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**SN**

ENTRY-EXIT INSPECTION AND QUARANTINE INDUSTRY

STANDARD OF THE PEOPLE'S REPUBLIC OF CHINA

**SN/T 3390-2012**

**Rules for the inspection of composite laminated self-supporting bag for food packaging of plastics materials and aluminum foil**

食品用塑料、铝箔复合自立袋检验规程

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# Rules for the inspection of composite laminated self-supporting bag for food packaging of plastics materials and aluminum foil

## 1 Scope

This Standard specifies the requirements, sampling, inspection and result determination of composite laminated self-supporting bag for food packaging of plastics materials and aluminum foil.

This Standard is applicable to the inspection of composite laminated self-supporting bag for food packaging of plastics materials and aluminum foil with volume less than 1000mL.

## 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.

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 4857.5, *Packaging-Transport packages - Vertical impact test method by dropping*

GB/T 5009.60, *Method for Analysis of Hygienic Standard of Products of Polyethylene, Polystyrene and Polypropylene for Food Packaging*

GB/T 5009.119, *Determination of diaminomethylbezen of complex for food packaging material*

GB/T 6672, *Plastics film and sheeting - Determination of thickness by mechanical scanning*

GB/T 6673, *Determination of Length and Width of Plastics Film and Sheet*

GB/T 7707, *The intaglio prints for decorating*

entering or containing contents from escaping

## 4 Requirements

**4.1** All raw materials used in this product (including composite adhesives and sealing adhesives) shall meet the requirements of relevant national health standards.

**4.2** The transport packaging shall be lined with plastic film, and the sealing is tight and firm. The transport mark of each package shall be eye-catching, tidy and clear. The contents include country name, product name, specification, batch number, nozzle, gross weight, net weight, quantity, production date, manufacturer name and address, storage period, etc. For export food packaging, it shall comply with the requirements of relevant laws and regulations of the importing country.

**4.3** The packaging environment requires clean, dry, no odor, no pollution. At the same time, each package shall be accompanied by a product certificate.

**4.4** Packaged products shall be stored in an indoor warehouse. The warehouse is required dry, clean, well ventilated, no odor, no pollution. It is strictly forbidden to store toxic or odorous items and contaminated items in the same warehouse. The stacking shall be neat and safe after the products are in the boxes. Do not crush or damage the products in the boxes. It shall be at least 2m away from the heat source. At the same time, the bottom layer shall have a height of not less than 100 mm.

**4.5** The means of transport for the product shall be kept dry, clean, free of odor, and free of contaminants. Handle with care during loading-unloading. Prevent mechanical collision. Do not damage the outer packaging. There are measures to prevent rain, moisture, virus, odor substances and direct sunlight exposure during transport.

## 5 Sampling

### 5.1 Inspection batch

The products continuously produced by the same material and process are one batch and have passed the factory inspection. The maximum batch is 500,000 pieces.

### 5.2 Sampling quantity

**5.2.1** See Table 1 for appearance inspection sampling quantity. The general inspection level (I L) is II; and the acceptance quality limit (AQL) is 4.0.

Aluminum foil / low density polyethylene (LDPE)	4.0
Biaxially stretched nylon (BOPA) / cast polypropylene (CPP)	6.0

## 6.2.6 Seal strength

### 6.2.6.1 Test method

In accordance with QB/T 2358.

### 6.2.6.2 Rules for approved test

Not less than 40N/15mm.

## 6.2.7 Heat resistance

### 6.2.7.1 Test method

The sample bag is filled with 10% of its own capacity into a saturated brine of 40°C, vacuum sealed, heated to 121°C ± 2°C in a sterilizer, kept at a constant temperature for 40 min, and then kept at constant pressure for cooling.

### 6.2.7.2 Rules for approved test

The sample bag has no obvious deformation, damage, delamination, and there is no peeling at the sealing part.

## 6.2.8 Sealing performance

### 6.2.8.1 Test method

In accordance with Method One in GB/T 15171-1994. The vacuum is 30kPa.

### 6.2.8.2 Rules for approved test

No leakage in the sample bag.

## 6.2.9 Rules for approved physical performance inspection

When the inspection items are all qualified, this batch shall be determined as qualified. If one of the inspection items fails, this batch shall be determined as unqualified.

## 6.3 Hygiene requirements inspection

### 6.3.1 Test method

In accordance with GB/T 5009.119 and GB/T 5009.60.

### 6.3.2 Rules for approved hygiene requirements inspection

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