
**Pallets for materials handling —
Flat pallets —**

**Part 1:
Test methods**

Palettes pour la manutention — Palettes plates —

Partie 1: Méthodes d'essai
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ISO 8611-1:2011

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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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. 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.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 8611-1 was prepared by Technical Committee ISO/TC 51, *Pallets for unit load method of materials handling*.

This second edition cancels and replaces the first edition (ISO 8611-1:2004), which has been technically revised.

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ISO 8611 consists of the following parts, under the general title *Pallets for materials handling — Flat pallets:*

- *Part 1: Test methods* <https://standards.iteh.ai/catalog/standards/sist/2d653183-020a-40e2-a9f6-b510b5560d8c/iso-8611-1-2011>
- *Part 2: Performance requirements and selection of tests*
- *Part 3: Maximum working loads*

Introduction

The forces to which pallets are exposed during use vary significantly. The test procedures described in this part of ISO 8611 are approximate simulations of pallet use. These tests help the pallet designer to establish an initial acceptable balance between the cost and the performance of a pallet design. It is intended that all results of tests performed using this protocol be confirmed and verified using field trials before publication of performance or the commercial implementation of a new pallet design.

The nominal load, determined according to this test protocol, does not represent a payload and cannot be verified using field trials. The nominal load is a minimum payload level for use in determining maximum working load according to the procedures in ISO 8611-3. The maximum working load can be verified for a specified payload and intended use, using field trials. It is intended that the publication of the maximum working load include a description of the payload and the intended modes of use of the pallet.

It is essential to exercise care when comparing the results of tests with historic experience using existing pallet designs. User expectations of pallet performance vary. Some require greater and some accept lower levels of performance. Users are accepting different levels of risk when using pallets. Because of the varied performance expectations of pallet users, the results of tests might not always reflect the user's perception of pallet performance in use.

The nominal load might not reflect users' perception of pallet performance because the nominal load does not represent a payload. It is intended that maximum working loads be used to compare with the historic performance of existing pallet designs.

Regarding the use of the ISO 8611 series,

- [this part of ISO 8611 describes the test methods,](https://standards.iteh.ai/catalog/standards/sist/2d653183-020a-40e2-a9f6-b510b5560d8c/iso-8611-1-2011) [ISO 8611-1:2011](https://standards.iteh.ai/catalog/standards/sist/2d653183-020a-40e2-a9f6-b510b5560d8c/iso-8611-1-2011)
- ISO 8611-2 describes the performance requirements and selection of tests, and
- ISO 8611-3 describes tests for determining maximum working loads for known payloads.

This part of ISO 8611 and ISO 8611-2 are required for determining nominal load. The nominal load is the lowest safe load value for the specified support conditions, independent of the type of load (excluding concentrated loads).

This part of ISO 8611, ISO 8611-2 and ISO 8611-3 are required for determining maximum working loads for known payloads.

The nominal load for the intended use is established by the selection of tests in this part of ISO 8611 and the performance requirement is established from criteria in ISO 8611-2.

The following three types of intended use with specified support conditions are defined:

- handling of loaded pallets with racking and stacking;
- handling of loaded pallets without racking;
- handling of loaded pallets without racking or stacking.

To determine the maximum working load through testing given in ISO 8611-3, the deflection under the known payload cannot exceed the limiting deflection (see 4.2, 4.3 and 4.4 of ISO 8611-3:2011) established in this part of ISO 8611 and ISO 8611-2. The maximum working load is the greatest payload that a pallet can be permitted to carry in a specific loading and support condition.

ISO 8611-1:2011(E)

Guidance is given in Annex A of ISO 8611-3:2011 as to the general effect on performance of different load types and stabilization methods. These can only give guidance as to the likely result from tests with the known payload.

Other tests for durability evaluation are specified in this part of ISO 8611.

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Pallets for materials handling — Flat pallets —

Part 1: Test methods

1 Scope

This part of ISO 8611 specifies the test methods available for evaluating new flat pallets for materials handling.

The test methods are split into groups for:

- nominal load testing;
- maximum working load testing;
- durability comparison testing.

It is not intended to apply to pallets with a fixed superstructure or a rigid, self-supporting container that can be mechanically attached to the pallet and which contributes to the strength of the pallet.

NOTE Specific tests for determining load capacity do not replace the value of conducting field tests on specific pallet designs.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 445, *Pallets for materials handling — Vocabulary*

ISO 2244, *Packaging — Complete, filled transport packages and unit loads — Horizontal impact tests*

ISO 8611-2, *Pallets for materials handling — Flat pallets — Part 2: Performance requirements and selection of tests*

ISO 12777-1, *Methods of test for pallet joints — Part 1: Determination of bending resistance of pallet nails, other dowel-type fasteners and staples*

EN 13183-2, *Moisture content of a piece of sawn timber — Part 2: Estimation by electrical resistance method*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 445 and the following apply.

3.1 breaking of one component

fracture of a structural element which significantly affects the strength, stiffness or functionality of a pallet

3.2 concentrated load

load concentrated over an area of less than 50 % of the pallet top deck

[ISO 445:2008, definition 2.3]

3.3 maximum working load

greatest payload that a pallet is permitted to carry in a specific loading and support condition

NOTE 1 This varies according to the type, distribution, arrangement and means of stabilization of the load and the system of support, and can be lower or higher than the nominal load (see ISO 8611-2 and ISO 8611-3).

NOTE 2 Adapted from ISO 445:2008, definition 2.7.

3.4 nominal load

R
lowest safe load value for the specified support conditions, independent of the type of load (excluding concentrated loads)

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NOTE 1 "Specified support conditions" refers to the range of conditions of use in 7.1 of ISO 8611-2:2011.

NOTE 2 Nominal load does not represent an actual payload on a pallet in use. The nominal load is used for comparing the performance of different pallets.

NOTE 3 Adapted from ISO 445:2008, definition 2.2.

3.5 payload

Q
load carried by the pallet in use

[ISO 445:2008, definition 2.8]

NOTE This can be above, identical to or below the nominal load.

3.6 platen

solid, rigid surface on a test machine used for applying a load to test a sample pallet

3.7 racking

storage of unit loads in drive-in or beam racks with free, unsupported spans

[ISO 445:2008, definition A.3.1]

3.8 safety factor

ratio of the ultimate load to the nominal load

NOTE In ISO 8611 (all parts), this ratio is at least 2,0.

3.9**solid load**

single, compact, rigid, homogeneous load, supported by all the blocks and/or stringers (bearers) of the pallet

NOTE Adapted from ISO 445:2008, definition 2.6.

3.10**stacking**

placing of pallets with unit loads one upon the other without recourse to intermediate shelves or racking

NOTE Adapted from ISO 445:2008, definition A.2.1.

3.11**stiffness**

relative deformation of a pallet or component under load

NOTE High stiffness means small displacement, deflection or deformation for a given load.

3.12**test load**

P

load applicators, the load board or load box and the applied load itself

3.13**ultimate load**

U

load at which compression, displacement or deflection is no longer contained, resulting in the destruction of the specimen or breaking of one component, or when displacement, deformation or deflection becomes excessive

NOTE See Table 1 of ISO 8611-2:2011. [ISO 8611-1:2011
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3.14**uniformly distributed bonded load**

load spread evenly across the full surface of the pallet top deck, where the pattern of each single layer changes, so that the packages are interlocked

3.15**uniformly distributed unbonded load**

load spread evenly across the full surface of the pallet top deck where the packages are not interlocked, bound or connected

4 Measurements

Pallets selected for testing shall be measured to ensure that materials, construction and dimensions conform to their associated written specification.

The mass and the material of each pallet shall be determined and recorded at the time of testing.

The moisture content of wooden pallets shall be measured and recorded in accordance with EN 13183-2 at the time of testing.

Clause 9 gives further details on what should be recorded during testing and in the written report.

5 Precision and accuracy of tests and apparatus

Test apparatus shall satisfy the following requirements.

- a) In the design of the test equipment, the tolerances on all dimensions shall be ± 2 %.
- b) The accuracy of measuring equipment for tests shall be $\pm 0,5$ mm.
- c) The accuracy of positioning of every component, excluding the test load, shall be ± 2 mm; measurement gauges shall be positioned to ± 4 mm.
- d) The accuracy of positioning of the centre of application of test load (where used) shall be ± 10 mm.
- e) The total mass of the test load applied shall be within ± 3 % of the prescribed value.

No part of any test rig shall distort an amount greater than ± 3 mm when under maximum test load. Distortion of the test rig shall be taken into account in measuring deflections of the pallet.

NOTE 1 Using heavy duty steel box sections in the construction of fixtures in tests 1 and 6 (see Table 1) normally results in central distortions approaching the 3 mm given limit.

The inclined plane apparatus shall be constructed as specified in ISO 2244 and shall permit inclined travel distance to change by 250 mm increments from 250 mm to 1 250 mm, each increment to within ± 5 mm.

NOTE 2 Experience suggests that the interlaboratory test precision for conducting tests 1a and 7a is 16,7 %; and 19,8 % when conducting tests 1b and 7b.

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6 Test load

A general value for the test load is not fixed. The test load for each test shall be determined in accordance with ISO 8611-2.

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The test load shall be applied with a testing machine, hydraulic or air pressure, or with dead load and shall increase continuously or in steps to the failure (for determination of ultimate load) or up to the fixed value (for qualification tests).

7 List of tests

Table 1 provides a matrix of the tests (in this part of ISO 8611) that shall be performed on flat pallets. Tests numbered 1, 2, 3, 4, 5, 6 and 7 shall be performed with new pallets.

NOTE 1 Tests 1, 2, 4, 5, 6 and 7 can be carried out on one test sample (first stiffness, then strength, when there is a declared nominal load) or on two separate samples.

NOTE 2 The tests are grouped into the three sections shown in Table 1. The selection of tests and evaluation of pallet performance are set out in ISO 8611-2 and ISO 8611-3.

8 Tests

8.1 Test 1 — Bending tests

8.1.1 Purpose

The purpose of these tests is to determine the bending strength (test 1a) and bending stiffness (test 1b) of the pallet in racking situations.

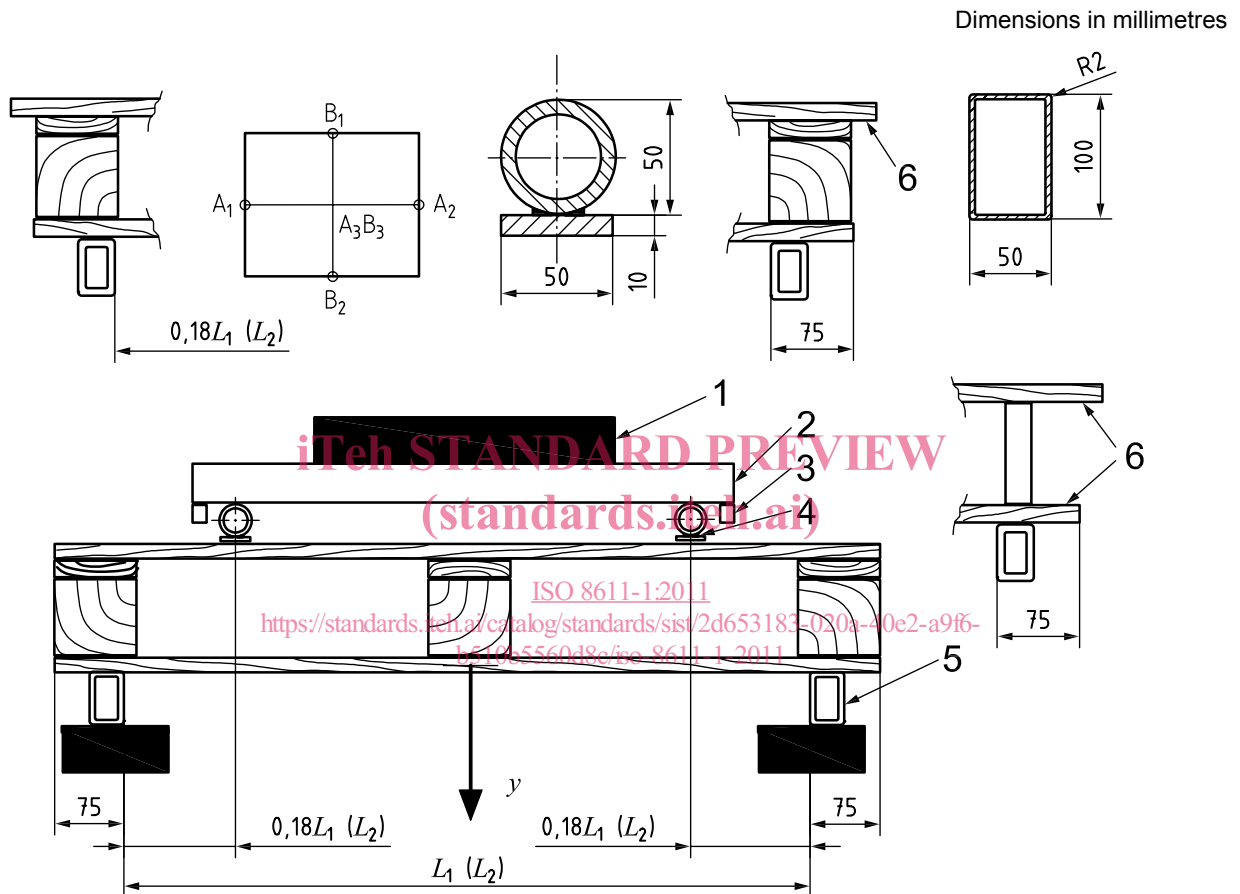
Table 1 — List of tests

Test no.	Test measurement	Characteristic	Handling activity or purpose of the test	(Sub)clause ref.
Nominal load tests				8
1	Bending tests			8.1
1a	Bending strength	Pallet length, width	Racking	8.1.3.1
1b	Bending stiffness			8.1.3.2
2	Forklifting tests			8.2
2a	Bending strength	Top deck	Lifting with forklift and pallet trucks	8.2.3.1
2b	Bending stiffness			8.2.3.2
3	Compression tests for blocks or stringers			8.3
3a	Block or stringer strength	Height of blocks, stringers	Any activity that compresses blocks or stringers, including stacking	8.3.3.1
3b	Block or stringer stiffness			8.3.3.2
4	Stacking tests			8.4
4a	Deck strength test	Top and bottom deck	Stacking	8.4.3.1
4b	Deck stiffness test			8.4.3.2
5	Bottom deck bending tests			8.5
5a	Bending strength	Bottom deck	Twin track conveyors	8.5.3.1
5b	Bending stiffness			8.5.3.2
6	Wing pallet bending tests			8.6
6a	Bending strength	Pallet length, width	Lifting with slings	8.6.3.1
6b	Bending stiffness			8.6.3.2
Maximum working load tests — With payload or airbag				
1	Bending test			8.1
1b	Bending stiffness	Pallet length, width	Racking	8.1.3.2
7	Airbag bending tests			8.7
7a	Bending strength	Pallet length, width	Racking	8.7.3.1
7b	Bending stiffness			8.7.3.2
2	Forklifting tests			8.2
2b	Bending stiffness	Top deck	Lifting with forklift and pallet trucks	8.2.3.2
4	Stacking tests			8.4
4b	Deck stiffness test	Top and bottom deck	Stacking	8.4.3.2
5	Bottom deck bending tests			8.5
5b	Bending stiffness	Bottom deck	Twin track conveyors and narrow span beam racking	8.5.3.2
6	Wing pallet bending tests			8.6
6b	Bending stiffness	Pallet length, width	Lifting with slings	8.6.3.2
Durability tests				
8	Static shear test	Decks, blocks, stringers	Distortion resistance	8.8
9	Corner drop test	Diagonal rigidity	Resistance to impacts	8.9
10	Shear impact test	Decks, blocks, stringers	Distortion resistance	8.10
11	Top deck edge impact test	Top leading deckboard	Resistance to fork arms	8.11
12	Block impact test	Corner block, stringer	Resistance to fork tip	8.12
13	Static coefficient of friction test	Under deck/fork arms	Slip resistance on fork arms	8.13
14	Slip angle test	Top deck/payload	Slip resistance of loads	8.14

8.1.2 Procedure

8.1.2.1 In order to establish the weakest pallet support dimension, test one pallet across the length of the pallet and then a second pallet across the width of the pallet. There is no requirement for further tests on the stronger dimension unless the result is within 15 % of the weaker.

8.1.2.2 This having been established, place a fresh pallet across its weakest side, top deck uppermost, on pallet supports positioned with their inside edges 75 mm from the outer edges of the pallet. The load applicators shall be positioned at $0,18 L_1$ or $0,18 L_2$, where measured as shown, where L_1 or L_2 is the distance between the pallet supports (see Figure 1).



Key

- 1 test load
- 2 load board
- 3 safety stop
- 4 load applicator
- 5 support
- 6 wing
- y deflection

Figure 1 — Bending test

8.1.2.3 Load applicators and supports shall be flush with or project beyond the edges of the pallet. Edges shall be relieved with (2 ± 1) mm radii. Where load applicators coincide with gaps between deckboards, in-fill pieces of equal thickness to deckboards with 3 mm to 6 mm overall clearance on each shall be used. Place on the pallet deck, the load applicators and the load board, then apply the rest of the test load.