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PE (PP, PET) Coated Paper and Board for Food Packaging

食品包装用淋膜纸和纸板

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PE (PP, PET) Coated Paper and Board for Food Packaging

1 Scope

This Standard specifies the classification, requirements, test methods, inspection rules, mark, packaging, transportation and storage of PE (PP, PET) coated paper and board for food packaging.

This Standard is applicable to PE (PP, PET) coated paper and board for food packaging. It is processed under the substrate of paper with single or double-side PE (PP or PET) coat.

2 Normative References

The following documents are indispensable to the application of this Standard. In terms of references with a specified date, only versions with a specified date are applicable to this Standard. The latest version (including all the modifications) of references without a specified date is also applicable to this Standard.

GB/T 450 Paper and Board - Sampling for Testing and Identification of Machine and Cross Direction Wire Side and Felt Side

GB/T 451.1 Paper and Board - Determination of Size and Deviation

GB/T 451.2 Paper and Board - Determination of Grammage

GB/T 451.3 Paper and Board - Determination of Thickness

GB/T 462 Paper, Board and Pulp - Determination of Moisture Content of Analytical Sample

GB/T 2679.2 Sheet Materials - Determination of Water Vapor Transmission Rate - Gravimetric (Dish) Method

GB/T 2828.1 Sampling Procedures for Inspection by Attributes - Part 1: Sampling Schemes Indexed by Acceptance Quality Limit (AQL) for Lot-by-lot Inspection

GB 4806.1 National Food Safety Standard - General Safety Requirements on Food Contact Materials and Articles

GB 4806.7 National Food Safety Standard - Food Contact Plastic Materials and Articles

4.2 The physical index of base paper of coated paper and board for food packaging shall comply with the requirements of corresponding product standards.

4.3 The safety requirements of coated paper and board for food packaging shall comply with stipulations in GB 4806.8 and GB 4806.7.

4.4 The width, diameter of rolls, and the dimension of surface plate of coated paper and board for food packaging shall comply with stipulations of the contract; the dimensional deviation shall be $\leq \pm 3$ mm, the degree of skewness of surface plate shall be ≤ 3 mm.

4.5 The surface of coated paper and board for food packaging shall be clean, flat and uniform; there shall be no external defects, such as bright strip, leakage, bubble, oil stain, wrinkle, eyelet and gap, etc.

4.6 The trimming of coated paper and board for food packaging shall be neat; the end face shall be even and clean; rolled coated paper and board shall be tightly winded, and the paper core shall not be loose or deformed.

4.7 Coated paper and board for packaging of the same batch of food shall manifest even colors; there shall be no obvious chromatic aberration.

5 Test Methods

5.1 Sampling shall comply with GB/T 450; the processing of sample and the standard atmospheric conditions for testing shall comply with GB/T 10739.

5.2 Dimensional deviation and the degree of skewness shall be determined in accordance with GB/T 451.1.

5.3 Grammage deviation shall be determined in accordance with GB/T 451.2. It shall be expressed by the result of dividing the difference between the average value and nominal value of the grammage of 5 pieces of sample by the nominal value.

5.4 The determination of grammage deviation of coat shall be conducted in this way: use a sampler to cut 3 pieces of sample (area: 0.01 m²) horizontally along the paper sample; place it in a metal or glass vessel that contains 95% ethanol, guarantee that the sample is completely soaked in ethanol. Wait for 10 min, take it out; slightly peel off the coat and remove paper fiber on the coat. Dry it, then, respectively place the 3 coats on a balance (division value: 0.001 g) to weight the coats. Take the difference between the average value and nominal value of the grammage of the 3 coats as the result; express it by g/m². The result shall retain one decimal point.

NOTE: in terms of sample with coat that cannot be easily peeled off, the soaking time can be properly prolonged, till coat can be peeled off.

Appendix C

(normative appendix)

Determination of Permeability

C.1 Sampling

Take 3 pieces of 200 mm x 200 mm from each sample; the selected pieces shall be representative.

C.2 Selection of Test Solution

Test solution shall be selected in accordance with the purposes: coated paper and board for processed paper cup: $(23 \pm 1) ^\circ\text{C}$ or $(90 \pm 5) ^\circ\text{C}$ water; coated paper and board for processed paper bowl: mixed solution of edible oil and $(95 \pm 5) ^\circ\text{C}$ water; coated paper and board for processed paper lunch box: $(95 \pm 5) ^\circ\text{C}$ edible oil; other coated paper and board: optional in accordance with the purposes.

C.3 Test Procedure

C.3.1 Take 1 piece of sample, fold the 4 sides; firmly bond the 4 corners and make it into a sample box (length and width on the bottom: 100 mm; height of 4 sides: 50 mm). Then, place it on a dry glass plate or surface plate that is lined with filter paper.

C.3.2 Pour the test solution into a sample box, add solution till it's 10 mm from the upper edge. Place it evenly for 30 min, then, observe whether there's permeated water (oil) mark on the glass plate or surface plate. During the test process, oil might permeate upward along the sample. It shall be guaranteed that there is no oil on the end of the sample box, otherwise, oil might permeate from the upper end, which might affect the test result.

NOTE: in the test of coated paper and board for processed paper bowl, pour 30.0 g of edible oil into the sample box; add $(95 \pm 5) ^\circ\text{C}$ water till it is 10 mm from the edge of the sample box.

C.3.3 Make 3 pieces from each sample, and if no water (oil) mark shows up on the 3 pieces, it shall be determined as impermeable; otherwise, it shall be determined as permeable.

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