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Oriental leaf tobacco — Baling

Tabac d'Orient en feuilles — Mise en balles

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Foreword

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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.

International Standard ISO 10919 was prepared by Technical Committee ISO/TC 126, *Tobacco and tobacco products*, Subcommittee SC 2, *Leaf tobacco*.

Annex A of this International Standard is for information only.

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Oriental leaf tobacco — Baling

1 Scope

This International Standard specifies the baling styles and specifications for manipulated oriental leaf tobacco.

NOTE 1 For the purposes of this International Standard, the word "tobacco" refers specifically to oriental leaf tobacco.

2 Definitions

For the purposes of this International Standard, the following definitions apply.

2.1 baling: Pressing and packaging of tobaccos of the same origin and grade by means of a suitable technique.

2.2 bale: A form of packaging which is most suitable for tobaccos during storage, fermentation and transportation. The usual form of bales used in the oriental producing areas is the tonga. The tonga bales are designated as big (2.2.1) or small (2.2.2) tonga bales according to the amount of tobacco contained.

2.2.1 big tonga bale: A tonga bale with a mass of between 31 kg and 55 kg.

2.2.2 small tonga bale: A tonga bale with a mass of between 20 kg and 30 kg.

2.3 wrapper: Material used to enclose the bale. The customary fabric used is burlap, hessian or any similar material which permits air and moisture transmission.

2.3.1 bottom wrapper: Wrapper which is used for the baling of tobacco to cover the lower, upper and back sides of the bale (see figure 1).

2.3.2 side wrapper: Wrapper which is used to cover the front, right and left sides of the bale which are not covered by the bottom wrapper (see figure 1).

2.4 tonga rope: A kind of rope made of hemp or any similar non-contaminating material. Tonga rope is used to tie firmly the lower and upper sides of the bottom wrapper to each other.

2.5 bale sewing thread: A kind of thread made of hemp or any similar non-contaminating material. The thread is used to sew the bottom and side wrappers to each other.

2.6 tonga baling box: A box used as a casing for the tonga bale. The box is rectangular in shape and may be made of wood, steel or any other non-contaminating material.

3 Specifications

3.1 General

The dimensions and mass values specified for bales and their components in this International Standard are nominal values. All dimensions and mass values shall be within 5 % of the values specified in tables.

3.2 Tonga baling box

The inner dimensions of tonga baling boxes shall be as given in table 1.

Table 1

Dimensions in metres

Type of baling box	Width	Length	Height
For big bales	0,38	0,7	0,65 (min.)
For small bales	0,36	0,6	0,55 (min.)

3.3 Tonga bales

Tobacco is packed in big or small tonga bales. Specifications for the bales shall be as given in table 2. (For

alternative tonga bale dimensions currently used in trade worldwide, see annex A.)

Table 2

Parameter	Big tonga bale	Small tonga bale
Width (m)	0,38	0,36
Length (m)	0,7	0,6
Height (m)	0,55 (min.)	0,5 (min.)
Volume (dm ³)	146 (min.)	108 (min.)
Mass (kg)	31 to 55	20 to 30

3.4 Wrappers

The dimensions of the bottom and side wrappers shall be as given in table 3.

Table 3

Dimensions in metres

Type of bale	Bottom wrapper		Side wrapper	
	Width	Length	Width	Length
Big tonga bale	0,38	2,1	0,55 (min.)	1,9
Small tonga bale	0,36	1,9	0,5 (min.)	1,6

3.5 Bale sewing thread

The thread shall have a minimum of two strands and have the specifications given in table 4.

Table 4

Type of bale	Bale sewing thread		Tonga rope	
	Length m	Tensile strength N	Length m	Tensile strength N
Big tonga bale	6	142,2	15	392,3
Small tonga bale	5	142,2	11	392,3

3.6 Tonga rope

The rope shall have a minimum of two strands and have the specifications given in table 4.

4 Procedure

4.1 Baling

Place the tobacco in the tonga box either mechanically or manually, in such a way as to ensure a uniform density throughout the bale.

Stretch the bottom wrapper across the bottom, back and top of the bale. Place tobacco leaves on the wrapper, then sew the wrapper tightly with tonga rope, stitching 5 cm to 6 cm apart on the front and 8 cm to 10 cm apart on the sides of the bale. Cover the remaining parts of the bale with the side wrapper, and sew the bottom and side wrappers together with bale sewing thread, placing stitches 2,5 cm apart (see figure 1).

4.2 Marking

Mark tonga bales legibly on the bottom wrapper by printing or using indelible ink, using patterns or characters or codes, with the following:

- a) crop year;
- b) origin;
- c) grade;
- d) net mass of bale, in kilograms;
- e) bale serial number.

On the upper surface, the address of the purchaser and the emblem or abbreviated name of the vendor may be printed according to agreement between the purchaser and vendor.

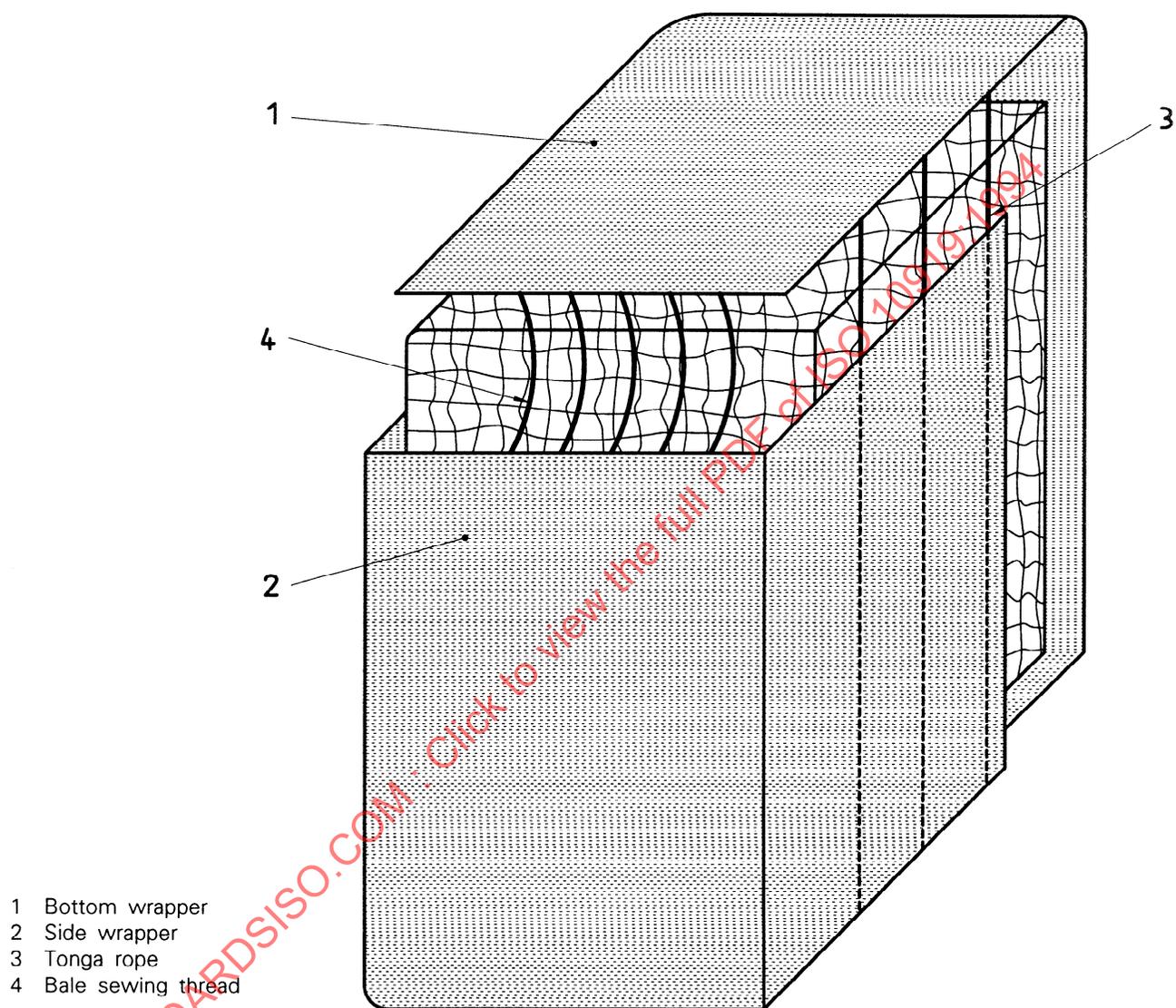


Figure 1 — Tonga bale

Annex A

(informative)

Acceptable tonga bale dimensions and masses used worldwide

In addition to the tonga bale dimensions and masses given in 3.3, acceptable alternatives which are currently used in trade worldwide are given in table A.1.

Table A.1

Parameter	Alternative I	Alternative II	Alternative III
Width (m)	0,3	0,26	0,3
Length (m)	0,6	0,75	0,5
Height (m)	0,4	0,5	0,7
Volume (dm ³)	72	97,5	105
Mass (kg)	18 to 21	30 to 50	30

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