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STANDARD

**ISO**  
**8351-2**

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**Packaging — Method of specification for  
sacks —**

**Part 2:**

Sacks made from thermoplastic flexible film

*Emballages — Méthode de spécification des sacs —  
Partie 2: Sacs faits d'un film thermoplastique flexible*



Reference number  
ISO 8351-2:1994(E)

## 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.

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 8351-2 was prepared by Technical Committee ISO/TC 122, *Packaging*, Subcommittee SC 2, *Sacks*.

ISO 8351 consists of the following parts, under the general title *Packaging* — *Method of specification for sacks*:

- *Part 1: Paper sacks*
- *Part 2: Sacks made from thermoplastic flexible film*

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# Packaging — Method of specification for sacks —

## Part 2:

## Sacks made from thermoplastic flexible film

### 1 Scope

This part of ISO 8351 provides a checklist for the characteristics to be specified when ordering sacks made from thermoplastic flexible film. These ordering specifications cover the description of the sack and do not deal with quantitative performance requirements. This part of ISO 8351 is primarily intended for application to the types of sacks made from thermoplastic flexible film as specified in ISO 6590-2.

### 2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 8351. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 8351 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 6590-2:1986, *Packaging — Sacks — Vocabulary and types — Part 2: Sacks made from thermoplastic flexible film*.

ISO 6591-2:1985, *Packaging — Sacks — Description and method of measurement — Part 2: Empty sacks made from thermoplastic flexible film*.

### 3 Method of specification

#### 3.1 General

When drawing up the specification of a sack made from thermoplastic flexible film for ordering purposes, customer and manufacturer shall consider each item in the following lists and, where relevant, mutually agree to include them in the ordering specifications at an appropriate level.

The format of the ordering specification shall be agreed upon between the customer and the manufacturer.

#### 3.2 Description

##### 3.2.1 Sack type

###### 3.2.1.1 Open-mouth

- heat-sealed flat;
- heat-sealed gusseted;
- pasted flat hexagonal-bottom;
- pasted gusseted rectangular-bottom;
- heat-sealed with corner seals;
- other not specified above.

###### 3.2.1.2 Valved (closed-mouth)

- valved heat-sealed flat;
- side-valved heat-sealed flat;

- valved heat-sealed gusseted;
- side-valved heat-sealed gusseted;
- valved pasted flat hexagonal-ends;
- other not specified above.

### 3.2.2 Tube type

- without longitudinal seam: flat or gusseted;
- with one or more longitudinal seams: flat or gusseted;
- side-welded.

### 3.2.3 Dimensions

The following dimensions, in millimetres, shall be specified in accordance with ISO 6591-2.

- length of sack, *a*
- width of sack, *b*
- width of gusset, *e*
- width of bottom, *c*
- width of valve, *g*
- length of valve, *f*
- width of valve sleeve, *v*
- length of valve sleeve, *i*
- valve sleeve position, *l*: distance between outermost edge of sack and outermost edge of valve sleeve, measured parallel to the bottom.

### 3.2.4 Type of material

Each ply shall be specified by its type, thickness (in micrometres) of grammage (in grams per square metre), special treatment (e.g. antislip, antistatic). If there is any surface treatment, the direction of treatment should be stated (e.g. face in, face out, both sides).

The materials shall be characterized as follows:

- loose or integral;
- paper type [e.g. normal (flat) sack paper, extensible sack paper] and grammage;
- film type, e.g. PE-LD, PE-LLD, PE-HD, PVDC or E/VAC;

- film state (flat or tubular);
- film thickness, in micrometres;
- film melt flow index, in grams per 10 min;
- length, in millimetres, where different from other plies (usually when loose or integral tubular);
- gusset, in millimetres, where different from other plies (usually when loose or integral tubular);
- width, in millimetres, where different from other plies (usually when loose or integral tubular);
- heat seal distance, in millimetres, from adjacent sack or thermoplastic ply transverse edge;
- skirt length, in millimetres, loose type only;
- Z-fold;
- cuffed or uncuffed;
- material combinations, e.g. extrusion-coated aluminium or textiles, with their respective characteristics.

### 3.2.5 Perforations

- beneath valve: number, size and pattern;
- ply: number, spacing, size and location of holes.

### 3.2.6 Valve/sleeve

- valve type: internal sleeve, external sleeve, reinforced sleeve, etc.;
- valve position: i.e. in which corner of sack;
- sleeve materials.

### 3.2.7 Longitudinal seam

- continuous or interrupted;
- overlap width, in millimetres.

### 3.2.8 Bottom cap

- position: valved end, non-valved end;
- material: type and thickness or grammage;
- dimensions, in millimetres: length, width.

**3.2.9 Bottom orientation**

- folded towards sack face side;
- folded towards sack back side.

**3.2.10 Heat-sealed closures**

- distance,  $n$ , of heat seal from sack edge;
- heat seal position: top or bottom of sack in relation to print.

**3.2.11 Filling aperture** (open-mouth sacks only)

- transverse pasting (yes/no) on all plies (yes/no, innermost without transverse pasting);
- thumb cut, yes/no.

**3.2.12 Printing**

- complete description of requirements and position of major elements of print, e.g. face side, back side, gussets, valve end, non-valve end and direction to valve end;
- ink colours and requirements, e.g. abrasion-resistant, UV-resistant.

**3.2.13 Packaging**

- sacks in bundles: tied/untied/folded;
- bundles in bales: total number of sacks per bale;

- bundles in palletized units: total number of sacks per unit;
- bundle stacking pattern;
- shingled reels: diameter and overlap in millimetres, number of sacks;
- pallet size and type, four-way entry/two-way entry;
- maximum unit height, in millimetres;
- special requirements for automatic packers;
- pallet wrapping: plastic, paper, shrink wrap, stretch wrap, wooden frame or fibre board on top of pallet;
- pallet strapping: steel, plastic;
- protection from strapping;
- labelling of pallet load.

**3.2.14 Accompanying documentation**

- customer's specification number;
- manufacturer's specification number;
- delivery address;
- invoice address;
- other acknowledgement.

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