

INTERNATIONAL STANDARD

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Paper and board — Sampling to determine average quality

Papier et carton — Échantillonnage pour déterminer la qualité moyenne



Reference number
ISO 186:1994(E)

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 186 was prepared by Technical Committee ISO/TC 6, *Paper, board and pulps*, Subcommittee SC 2, *Test methods and quality specifications for paper and board*.

This third edition cancels and replaces the second edition (ISO 186:1985), of which it constitutes a technical revision.

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Paper and board — Sampling to determine average quality

1 Scope

This International Standard specifies a method of obtaining a representative sample from a lot of paper or board for testing to determine whether or not its average quality complies with set specifications including solid and corrugated fibreboard (see ISO 4046).

For some tests, special methods of sampling may be necessary; these will be given in the International Standard for the appropriate method of test.

NOTE 1 If less than 50 % of the lot is available for sampling, then sampling will be invalid in the absence of agreement to the contrary.

This method is unsuitable for determining the variability within a lot.

NOTES

2 Information on sampling for other purposes is given in ISO 2859-1:1989, *Sampling procedures for inspection by attributes — Part 1: Sampling plans indexed by acceptable quality level (AQL) for lot-by-lot inspection*, ISO 2859-2:1985, *Sampling procedures for inspection by attributes — Part 2: Sampling plans indexed by limiting quality (LQ) for isolated lot inspection*, ISO 2859-3:1991, *Sampling procedures for inspection by attributes — Part 3: Skip-lot sampling procedures*, and ISO 3951:1989, *Sampling procedures and charts for inspection by variables for percent nonconforming*.

3 Information on the preparation of test pieces is given in the appropriate standard test methods.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions

of this International Standard. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 4046:1978, *Paper, board, pulp and related terms — Vocabulary*.

3 Definitions

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

3.1 lot: The aggregate of paper or board of a single kind of specified characteristics produced under conditions that are presumed uniform, and available for sampling at one time.

A lot comprises one or more nominally identical units. Where the material to be tested has already been incorporated into a manufactured article (for example a packing case), the lot is the aggregate of such articles of a single kind, of specified characteristics. (See figure 1.)

3.2 unit: A component of a lot which may be in the form of a reel, a bale, a bundle, a parcel, the contents of a packing case, a pallet load, etc. (See figure 1.)

3.3 sheet: The area of paper or board taken from the selected units. (See figure 1.)

3.4 specimen: An area of paper or board cut to given dimensions, from the sheets (or manufactured articles). (See figure 1.)

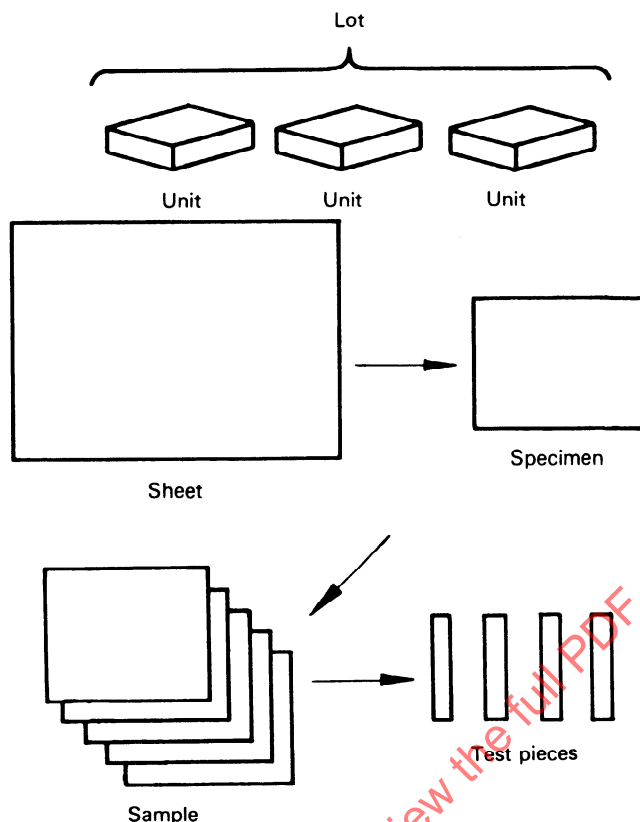


Figure 1

3.5 sample: The aggregate of all the specimens taken from the lot to provide information on the average quality of the lot and possibly serve as a basis for a decision on the lot. (See figure 1.)

3.6 test piece: The piece or pieces of paper or board on which the measurement is carried out in accordance with the stipulations of the method of test.

The test piece is generally taken from a specimen; in some instances the test piece may be the specimen itself, or several specimens. (See figure 1.)

3.7 selected at random: Taken in such a way that each part of the whole has an equal chance of being selected.

4 Principle

Selection of sheets at random from production units selected at random from a lot of paper or board. Further subdivision and combination of these sheets to provide the specimens of the sample from which the test area or test pieces will be taken.

5 Procedure

5.1 Selection of units

Select the units to be sampled according to table 1.

The units selected should be intact and in good external condition.

5.2 Selection of sheets

For each unit withdrawn from the lot, proceed as follows.

5.2.1 Units that can be unwrapped

If the unit is a package that can be and may be completely unwrapped.

5.2.1.1 When the unit is not subdivided (with or without a pallet)

Avoiding all damaged sheets and the three outermost undamaged sheets, take at random, in conformity with table 2, the same number of sheets from each

Table 1

Size of lot, n units ¹⁾	Number of units selected	Method of selection
1 to 5	All	—
6 to 399	$\sqrt{n + 20}$	At random
400 or more	20	At random
1) In deciding the number of units to be selected, any remainder of less than 20 units shall be ignored.		

unit selected (see 5.1) such that the number of sheets taken from the lot is sufficient to provide enough sample for the required testing.

If known, mark the machine direction on the sheets.

5.2.1.2 When the unit is composed of elements (reams or parcels, etc.) packaged together (with or without a pallet)

Assemble all the selected units (see 5.1) and select elements from the units in the same way that units were selected from the lot in 5.1.

Avoiding all damaged sheets and the three outermost undamaged sheets, take at random, in conformity with table 2, the same number of sheets from each element selected such that the number of sheets taken from the lot is sufficient to provide enough sample for the required testing.

If known, mark the machine direction on the sheets.

5.2.1.3 When the unit is a reel

Remove all damaged layers from the outside of each selected reel (see 5.1) plus three undamaged layers of paper (grammage less than 225 g/m²) or one undamaged layer of board (grammage equal to or greater than 225 g/m²), whichever is appropriate.

Cut the same number of sheets from each reel such that the number of sheets taken from the lot is sufficient to provide enough sample for the required testing and the number of sheets taken from the lot does not exceed 15. Vary the position of the sheets for each reel such that each 400 mm section across the reel is equally represented.

NOTES

4 The sheets may be taken directly from the reel or the reel may be cut across its full width, the pile of cut sheets allowed to fall to each side, the reel removed and the sheets cut from each pile.

Table 2

Number of sheets in the lot	Minimum number of sheets to be taken from the lot
Less than or equal 1 000	10
1 001 to 5 000	15
More than 5 000	20

5 The term reel is used throughout this method but the same procedure is equally applicable to a roll of paper or board.

5.2.2 Units that cannot or may not be unwrapped

If the unit is a package that cannot be or should not be completely unwrapped, for example reels, pallets or possibly reams, in store or selected by the customs.

Assemble the selected units (see 5.1).

5.2.2.1 Known machine direction

If the machine direction is known, cut a window from each unit of at least 300 mm × 450 mm with the long dimension in the machine direction. Vary the position of the window(s) within and between units. Remove all damaged layers and, in addition, as the case may be, at least the three outermost undamaged layers of paper (grammage less than 225 g/m²) or at least one undamaged layer of board (grammage equal to or greater than 225 g/m²).

Through each window cut to a sufficient depth to enable the requisite number of sheets, i.e. as derived from table 2, to be taken. Take at random from each window the same number of sheets so that the number of sheets taken from the lot is sufficient to provide enough sample for the required testing.

In the case of lots consisting of less than five units it is recommended that more than one window be cut in each unit. When only one reel is available, at least three and preferably five windows should be cut.

5.2.2.2 Unknown machine direction

If the machine direction is not known, cut windows of dimensions 450 mm × 450 mm with sides parallel to those of the unit. Then proceed as in 5.2.2.1.

5.2.3 Individual manufactured articles

If the lot consists of individual manufactured articles (see definition of lot in 3.1).

Take at random from the lot a sufficient number of articles in conformity with table 3 so as to provide enough sample for the required testing.

Table 3

Number of articles in the lot	Minimum number of articles to be taken from the lot
Less than or equal to 1 000	10
1 001 to 5 000	15
More than 5 000	20

5.3 Preparation of specimens

All specimens in a sample shall be the same size.

If the machine direction is not known, determine this if possible and, if necessary, for each sheet by a tensile test, for example.

Cut the specimens as indicated in 5.3.1 to 5.3.3.

For sheets taken in accordance with 5.2.1, see 5.3.4.

After cutting, mark the machine direction on each specimen or mark that the machine direction is unknown.

Where manufactured articles have been selected proceed as in 5.3.5.

5.3.1 If the sheets have been selected in accordance with 5.2.1 and have dimensions equal to or greater than 300 mm CD¹⁾ × 450 mm MD²⁾.

If the machine direction is known, cut one or more specimens from each sheet selected, but the same number from every sheet, each specimen to be at least 300 mm CD × 450 mm MD. If the sheets are already an appropriate size, they may constitute the specimens.

If the machine direction could not be determined, cut one or more specimens from each sheet selected, but the same number from every sheet, each specimen to be square and if possible about 450 mm × 450 mm.

1) CD = cross direction

2) MD = machine direction

3) If the specimens are in the form of very narrow strips, wind them on a core of diameter of at least 75 mm.

5.3.2 If the sheets have been selected in accordance with 5.2.1 and have one dimension or both below the 300 mm CD and 450 mm MD referred to in 5.3.1, but the surface area of the sheet is greater than 0,1 m².

From each sheet selected, cut one or more specimens, but the same number for every sheet, in such a manner that the surface area of each specimen is between 0,100 m² and 0,135 m².

5.3.3 If the surface area of each sheet selected in accordance with 5.2.1 is less than 0,1 m².

The selected sheets constitute the specimens provided they are all the same size.

The number of selected sheets should be sufficient to provide enough sample for the required testing.

5.3.4 If the sheets have been selected in accordance with 5.2.2.

These sheets constitute the specimens.

5.3.5 If the manufactured articles have been selected in accordance with 5.2.3.

From each selected article, cut one or more specimens, but the same number from each article, varying the position of selection in each article. If convenient a whole article may comprise a specimen.

6 Additional requirements

6.1 Specimens

6.1.1 Precautions

Specimens shall be kept flat, free from wrinkles and folds³⁾ and protected from exposure to conditions which may change the relevant properties. Care shall be taken in handling specimens, as contact with the hands can appreciably affect the chemical, physical, optical, surface or other characteristics of the paper.

6.1.2 Marking

Each specimen shall be provided with identification marks sufficient to ensure that it can be recognized beyond all doubt. These marks shall be indelible; they may be limited to the number of the sampling report and the signature of the sampler. They shall, where