INTERNATIONAL STANDARD

ISO 8351-1

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Packaging — Method of specification for sacks —

Part 1: Paper sacks

Emballages — Méthode de spécification des sacs —
Partie 1: Sacs en papier

Reference number
ISO 8351-1:1994(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 8351-1 was prepared by Technical Committee ISO/TC 122, *Packaging*, Subcommittee SC 2, *Sacks*.

ISO 8351 consists of the following parts, under the general title *Packaging — Method of specification for sacks*:

— *Part 1: Paper sacks*

— *Part 2: Sacks made from thermoplastic flexible film*

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Packaging — Method of specification for sacks —

Part 1:
Paper sacks

1 Scope

This part of ISO 8351 provides a checklist for the characteristics of paper sacks to be specified when ordering. These ordering specifications cover the description of the sack and do not deal with quantitative performance requirements. This part of ISO 8351 is primarily intended for application to the types of paper sacks specified in ISO 6590-1.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 8351. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 8351 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 6590-1:1983, *Packaging — Sacks — Vocabulary and types — Part 1: Paper sacks.*

ISO 6591-1:1984, *Packaging — Sacks — Description and method of measurement — Part 1: Empty paper sacks.*

3 Method of specification

3.1 General

When drawing up the specifications of a paper sack for ordering purposes, customer and manufacturer shall consider each item in the following lists and, where relevant, mutually agree to include them in the ordering specifications at an appropriate level.

The format of the ordering specification shall be agreed upon between the customer and the manufacturer.

3.2 Description

3.2.1 Sack type

3.2.1.1 Open-mouth

— sewn flat;

— sewn gusseted;

— pasted flat hexagonal-bottom;

— pasted flat turn-over-bottom;

— pasted gusseted rectangular-bottom;

— pasted gusseted turn-over-bottom;

— other not specified above.

3.2.1.2 Valved (closed-mouth)

— sewn flat;

— sewn gusseted;

— pasted flat hexagonal-ends;

— pasted gusseted rectangular-ends;

— other not specified above.

3.2.2 Tube type

— flush-cut;

— stepped-end;

— notched-end.

3.2.3 Dimensions

The following dimensions, in millimetres, shall be specified in accordance with ISO 6591-1.

— length of sack, a

— width of sack, b

— width of gusset, e

— width of bottom, c

— width of valve, g

— length of valve, f

— width of valve sleeve, v

— length of valve sleeve, i

— length of turn-over, p

— sewing line distance, n, from adjacent sack transverse edge;

— valve sleeve position, l: distance between outermost edge of sack and outermost edge of valve sleeve, measured parallel to the bottom.

3.2.4 Type of material

Each ply shall be specified by type, grammage (in grams per square metre) or thickness (in micrometres), surface treatment [e.g. coating type and grammage, antislip type and application method, direction of the treatment faces (face in or face out)].

Thermoplastic film plies, normally an inner ply, shall be specified as follows:

— loose or integral;

— film type, e.g. PE-LD, PE-LLD, PE-HD, PVDC or E/VAC;

— film state (flat or tubular);

— film thickness, in micrometres;

— film melt flow index, in grams per 10 min

— length, in millimetres, where different from other plies (usually when loose or integral tubular);

— gusset, in millimetres, where different from other plies (usually when loose or integral tubular);

— width, in millimetres, where different from other plies (usually when loose or integral tubular);

— heat seal distance, in millimetres, from adjacent sack or thermoplastic ply transverse edge;

— skirt length, in millimetres, only for loose type;

— Z-fold;

— cuffed or uncuffed.

3.2.5 Perforations

— beneath valve: number, size and pattern;

— ply: number, spacing, size and location of holes.

3.2.6 Valve/sleeve

— valve type: simple, reinforced, internal sleeve, external sleeve;

— valve position: i.e. in which corner of sack;

— sleeve materials: e.g. kraft, polyethylene-coated kraft, tubular polyethylene.

3.2.7 Longitudinal seam

— type: continuous, interrupted or unbonded;

— overlap width, in millimetres.

3.2.8 Pasted closure type

— flush-cut bottom: with/without bottom patch and/or bottom cap;

— stepped-end bottom: with/without bottom patch and/or bottom cap;

— turn-over bottom.

3.2.9 Bottom patch

— position: valved end, non-valved end;

— material: type and grammage;

— dimensions, in millimetres: length, width.

3.2.10 Bottom cap

— position: valved end, non-valved end;

— material: type and grammage;

— dimensions, in millimetres: length, width;

— wrap around: yes/no.

3.2.11 Bottom orientation

— folded towards sack face side;

— folded towards sack back side.

3.2.12 Sewn closures/sewing

3.2.12.1 Type of sewn closure

— simple;

— taped and sewn (tape under sewing);

— sewn and taped (tape over sewing);

— taped and sewn and taped (reinforced);

— heat-sealed and sewn and taped.

3.2.12.2 Type of stitch

— single chain stitch: with/without filter cord;

— double locked stitch: with/without filter cord.

3.2.12.3 Type of thread

— natural;

— synthetic;

— blend.

3.2.12.4 Type of filter cord

— jute;

— paper;

— other.

3.2.12.5 Stitch count per 250 mm.

3.2.12.6 Tape protrusion from sack edges, in millimetres.

3.2.12.7 Number of stitches in protruding tape.

3.2.12.8 Tape

— material;

— colour.

3.2.12.9 Sewing position: top or bottom of sack in relation to print.

3.2.13 Filling aperture (open-mouth sacks only)

— knife-cut pattern: number of serrations per 100 mm and depth of serrations, in millimetres;

— transverse pasting, (yes/no):

a) all plies;

b) discrete plies;

c) longitudinal and horizontal position of paste spots.

— thumb cut, yes/no.

3.2.14 Adhesives

— longitudinal seam pasting: type, e.g. starch, PVAC;

— transverse pasting: type, e.g. hot melt, CMC;

— bottom pasting: type, e.g. resin;

— bottom patch and cap pasting: type;

— special requirements, e.g. water-resistant, heat-stable, etc.

3.2.15 Printing

— ink type, e.g. water-based acrylic, organic pigments;

— ink colours, e.g. Pantone ref. Nos.

— complete description of requirements and position of major elements of print, e.g. face side, back side, gussets, valve end, non-valve end.

3.2.16 Packaging

— sacks in bundles: tied/untied/folded;

— bundles in bales: total number of sacks per bale;

— bundles in palletized units: total number of sacks per unit;

— bundle stacking pattern;

— shingled reels: diameter and overlap in millimetres, number of sacks;

— pallet size and type, four-way entry/two-way entry;

— maximum unit height, in millimetres;

— special requirements for automatic packers;

— pallet wrapping: plastic, paper, shrink wrap, stretch wrap, wooden frame or fibre board on top of pallet;

— pallet strapping: steel, plastic;

— protection from strapping;

— labelling of pallet load.

3.2.17 Accompanying documentation

— customer's specification number;

— manufacturer's specification number;

— delivery address;

— invoice address;

— other acknowledgement.

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Descriptors: packaging, paper packaging, bags, technical data sheets, orders (sales documents).

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