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Plastics Flat Pallets

塑料平托盘

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Plastics Flat Pallets

1 Theme Contents and Scope of Application

This Standard specifies the basic requirements for product classification, technical requirements, test methods, inspection rules and signs, transportation, and storage of plastic flat pallets.

This Standard is applicable to single-sided and double-sided plastic flat pallets (hereinafter referred to as pallets) that use high-density polyethylene, polypropylene, etc. as the main raw materials, and can be used in 2-way or 4-way with a cross load P of 1000 kg.

2 Normative References

GB 2918 Plastics - Standard atmospheres for conditioning and testing

GB 2934 Flat Pallets for through Transit - Series of External Dimensions

GB 3716 Vocabulary of Terms Relating to Pallets

GB 4996 Testing Methods of Wooden Flat Pallets for through Transit

3 Terms

It shall be implemented according to the provisions of GB 3716.

4 Product Classification

4.1 The categories of pallets can refer to Table 1.

4.2 The dimension of pallets can be implemented according to the provisions of GB 2934.

6 Test Methods

6.1 Conditioning of the specimen and standard environment for testing

The specimens in Sub-clauses 6.4, 6.5 and 6.7 shall be carried out conditioning for no less than 48h in an environment with a temperature of $23\pm 2^{\circ}\text{C}$ and a relative humidity of 45%~55% as specified in GB 2918; and the test shall be carried out under this condition.

6.2 Test device

The size error of the test device is $+2\% \sim -2\%$;

The accuracy of the measuring instrument is 0.5 mm;

The position accuracy of each component including the test load is ± 2 mm;

The total error of the test load is $+1\% \sim -1\%$.

6.3 Stacking test

6.3.1 Procedures

- a. Place the pallet on a flat, hard horizontal surface as shown in Figure 1; and place a test load block with an external dimension of 300 mm $\times$ 300 mm $\times$ 25mm on the centre point of the outer pad;
- b. The test load plate is placed on the test load block; and the test load is increased to $0.25 P$. The test load includes the mass of the test load block and the test load plate. The test load must be evenly distributed, and record the Value y_1 at this time;
- c. Within 1~5 min, increase the test load to $1.1 P$. The test load must be evenly distributed. Keep the test load for 24h, and record the Value y_2 at this time;
- d. The deformation of point A is expressed by the average of the results measured at A_1 and A_2 ;
- e. Test the four corner pads in sequence.

6.7.2 Calculation

$$\phi_2 = \frac{\delta}{L} \times 100 \quad \dots\dots\dots (4)$$

Where:

ϕ_2 – deflection rate, in %;

δ – the deflection value when the test load is $1.1P$, in mm;

L – length of the pallet, in mm.

6.7.3 Results

After unloading, the appearance shall be free of the cracks and deformation that affect use. The test result is expressed by the arithmetic mean value.

7 Inspection Rules

7.1 Inspection classification

Exit-factory inspection: The products shall be inspected appearance one by one, and it shall conform to the provisions of 5.3.

Type inspection: each batch of products shall be inspected item by item in accordance with 5.3. When raw materials, formulas, and process conditions change, type inspection must be carried out. The longest period of type inspection shall not exceed three months.

7.2 Batching

The same raw material, the same formula, the same process conditions, and the same specification of pallets constitute one batch; and the maximum quantity of each batch shall not exceed 5000 pieces.

7.3 Sampling

Each test shall be carried out with no less than 3 pallets.

7.4 Judgment rules

When one appearance item is unqualified, the pallet shall be judged as unqualified.

When any item of the physical and mechanical properties is unqualified, double sampling is required, and the unqualified items shall be re-inspected. After the re-

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