

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION R 198

DOUBLE-DECK FLAT PALLETS FOR THROUGH TRANSIT OF GOODS

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BRIEF HISTORY

The ISO Recommendation R 198, *Double-Deck Flat Pallets for through Transit of Goods*, was drawn up by Technical Committee ISO/TC 51, *Pallets for Unit Load Method of Materials Handling*, the Secretariat of which is held by the British Standards Institution (B.S.I.).

Work on this question by the Technical Committee began in 1952 and led, in 1954, to the adoption of a first Draft ISO Recommendation, dealing with two pallet sizes. This first Draft ISO Recommendation (No. 42) was circulated, in May 1954, to all the ISO Member Bodies for enquiry.

However, during its third meeting, held in Stockholm in June 1955, the Technical Committee decided to complete the Draft so as to include a third pallet size, as well as the specifications concerning the construction details of the pallets in question. In November 1959, the Draft thus completed was circulated to all the ISO Member Bodies as a Second Draft ISO Recommendation (No. 42) and was approved, subject to some editorial amendments, by the following Member Bodies:

Austria	Ireland	Romania
Belgium	Italy	Spain
Chile	Netherlands	Sweden
Czechoslovakia	New Zealand	Switzerland
Denmark	Norway	United Kingdom
France	Poland	U.S.S.R.
Greece	Portugal	

One Member Body opposed the approval of the Draft: Germany.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in May 1961, to accept it as an ISO RECOMMENDATION.

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Throughout this ISO Recommendation, dimensions are given both in inches and in millimetres. The dimensions in millimetres and in inches are considered to be "corresponding values", although some of these are not exactly equivalent.

1. The nominal sizes of flat pallets for general purposes are as follows:

TABLE I.—Nominal sizes

Inches	Millimetres
32 × 48	800 × 1200
40 × 48	1000 × 1200
32 × 40	800 × 1000

2. The actual overall sizes of the decks of these pallets, which are equal to the nominal sizes given under clause 1, and their tolerances are indicated in Table II below:

TABLE II.—Actual overall sizes

Nominal dimensions of the pallets		Actual length <i>L</i>		Actual width <i>B</i>	
in	mm	in	mm	in	mm
32 × 48	800 × 1200	48 $\begin{smallmatrix} 0 \\ - 3/4 \end{smallmatrix}$	1200 $\begin{smallmatrix} + 20 \\ 0 \end{smallmatrix}$	32 $\begin{smallmatrix} 0 \\ - 1/2 \end{smallmatrix}$	800 $\begin{smallmatrix} + 15 \\ 0 \end{smallmatrix}$
40 × 48	1000 × 1200	48 $\begin{smallmatrix} 0 \\ - 3/4 \end{smallmatrix}$	1200 $\begin{smallmatrix} + 20 \\ 0 \end{smallmatrix}$	40 $\begin{smallmatrix} 0 \\ - 5/8 \end{smallmatrix}$	1000 $\begin{smallmatrix} + 16 \\ 0 \end{smallmatrix}$
32 × 40	800 × 1000	40 $\begin{smallmatrix} 0 \\ - 5/8 \end{smallmatrix}$	1000 $\begin{smallmatrix} + 16 \\ 0 \end{smallmatrix}$	32 $\begin{smallmatrix} 0 \\ - 1/2 \end{smallmatrix}$	800 $\begin{smallmatrix} + 15 \\ 0 \end{smallmatrix}$

These tolerances should be regarded as extreme limits within which the manufacturing tolerances of the national standards should be specified.

3. The pallets specified are all double-decked and are constructed so as to permit the entry of forks or fingers of fork lift trucks or pallet trucks, preferably from any side, but at least from two opposite sides.
4. The distance from the underside of the top deck to the ground is 5 in (127 mm) maximum, and the free height for the entry of forks or fingers, from any side, is $3\frac{7}{8}$ in (99 mm) minimum.
5. The bearing surface of the bottom deck should be equal to or greater than 40 per cent of the overall surface of the top deck.
6. The arrangement and the minimum entry dimensions which are provided to allow the entry of the forks of fork lift trucks and pallet trucks, and also the arrangement and minimum dimensions of the openings, should conform with Figure 1 and Table III. However, for the pallets of

32 in × 48 in 800 mm × 1200 mm
40 in × 48 in 1000 mm × 1200 mm

and if the construction will permit, it is recommended that the minimum openings should be those given in Figure 2 and Table IV.