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**BUILDING MATERIAL INDUSTRY STANDARD
OF THE PEOPLE'S REPUBLIC OF CHINA**

ICS 91.100.01

Q 08

Filing number: 24226-2008

JC/T 694-2008

Replacing JC/T 694-1998

Packaging for sanitary wares

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Issued on: June 16, 2008

Implemented on: December 01, 2008

Issued by: National Development and Reform Commission of PRC

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Packaging for sanitary wares

1 Scope

This standard specifies the terms and definitions, packaging forms, packaging materials, technical requirements, test methods, inspection rules, marking, packaging, transportation and storage of packaging of sanitary wares.

This standard applies to the packaging of sanitary wares.

2 Normative references

The provisions in following documents become the provisions of this Standard through reference in this Standard. For the dated references, the subsequent amendments (excluding corrections) or revisions do not apply to this Standard; however, parties who reach an agreement based on this Standard are encouraged to study if the latest versions of these documents are applicable. For undated references, the latest edition of the referenced document applies.

GB/T 153 Coniferous sawn timber

GB 191 Packaging - Pictorial marking for handling of goods

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/T 2829 Sampling procedures and tables for periodic inspection by attributes (apply to inspection of process stability)

GB 5034 Corrugated fiberboard for export products

GB/T 6544 Corrugated fiberboard

GB 6952 Sanitary wares

GB/T 12464 Wooden boxes

GB/T 13483 Package printing terms

BB/T 0016 Packaging material - Honeycomb fiberboard

containers and packaging, including various metal nails, adhesives, adhesive tapes, plastic straps, steel belts or other materials with equivalent effects.

3.7

Open crate

A fence-like wooden box made by nailing the surface of the box with wooden slats.

3.8

Corrugated fiberboard

It is a kind of composite paperboard made of fiberboard and corrugated base paper, which is used to make corrugated boxes.

3.9

Corrugated box

A carton made of corrugated fiberboard joined by folding, nailing, gluing, sleeving, or other methods.

3.10

Honeycomb fiberboard

After the continuous honeycomb core paper is stretched and shaped, the fiberboard whose upper and lower sides are glued with fiberboard paper.

3.11

Honeycomb box

A carton formed by joining honeycomb fiberboard by nailing, gluing, laminating or other methods.

3.12

Stacking test

A test to impose a certain load on the package or container, to evaluate the ability of the package or container to withstand the static load of the stack and the protection of the packaging to the contents.

3.13

The surface of the horizontal platform shall be flat and hard. The height difference between any two points shall not exceed 2 mm. If concrete floor is used, its thickness shall not be less than 150 mm.

7.1.3.2 Loading device

The loading device can be selected from the following two methods according to the shape of the package.

7.1.3.2.1 Free loading plate

The flat plate is suitable for packages whose top surface center and bottom surface center of the container are on a vertical line. The plate shall be able to adjust freely on the specimen to achieve balance together with the appropriate load. The load and the loading plate can also be a whole.

When the loading plate is placed in the center of the top surface of the specimen, its size shall be at least 100 mm larger than each side of the top surface of the specimen. The plate shall be sufficiently rigid, to ensure that it can bear the load without deformation.

7.1.3.2.2 Guided loading plate

The flat plate is suitable for packages whose top surface center and bottom surface center of the packaging container are not in a vertical line. Guided measures are adopted to keep the plate together with appropriate loads always at horizontal. The measures adopted shall not cause friction, thereby affecting the test results.

When the loading plate is placed at the center of the horizontal plane on the top or upper surface of the specimen, its size shall be at least 100 mm larger than each side of the horizontal plane. The plate shall be sufficiently rigid, to ensure that it can bear the load without deformation.

7.1.4 Safety facilities

Attention shall be paid to the stability and safety of the applied load during the test. For this reason, a set of reliable test facilities must be provided; the load can be ensured to be controlled in the event of a dangerous situation, in order to prevent damage to nearby personnel.

7.1.5 Load

Weights can be used, or other devices can be used. The load must meet the requirements of 7.1.6.

7.1.6 Load capacity

plan. If necessary, it may also determine the changes of the specimen at any time.

7.1.7.4 A stacking test is carried out for each specimen. After the test is completed, remove the load and the loading plate. Check the change and damage of the package, its contents and other related materials.

7.2 Drop test

7.2.1 Specimen

The package after the sanitary ware product packaging is completed is used as a specimen. Before the test, check the specimen to ensure that there is no breakage or damage of the fiberboard, box retainer, box and seam joints. The contents shall be free from obvious loosening or cracks or damage. The strapping shall be free from breakage or tripping.

7.2.2 Test principle

Elevate the specimen to a predetermined height. Then make it fall freely according to the predetermined state and collide with the impact platform.

7.2.3 Test device

7.2.3.1 Impact platform

The impact platform shall be a horizontal platform, which shall not move or deform during the test, meanwhile meet the following requirements:

- a) It shall be a whole object which has a mass at least 50 times the mass of the specimen;
- b) It has a large enough area, to ensure that the specimen falls completely on the impact platform;
- c) It shall be flat; the level difference between any two points of the impact platform is not more than 2 mm;
- d) There shall be sufficient rigidity. When any 100 mm² area on the impact platform is subject to a static load of 10 kg, the deformation shall not exceed 0.1 mm.

Note: If concrete floor is used as the impact surface, its thickness must be at least 150 mm to meet the above requirements.

7.2.3.2 Lifting device

The specimen shall not be damaged during lifting and lowering.

8 Inspection rules

8.1 Inspection classification

Product inspection is divided into exit-factory inspection and type inspection.

8.2 Exit-factory inspection

8.2.1 Inspection items

The exit-factory inspection item is the packing quality.

8.2.2 Group-batching rules and sampling plan

The exit-factory inspection items are carried out in accordance with the provisions of GB/T 2828.1, using the one-time sampling plan of general inspection level II.

8.2.3 Judgment rules

The acceptance quality limit (AQL) of appearance quality inspection items is 1.5.

8.3 Type inspection

8.3.1 Inspection items

Type inspection includes all items in the technical requirements of Chapter 6 of this standard.

8.3.2 Inspection conditions

Type inspection shall be carried out in one of the following situations:

- a) During trial production, type finalization and appraisal of newly designed containers;
- b) After formal production, there are major changes in structure and materials that may affect the quality of the container;
- c) When the production of containers is restored after suspension for more than half a year;
- d) When there is a big difference between the exit-factory inspection result and the last type inspection result;
- e) Under normal circumstances, at least once every year;

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