
Methods for

Determination of saleable mass, in lots, of pulp

Part 1. Pulp baled in sheet form

[ISO title : Pulps — Determination of saleable mass in lots —
Part 1 : Pulp baled in sheet form]

Méthodes pour la détermination de la masse marchande des lots de pâtes
Partie 1. Balles de pâte en feuilles

Methoden zur Bestimmung von verkaufsfähiger Masse, postenweise, von Papierbrei
Teil 1. Ballen von Papierbrei in Bogenform

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National foreword

This British Standard has been prepared under the direction of the Paper Standards Committee. It is identical with ISO 801/1 'Pulps— Determination of saleable mass in lots— Part 1 : Pulp baled in sheet form', which was developed by Technical Committee ISO/TC 6, Paper, board and pulps, and was published in 1979 by the International Organization for Standardization (ISO).

BS 4747, entitled 'Method for the determination of the saleable mass, in lots, of pulp baled in sheet form' was first published in 1971. It was concerned with determination of saleable mass of pulp baled in sheet form, whereas BS 4747 is now published in Parts which are concerned with determination of saleable mass of pulp baled in slab form in addition to pulp baled in sheet form. The other Part of this British Standard, already published, is Part 2 'Pulps (such as flash-dried) baled in slabs'.

This Part 1 contains changes from the version of BS 4747 published in 1971, including a change in the oven drying temperature from $103 \pm 2 \text{ }^{\circ}\text{C}$ to $105 \pm 2 \text{ }^{\circ}\text{C}$.

Part 1 of this standard supersedes the edition of the standard published in 1971, which is therefore withdrawn from publication.

Terminology and conventions. The text of the international standard has been approved as suitable for publication, without deviation, as a British Standard. Some terminology and certain conventions are not identical with those used in British Standards; attention is especially drawn to the following.

The comma has been used throughout as a decimal marker. In British Standards it is current practice to use a full point on the baseline as the decimal marker.

Wherever the words 'International Standard' appear, referring to this standard, they should be read as 'British Standard'.

Cross-reference

International standard	Corresponding British Standard
ISO 801/2-1979	BS 4747 Methods for determination of saleable mass, in lots, of pulp Part 2 : 1980 Pulps (such as flash-dried) baled in slabs (Identical)

British Standard Methods for

Determination of saleable mass, in lots, of pulp

Part 1. Pulp baled in sheet form

0 Introduction

This International Standard is complementary to ISO 801/2, which concerns the determination of saleable mass of pulp baled in slab form. For the time being, the working group ISO/TC 6/SC 5/WG 1 is considering possibilities to recommend a method which could be applicable to determining of saleable mass of pulp in unitized bales.

1 Scope and field of application

This International Standard specifies a method for determining the dryness of a lot of pulp baled in sheet form and for calculating its saleable mass.

This method is applicable to all kinds of pulp baled in sheet form. It does not apply to pulp baled in lots in slab form or to pulp baled in unitized lots.

An example of a full certificate of analysis and related calculations is given in annex A. Annex B gives details of equipment for marking the position of specimen sheets in sample bales.

2 Definitions

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

2.1 lot : The total number of bales of the same sort of pulp of specific characteristics.

The number of bales comprising a lot is indicated by the invoice or by agreement between the interested parties.

A lot of bales of pulp is said to be "with specification" if it is accompanied by a certificate of origin stating for each bale either

- its gross mass (2.2) and its absolute dryness (2.4),

or

- its saleable mass (2.7).

2.2 gross mass : The total mass of a bale, a part of a lot or a lot comprising

- contents,
- wrappers (pulp — paper),
- packaging wires or strappings.

2.3 oven-dry mass : The mass obtained on drying pulp at 105 ± 2 °C, until constant mass is reached.

2.4 absolute dryness : The ratio of the oven-dry mass (2.3) of the pulp to its initial mass, expressed as a percentage.

2.5 air-dry mass : The mass of the pulp when its moisture content is in equilibrium with the ambient atmosphere.

2.6 theoretical commercial dryness : A conventional equilibrium value of 88 % or 90 % according to the country and/or commercial agreements.¹⁾

2.7 saleable mass : The gross mass (2.2) multiplied by the absolute dryness (2.4) divided by the theoretical commercial dryness (2.6). Usually, it approximates to the air-dry mass (2.5).

2.8 invoiced mass : The saleable mass (2.7) indicated by the vendor on the invoice.

3 Principle

From the lot, sample bales are taken in number which is a function of the total number of bales in the complete lot and in accordance with a sliding scale. These sample bales are weighed²⁾ and collected in groups of six bales.

Five specimen sheets are selected from each sample bale under defined conditions.

From each specimen sheet, a test piece is cut in the form of a triangle, as indicated in clause 6.

1) If the air dryness is 90 %, the pulp contains 90 parts by mass of absolutely dry fibres and 10 parts by mass of water. For an air dryness of 88 %, the corresponding figures are 88 and 12.

2) The mean of the gross mass of the sample bales is considered as being the mean of the gross mass of all the bales in the lot.

The test pieces are weighed and dried to constant mass to determine their oven-dry mass (2.3).

The saleable mass (2.7) of the lot is then calculated.

4 Apparatus

4.1 Scale, suitable for weighing the bales to an accuracy of at least 1/1 000.

4.2 Balance, of sensitivity suitable for weighing the test pieces to an accuracy of at least 1/5 000.

4.3 Equipment, for marking the position of the specimen sheets to be selected (see annex B) and the test pieces in these sheets, as well as for cutting them.

4.4 Equipment, for storing at least thirty test pieces to prevent them from gaining or losing mass before weighing.

4.5 Drying oven, with good ventilation, and capable of being controlled at 105 ± 2 °C.

5 Sample bales

All the sample bales shall be representative of the lot and for this purpose, so far as possible, these bales should be selected at random from all parts of the lot. In the absence of any other agreement between the interested parties, the available part of the lot to be examined shall be not less than half the complete lot at the time of examination.

If the bales have identification numbers relating to several series, the sample bales shall be selected as far as possible in proportion to the size of each of these series.

The sample bales shall be intact and as little damaged as possible, and shall not include

- bales showing signs of definite drying or wetting, as may happen with bales situated on the external faces of a stack;
- bales or wrappings of bales having deteriorated, or showing clear signs of accidental localized wetting or loss;
- bales carrying traces of previous sampling;
- bales whose number is illegible or is not contained in the specification, if this is a lot specified bale by bale.

The number of sample bales to be taken is given in table 1.

Above 5 000, the minimum number to be taken is 100 plus 1 % of the bales in excess of 5 000, the maximum number being 200 plus 1 % of the bales in excess of 5 000. In all cases, the total number of sample bales shall be a multiple of 6.

When the lot is relatively uniform, and the number of bales rejected (exclusive of bales from the outer faces of the stack) does not exceed 10 % of the minimum number of bales to be selected (see table 1), then the minimum number shall be taken. Otherwise, the analyst shall decide, within the limits set in table 1, the number of bales to be selected.

For frozen pulp, the sampling shall be postponed until the bales have thawed, so that satisfactory test pieces can be cut from the sheets.

Table 1 — Number of sample bales to be taken

Total number of bales in lot	Number of sample bales	
	min.	max.
Up to 100	12	24
101 to 200	18	36
201 to 300	24	48
301 to 400	24	48
401 to 500	24	48
501 to 600	30	60
601 to 700	30	60
701 to 800	36	72
801 to 900	36	72
901 to 1 000	42	84
1 001 to 2 000	48	96
2 001 to 3 000	60	120
3 001 to 4 000	72	144
4 001 to 5 000	96	192

6 Procedure

6.1 Weighing of sample bales

Determine the gross mass of each sample bale separately and report the results to an accuracy between 1/500 and 1/1 000; report, if possible, their marks and references in the order of their weighing. Check the scale (4.1) before the weighings and during the course of the operation.

If the moisture content of the sheets of pulp serving as wrappers obviously differs from that of the rest of the bale, or if the wrappers are invoiced separately, test them separately in accordance with 7.2.

6.2 Selection of specimen sheets

Select five specimen sheets from each sample bale, as specified below, as soon as possible after weighing.

Draw five sheets from each sample bale, the distance between the sheets being constant and equal to one-fifth of the total thickness of the bale (see the note). Do not take the sheets from the same positions in each bale, but select them according to the procedure specified below and illustrated in figure 1. In sample bale No. 1, the first sheet to be taken is that at the extreme top, and the last sheet (the fifth) will be one-fifth of the thickness of the bale from the bottom. In sample bales Nos. II, III, IV, V and VI, each sheet is taken from a slightly lower position (actually 1/50 of the thickness of the bale) than the corresponding sheet of the preceding bale; thus, in sample bale No. VI, the first sheet will be taken 1/10 of the height of

the bale from the top, and the last sheet will be 1/10 of the height of the bale from the bottom. The sample bale No. VII will recommence the cycle and be treated in the same way as the sample bale No. I, etc. In this way, one outside sheet is taken from every six sample bales, the proportion thus being one outside sheet in every thirty specimen sheets taken.

NOTE — Pulp bales composed of sheets folded or in juxtaposition. Pulp sheets are sometimes delivered folded two or more times into laps to conform to the size of the bale. In such cases, the word "sheet" should be interpreted as applying to only one thickness of the lap. If several sheets are folded into one lap, the test piece should be drawn from the sample sheet defined above. It is advisable to cut the pulp sheet(s) along the fold of the lap to determine the exact position from which the specimen sheet should be drawn.

Where the bales are composed of two adjacent sheet piles, the two sheets in juxtaposition on the same level¹ should be considered as constituting one specimen sheet.

[illegible]

Figure 1 — Diagram indicating the position from which specimen sheets shall be taken

Select all specimen sheets very carefully, especially those within about 5 cm from the top and the bottom of the bale.

The specimen sheets can be selected easily with the aid of an appropriately graduated measuring rod (see annex B). Place the rod in an inclined position against the side of the bale, so that its lower end is at the level of the bottom face on the bale, and the upper line at the level of its top. The faces on the rod correspond to the six bales in a bale group and the lines correspond to the five specimen sheets in the table.

If the top and bottom of the bales can be established by means of numbers or other identifying marks, start the selection of specimen sheets from the top of the first group of six sample bales and from the bottom of the second group of six sample bales. Follow this alternating procedure for successive groups of six bales.

6.3 Cutting the test pieces

6.3.1 General

From each of the specimen sheets selected, take a triangular test piece by making two *straight* cuts through the sheet from the edge to the mid-point. These triangles (see the note) have their bases at the outside edges and apices at the mid-point of the sheets. All test pieces used in the test have either the same area, or a constant apex angle of 24°.

It is very important that each specimen sheet shall remain in contact with the sheet underneath when the test piece is cut and that the cutting of the test piece is carried out on the same bale at the moment when the specimen sheet is exposed.

NOTE — As a result of a very full study, it has been decided to adopt two alternative ways of cutting the triangular test pieces.

In alternative 1, the test pieces are cut in such a way that they are equal in area.

In alternative 2, the test pieces are cut so that the angle at the peak is constant; hence, the areas of the test pieces vary according to the position from which they are taken in the specimen sheets.

Alternative 1 is theoretically correct for representative sampling but believed by some to be difficult to operate in practice. Alternative 2 is considered by some to be easier to follow. Data collected show that, in practice, the difference between the results obtained by the two ways of cutting the test pieces is likely to be negligible, and for this reason it has been agreed to recognize both alternatives.

6.3.2 Alternative 1: Constant area

From the first bale of a group of six sample bales, proceed as follows :

Cut test pieces in the shape of triangles in which the apices are at the mid-point of the sheets and where the lengths of the bases of the triangles are

$$\frac{l_1}{7.5} \text{ and } \frac{l_2}{7.5}$$

where

l_1 is the length of the long side of the sheet:

l_2 is the length of the short side of the sheet.

The test piece cut from the first specimen sheet has one side which coincides with a sheet diagonal (starting point shown in figure 2).

If the specimen sheets vary in grammage, and, hence also in thickness, compensate this by cutting narrower test pieces from the thicker sheets and wider ones from the thinner sheets.

Cut the test pieces from the consecutive specimen sheets as indicated in figure 2. These five triangular pieces together form the sample from bale No. 1.

In sample bale No. II, cut the test pieces from consecutive positions clockwise of the respective test piece positions in sample bale No. I, and progressively for sample bales Nos. III, IV, V and VI.