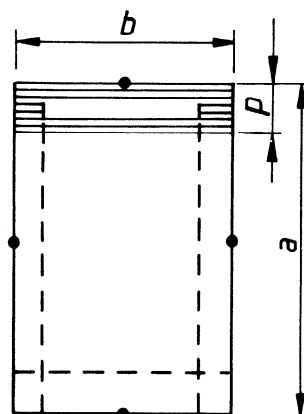
Sack width b / width of gusset e / sack length a / width of bottom c (see figure 5).



NOTE — Dimension e is shown in figure 2.

4.1.6 Open-mouth pasted gusseted turn over bottom sack

Sack width b / width of gusset e / sack length a / length of open flap p (see figure 6).



NOTE — Dimension e is shown in figure 2.

Figure 5 **STANDARD PREVIEW** Figure 6
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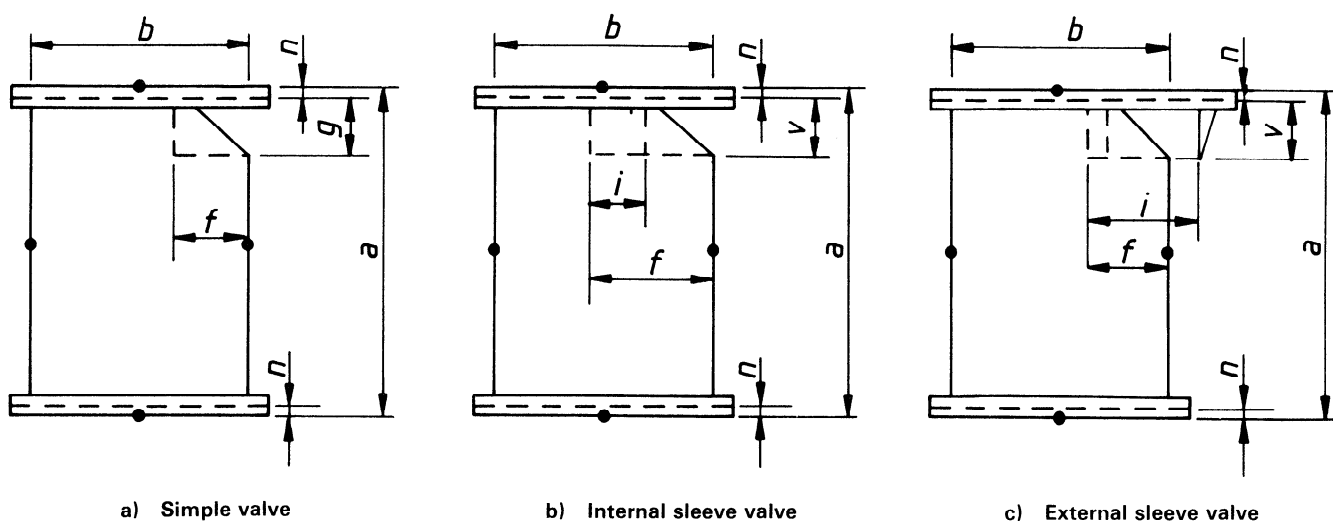
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4.2 Valved sack

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4.2.1 Valved sewn flat sack

Sack width b / sack length a / width of valve g (width of valve sleeve v) / length of valve f / (length of valve sleeve i) (see figure 7).



a) Simple valve

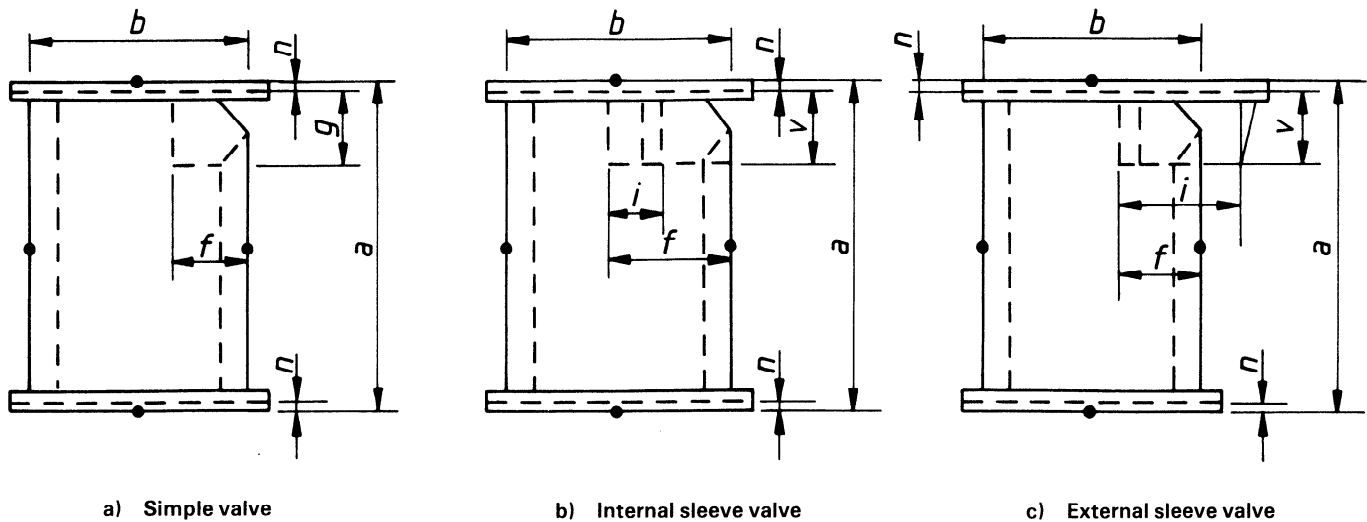
b) Internal sleeve valve

c) External sleeve valve

Figure 7

4.2.2 Valved sewn gusseted sack

Sack width b / width of gusset e / sack length a / width of valve g (width of valve sleeve v) / length of valve f / (length of valve sleeve i) (see figure 8).



NOTE Dimension e is shown in figure 2.
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 Figure 8

4.2.3 Valved pasted flat hexagonal ends sack

Sack width b / sack length a / width of bottom c / width of valve g (width of valve sleeve v) / length of valve f / (length of valve sleeve i) (see figure 9).

NOTES

- 1 The figure represents one type of valve but there are a number of alternative valve designs possible with this type of sack.
- 2 The two ends of a pasted valve sack can differ in width; in this case, the end with the valve shall be designated first :

$$b/a/c_1/c_2/g (v)/f/i$$

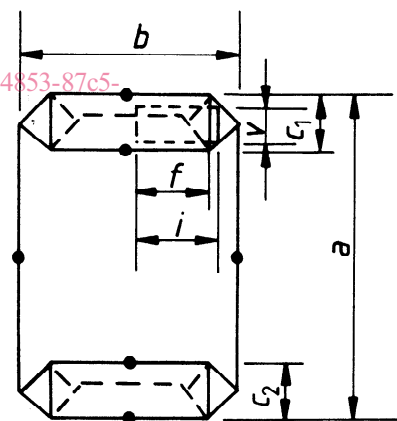


Figure 9

Table — Summary of descriptions and dimensional designations of paper sacks

Clause	Description	Dimensional designation
4.1.1	Open-mouth sewn flat sack	b/a
4.1.2	Open-mouth sewn gusseted sack	$b/e/a$
4.1.3	Open-mouth pasted flat hexagonal bottom sack	$b/a/c$
4.1.4	Open-mouth pasted flat turn over bottom sack	$b/a/p$
4.1.5	Open-mouth pasted gusseted rectangular bottom sack	$b/e/a/c$
4.1.6	Open-mouth pasted gusseted turn over bottom sack	$b/e/a/p$
4.2.1	Valved sewn flat sack	$b/a/g (v)/f/i$
4.2.2	Valved sewn gusseted sack	$b/e/a/g (v)/f/i$
4.2.3	Valved pasted flat hexagonal ends sack	$b/a/c/g (v)/f/i$

4.3 Valve position

The following designation is applicable to both pasted and sewn valved sacks.

With the longitudinal overlap downwards and displaced to the right of the sack when viewed from above, the valve position shall be described as top or bottom, and left or right, as shown in figure 10.

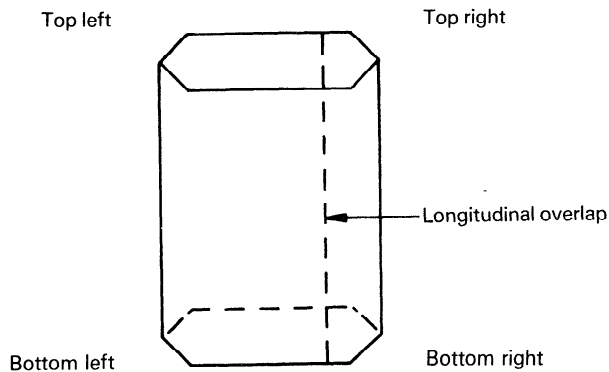


Figure 10

NOTES

- 1 Pasted valved sacks may be manufactured with the pasted ends turned towards or away from the side with the longitudinal overlap.
- 2 The position of printing, if any, does not affect this nomenclature.
- 3 Not all types of valve are available in every position.

5 Method of measurement

5.1 Equipment

Ruler or instrument graduated in millimetres, and capable of measuring dimensions of the sack, to an accuracy of 1 mm.

5.2 Sampling

Sampling shall be carried out in accordance with ISO 7023.

5.3 Procedure

Condition the sacks in one of the conditioning atmospheres given in ISO 6599/1 until equilibrium has been reached. This equilibrium is considered to have been reached when the sacks measured at intervals of not less than 6 h, do not differ by more than 1 mm between consecutive measurements. Usually 1 d for sacks without, and 3 d for sacks with a moisture barrier will be sufficient.

Place each sack on flat horizontal surface, and smooth out any wrinkles.

Measure the dimensions at the measuring points indicated in clause 4 for the type of sack concerned, to an accuracy of 1 mm. Calculate the dimension as the mean of all determinations and express the result to the nearest millimetre.

5.4 Test report

The test report shall include the following information :

- a) full information necessary for complete identification of the sample;
- b) reference to this International Standard;
- c) conditioning atmosphere used;
- d) the measured dimensions, expressed to the nearest millimetre;
- e) any unusual features observed;
- f) any additional information not specified in this International Standard, or any circumstances or influences, which might have affected measurements.

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