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**Boiled reproduction cork — Grading,  
classification and packing**

*Liège de reproduction bouilli — Calibrage, classification et emballage*

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document was prepared by Technical Committee ISO/TC 87, *Cork*.

This fourth edition cancels and replaces the third edition (ISO 1216:1998), which has been technically revised. The main changes compared to the previous edition are as follows: the title and the scope have been changed.

# Boiled reproduction cork — Grading, classification and packing

## 1 Scope

This document defines when boiled reproduction cork is considered to be commercially dry. In addition, it classifies the different possibilities of grading boiled reproduction cork in terms of thickness, specifies its visual classification, packing and marking and defines the acceptable loss in transit.

## 2 Normative references

The following documents are referred to in such a way that some or all of their content constitutes requirements 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.

ISO 633, *Cork — Vocabulary*

## 3 Terms and definitions

For the purposes of this document, the terms and definitions given in ISO 633 and the following apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

### 3.1

#### **commercially dry corkwood**

corkwood in which the *moisture content* (3.2) is not higher than 14 %

Note 1 to entry: Virgin cork, raw reproduction cork, ramassage, gleanings, burnt cork, corkwaste, boiled cork pieces, and boiled corkwaste are types of corkwood.

Note 2 to entry: Moisture content of commercially dry corkwood is determined in accordance with ISO 2386.

### 3.2

#### **moisture content**

loss of mass of a test specimen after drying under specific conditions, compared to the initial mass of the test specimen

[SOURCE: ISO 2386:2015, 3.1]

## 4 Grading

**4.1** Boiled reproduction cork, free from corkwood refuse and cork pieces, may be graded in terms of thickness.

**4.2** The thickness of boiled reproduction cork without back expressed in millimetres or in "lines"<sup>1)</sup> is determined as the average of four measurements carried out at the ends of the two segments of straight lines which, passing at the centre of the cork, are in the tangential and axial directions.

In the boiled reproduction cork being graded, the irregularly thick zones shall not surpass 10 % of its total area.

**4.3** Unless otherwise agreed, boiled reproduction cork, free from raw corkwaste and cork pieces, can be graded in terms of its thickness in the following manner:

a) **Grade 14 <math>d \leq 22</math> — Extra thin**, with a thickness of between 14 mm and 22 mm.

Within this grade, the following sub-grades may be separated:

—  $14 < d \leq 18$ : from 14 mm to 18 mm;

—  $18 < d \leq 22$ : from 18 mm to 22 mm.

b) **Grade 22 <math>d \leq 27</math> — Thin**, with a thickness of between 22 mm and 27 mm.

c) **Grade 27 <math>d \leq 32</math> — Pint**, with a thickness of between 27 mm and 32 mm.

d) **Grade 32 <math>d \leq 40</math> — Quart**, with a thickness of between 32 mm and 40 mm.

e) **Grade 40 <math>d \leq 54</math> — Thick**, with a thickness of between 40 mm and 54 mm.

Within this grade, the following sub-grades may be separated:

—  $40 < d \leq 45$ : from 40 mm to 45 mm;

—  $45 < d \leq 54$ : from 45 mm to 54 mm.

f) **Grade  $d > 54$  — Extra thick**, with a thickness greater than 54 mm.

NOTE The grouping  $27 < d \leq 40$ , thickness between 27 mm and 40 mm, corresponding to the combined grades pint and quart, is also permitted.

## 5 Classification

After grading, the boiled reproduction cork may also be classified in seven visual qualities.

## 6 Packing

**6.1** Boiled reproduction cork, free from corkwood refuse and cork pieces, shall be packed in bales having the shape of rectangular parallelepipeds. The cork shall be pressed into compressed layers and held by means of a non-metallic strap or any other method which may be mutually agreed upon between the parties involved.

**6.2** The tare of the packing should not exceed a mass fraction of 3 % of the gross mass of the bale, in which the moisture content is 14 %.

**6.3** Unless otherwise agreed upon, boiled reproduction cork, graded in terms of thickness, shall be packed by grades (each bale having no more than one grade) and, if classified, also by qualities.

**6.4** Unless otherwise agreed, the dimensions of the bales shall be as follows:

— length: 1 150 mm  $\pm$  50 mm;

1) In the cork industry, the grade is currently expressed in "lines". The conversion factor is: 1 line  $\cong$  2,256 mm.

- width: 550 mm  $\pm$  50 mm;
- height: expressed by the number of layers, according to the thickness of cork, as shown in [Table 1](#).

**Table 1 — Thickness grade**

Thickness grade mm	Number of layers
14 to 22	26
14 to 18	29
18 to 22	24
22 to 27	21
27 to 40	17
27 to 32	19
32 to 40	16
40 to 54	13
40 to 45	13
45 to 54	13
over 54	11

## 7 Marking

The bales, in addition to other required marks, shall be marked with:

- a) their thickness grade, if the boiled reproduction cork has been graded in terms of thickness;
- b) their thickness grade and their visual quality (or qualities), if the boiled reproduction cork has been graded in terms of thickness and has also been classified;
- c) manufacturer's and/or exporter's name or trade mark;
- d) name of the exporting country.

## 8 Loss in transit

The loss in transit (breakage), acceptable under normal transport conditions, shall not exceed a mass fraction of 3 % of the gross mass of the bales, referred to 14 % of the moisture content.

## Bibliography

- [1] ISO 2386:2015, *Packed cork — Virgin cork, raw reproduction cork, ramassage, gleanings, burnt cork, boiled reproduction cork and raw corkwaste — Determination of moisture content*

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