

THE VOLLRATH COMPANY, L.L.C.
沃华夫有限公司
VOLLRATH SYSTEM WORK INSTRUCTION
沃华夫作业指导书

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SUBJECT 主题 OEM/ODM Packaging Requirements for Purchased Products 已购产品原始制造商/原始设计商包装要求	
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1.0 PURPOSE

目的

The purpose of this document is to provide general guidelines and information to qualify The Vollrath Company packaged products – shipped domestically and internationally. This document details the requirements for testing, graphics, material marking, labeling and palletization, plus to help determine the package's ability to provide the desired product protection and visual clarity during distribution and shipment to customers.

本文件旨在为沃华夫公司（国内运输和国际运输的）包装产品的认证提供一般指南和相关信息。本文件中详细叙述了测试，图形，材料标识，贴花以及托盘化的要求，并帮助确定包装能为预期产品提供保护的能力，在分销和运输到客户手中时的目测洁净度。

2.0 SCOPE

范围

This procedure applies to all packaging used by The Vollrath Company for shipping palletized product and non-palletized product thru all distribution environments. Exceptions to this procedure will be documented in the Purchase Order Process. All exceptions to this procedure must be approved by Vollrath Purchasing. 本程序对于沃华夫公司整个分销环境中用托盘装运产品和非托盘装运的包装都适用，本程序的例外情况将在订单流程中有记录，所有的例外情况必须通过沃华夫采购部的认可。

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Packaging Guide Check List

包装指南一览表

SECTION 章节		FOR CONSIDERATION 考虑事项	Check (X) 核对 (X)
2.0	General Requirements 一般要求		
.1		New shipping package design meets requirements 新的运输包装设计达到要求	
.2		Package design accommodates accessory items 包装设计足够放置配件	
.3		Bags used where appropriate 使用了适当的包装袋	
.4		Modifications approved via PPAP by Vollrath QA and/or Engineering 通过PPAP提交，变更获得了沃华夫公司质量/工程的批准	
3.0	Shipping Container Requirements 运输包装要求		
.1		Container size is suitable for shipment 包装大小适应运输的要求	
.2		A third party has a suitable package/carton design 第三方有适当的包装/纸箱设计	
.3		Outer corrugated fiberboard is Kraft (unless otherwise specified) (除非另有所述) 瓦楞纸箱外为牛皮纸	
.4		Vollrath graphics printed on all outer shipping cartons 所有运输纸箱外需打印沃华夫公司的图案	
.5		Recycled material will not adversely affect carton 循环使用的材料不得对纸箱产生负作用	
.6		Carton is sealed with suitable clear tape 用适当的透明胶带来封装纸箱	
.7		Pallet and shipping container and components ISPM 15 compliant 托盘，船用包装和零件国际贸易中木质包装材料管理准则 (ISPM15 准则)	

4.0	Cushion Requirements 填充物要求		
.1		Cushions are made of homogenous materials 包装填充物需由同质材料制成	
.2		Recycled materials will not adversely affect cushion performance 循环使用的材料不得影响填充物的性能	
.3		Design optimizes product protection and minimizes costs 优化产品保护性能的设计并降低成本	
.4		Void filling packaging materials (packing peanuts, bubble wrap, etc) are prohibited 禁止使用复合包装材料 (类花生填充物 , 泡沫包装等)	
5.0	Protective Package Testing 保护性包装测试		
.1		ASTM tests procedures located and determined by package type. ASTM测试程序中查找 , 并由包装类型来确定	
.2		Test levels determined and approved by Vollrath 沃华夫公司确定测试和验收的级别	
.3		Damage occurring in testing compared with actual damage during distribution. 测试中产生的损坏与实际分销过程中产生的损坏	
.4		Package provides acceptable levels of protection in accordance with acceptance and damage criteria. Test report prepared and submitted with PPAP. 包装按验收和损坏标准的要求提供了可接受的保护水平 , 编写测试报告并提交PPAP。	

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Packaging Guide Check List (Cont.)

包装指南校验表 (续)

SECTION 章节	FOR CONSIDERATION 考虑事项	Check (X) 核对 (X)
6.0	Graphic Requirements 图形要求	
.1	Acceptance Criteria for Graphics 图形验收标准	
7.0	Material Marking Requirements	

	材料标识要求		
.1		Plastic resin identification mark embossed on material in accordance with specification 塑料树脂识别码压印在与规格相符的材料上	
8.0	Labeling Requirements 标识要求		
.1		Product/Bar Code Label requirements 产品/条形码要求	
.2		Shipping Label placement and orientation 发货标签的放置与方向	
9.0	Palletized Shipment Requirement 托盘运输要求		
.1		Unitization, Wrapping, and Banding 单元化包装，卷包，和用包装带捆	
10.0	Pallet & Crating Material Treatment 托盘和板条箱材料处理		
.1		All Non-Manufactured Wood Packaging (NMWP) is bark free 所有未经加工的木制包装材料 (NMWP) 都不得有树皮	
.2		All Non-Manufactured Wood Packaging (NMWP) is heat treated for international shipment 所有未经加工的木制包装材料 (NMWP) 都必须经过热处理以便用于国际运输	
11.0	Pallet & Crating Material Marking 托盘和板条箱材料标记		
.1		Marking Procedure, symbols, and placement 注标程序，符号与位置	
.2		Material Classification Requirements for untreated NWWP components 未处理过的木制包装材料NMWP组件分类要求	

3.0 GENERAL REQUIREMENTS

一般要求

- 3.1 If a shipping package design does not exist at the time of Vollrath's project/product initiation, a shipping package design must be produced which addresses all the Vollrath design, manufacturing, service, reseller, marketing, environmental, sustainment and distribution objectives.

在沃华夫项目/产品启动的时候若尚无运输包装设计，则必须进行包装制作，并体现沃华夫设计、制造、售后服务、中间商、市场、环保、支持和分销等目标。

- 3.2 The shipping package design must accommodate all accessory items as identified on the Bill of Materials, i.e. manuals, hardware, power cables, trays, racks, and shelves.

运输包装的设计必须能够容纳所有材料单中确认的附件，如：手册、五金件、动力电缆、托盘、托架和货架等。

- 3.3 Bags shall be used where appropriate – to contain small parts, reduce dusting, abrasion, and lost/missing parts. Antistatic bags must be used where appropriate and be amine-free. All parts within each bag shall be identified by description and supplier part number.

适当的时候应使用袋装——以收纳小的零件，减少灰尘，摩擦和零件的缺失，适当的时候必须使用防静电的包装袋，且应当是不含胺的材质。袋子中所有的零件都必须在描述中经过鉴定，并具备供货商的产品编号。

- 3.4 Any modification or alteration of any of the packaging components during the life span of the product must be reviewed and approved by Vollrath Quality Assurance.

在产品的使用寿命内包装组成如有任何修订或改变都必须进行检查，并获得沃华夫质量保证部的批准。

4.0 SHIPPING CONTAINER REQUIREMENTS

运输包装要求

- 4.1** The final container size must take into consideration the optimization of shipment by all modes of transportation (surface, water and air) worldwide, including palletized shipments.

最终的运输包装尺寸必须考虑到在全球所有最优化的运输方式（地面、水运和空运），包括托盘运输。

- 4.2** If a third party has an existing package/carton design already in place for a particular product component, utilizing the package/carton design may increase efficiency.

对于某一个具体的产品，如果第三方已经有现存的包装/纸箱设计，使用该包装/纸箱设计可能会增加有效性。

- 4.3** All corrugated fiberboard shipping container to be Kraft (brown – unless otherwise specified) and shall conform to specification #1234-5678: General Specification Corrugated Containers and Components.

所有的瓦楞纸箱应当为牛皮纸（棕色——除非另有所述）制作而成，而且应当与标准#1234-5678 相符：瓦楞纸箱和组件的一般规格

- 4.4** Vollrath brand graphics must be printed on all outer shipping cartons – per specification #1234-5678 Graphics and Product/Bar Code Labels.

沃华夫的图案必须打印在所有运输纸箱的外面——与#1234-5678 规格中图案和产品/条形码标签相符。

- 4.5** Recycled material used in the shipping container is desirable as long as it will not adversely affect the container's performance.

包装箱内循环使用的材料若不会影响到包装箱的性能是可以使用的。

- 4.6** Clear plastic tape, of appropriate size and tensile strength, is required for sealing all corrugated shipping containers. Corrugated staples maybe used for container closure if preapproved and/or otherwise specified by Vollrath specifications.

要求所有用于封装瓦楞纸箱的透明塑料胶带，必须具备适当的尺寸与抗拉强度。若需使用订钉的方式来封装包装箱，则应当事先获得批准和/或在沃华夫规格中有述。

- 4.7** Any shipping containers, components and/or pallet material constructed from wood must be ISPM 15 compliant for all import/export shipments.

任何由木制材料所制造的包装箱，包装组成和/或托盘材料都必须具备 ISPM15 标志以用于进/出口运输。

5.0 CUSHION REQUIREMENT

填充物要求

5.1 Cushions, if required, must be of a homogenous material to promote ease of recycling.

如有填充物，则填充物必须是同质的材料，以易于回收。

5.2 Recycled material added to the virgin cushion material is desirable providing it will not adversely affect the cushion performance.

若循环使用的材料不会对填充料的性能产生影响，则可加到新的填充材料中。

5.3 Cushion design will optimize protection, and minimize material usage and cost. Cushions designed for systems that are distributed through resellers, must utilize resilient material (i.e. expanded polypropylene, extruded polyethylene).

填充物的设计应优化保护性能，降低材料的使用和成本。由中间商分销的产品，其包装填充物的设计必须使用弹性材料（如松散的聚丙烯，挤压成型的聚乙烯）。

5.4 Void filling cushioning materials (i.e. packing peanuts, bubble wrap, newspapers, paper wadding) are strictly prohibited unless pre- approved by The Vollrath Company.

除非沃华夫公司批准，否则不得使用复合材料填充物（如花生填充物，泡沫包装，报纸，纸填料）。

6.0 PROTECTIVE PACKAGE TESTING

保护性包装测试

6.1 Vollrath manufactures and sells a variety of products that vary in size, weight, and price. The package must provide acceptable levels of product protection from the distribution environment. All testing methods, procedures, and qualification can be found in document number 1234-5678 located at: <http://Vollrath.com/Pkg Test Requirements/index.htm>.

沃华夫公司生产并销售种类繁多的不同尺寸、重量和价格的产品，而在各分销环境中，包装必须能够提供可靠的产品保护水平。所有的测试方法、程序以及认证都可以在编号为 1234-5678 的文件中找到，文件位于：<http://Vollrath.com/Pkg Test Requirements/index.htm>.

6.2 The test levels specified in 1234-5678 are per Vollrath and industry. The tests to be conducted and the appropriate test levels will be determined by the responsible person contracting with OEM/ODM. Please refer to check list at Appendix A.

文件 1234-5678 中所述的级别符合沃华夫和行业要求，所要进行的测试以及适当的测试级别将由原始制造商/原始设计商的缔约负责人来确定。请参考附录 A 一览表。

6.3 The type and quantity of damage that occurs during package testing should be compared with the damage that actually occurs during distribution for similar products. This information will help to determine if alternative packaging tests and test levels are required.

在包装测试过程中出现的损坏类型和数量应当与在实际分销过程中类似产品所出现的损坏作比较，该信息将会帮助确认是否需要选择另外的包装测试和测试级别。

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6.4 Acceptance and Damage Criteria:

验收及损坏标准：

The package must provide acceptable levels of product protection from the distribution environment and also withstand storage stresses.

包装必须能够为产品在分销环境中提供可接受的产品保护，并能承受存放时产生的压力。

Examples of general acceptance criteria are as follows:

一般验收标准范例如下：

- Product is damage-free; no structural damage including no detached, loose, fractured or deformed materials beyond allowable manufacturing tolerances.
- 产品无损坏；无结构性损伤，包括无拆开、松动、断裂或超出制造公差范围的变形材料。
- Product cosmetic areas are not degraded beyond manufacturing or final acceptance criteria.
- 产品外观区域不得低于制造或终验收标准。
- Cosmetic damage is any abnormality that makes the product unacceptable to the customer.
- 导致客户不接收产品的任何外观损坏的异常情况。
- No conductive (electrostatic) particles should be generated as a result of the testing.
- 测试之后不得产生导电（静电）的粒子。

- The product should meet all product data sheet and manufacturing specifications and tolerances after testing. The product functions to specification.
- 产品在测试之后应当达到所有产品数据表、制造规格和公差的要求。产品功能与规格要求相符。

Unacceptable package degradation may be defined as, but is not limited to:

不可接受的包装变差定义如下，但不仅限于下述情况：

- Any change in package condition, including fractured or deformed materials that result in product damage or permanent displacement of the product and accessories from their intended position.
- 任何包装有变化的情况，包括导致产品损坏，或产品和附件从其预期的位置发生永久性位移的开裂或变形的材料。
- No foreign particles should be present from abrasion or other sources.
- 不得有因磨损或其它情况所产生的外来杂质。
- Some cushion deformation and cracking is acceptable. Complete cushion material fracture and/or cushion damage such that adequate product protection is absent is unacceptable.
- 一些填充物变形或开裂是可以接受的，而整个填充材料断裂和/或填充物损坏导致产品无充分的保护则是不可接受的。
- Multiple fractured cushion pieces may cause customer concerns, dissatisfaction and possibly product returns (even if the product still functions to specification).
- (即使产品的功能性满足规格要求)，多个裂开的填充物也有可能引起客户的关注，不满甚至退货。

Severe damage to packaging materials/mediums is not acceptable.

严重的包装材料/介质损坏是不可接受的。

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The Table below provides examples of acceptable and unacceptable containment type damage.

下表中提供了接受和不可接受的损坏类型的范例：

SHIPPING UNIT TYPE 运输件类型	DAMAGE LOCATION 受损位置	UNACCEPTABLE PACKAGE DAMAGE 不可接受的包装损坏	ACCEPTABLE PACKAGE DAMAGE 可接受的包装损坏
Type 1 (Boxed) 类型1 (盒装)	Container (External) 包装箱 (外)	<p>Edge ruptures to the extent that it can no longer contain the product or support the product's weight 边缘断裂到不能再包住产品或为产品重量提供支撑。</p> <p>Failure of closure; such that one or more flaps are free to open or cannot support the weight of the product. 封口失效：如一个或多个折边导致封口打开，且不能支撑产品的重量。</p>	<p>Dented corners and edges from impacts on those areas. 冲击导致角和边缘等位置凹陷。</p> <p>Localized rupture of edges near impacted corner. 靠近冲击角的边缘出现局部断裂。</p> <p>Localized failures in closure in area of impact (carton is still effectively closed). 冲击部位封口局部失效（纸箱仍然能有效地封闭）。</p>
	Cushioning (Internal) 填充物 (内)	<p>Failure of bonded joints or surfaces which results in internal packaging to lose original configuration. 捆扎的结头和表面失效，导致内包装失去初始配置。</p> <p>Fractured or deformed material which no longer maintains product position. 因为材料的断裂或变形导致不能再保持产品的位置。</p>	<p>Small fracture or permanent deformation that still permits internal packaging to maintain product position. 少量的断裂或永久变形，但内包装尚能保持产品的位置。</p>
Type 2 (Single Product Palletized) 类型2 (单品托盘装运)	External 外部	<p>Fractured wood members on pallet. 托盘上断裂的木质结构。</p> <p>Ruptured straps that were used to hold a corrugated cover down. 用来压住瓦楞外板的捆扎带断开。</p> <p>Fractured bolts or other hardware used in pallet construction. 用来制作托盘的螺栓或其它五金件断裂。</p>	<p>Dents in wooden pallet along impacted edges. 木托盘上冲击边缘上有凹痕。</p>

	Internal 内部	Same as Type 1. 与类型1一致。	Same as Type 1. 与类型1一致。
Type 3 (Multiple Product Palletized) 类型3 (多个产品托盘装运)	Pallet and Retainer (External) 托盘与保持架 (外部)	Unitization method (i.e. straps) allows individual cartons to leave the load. 统一产品装运法 (如：打包带) 可使单件产品从荷载中移开。	Carton or load shift, where carton edges are no longer aligned but load configuration is stable for transport 包装箱或荷载位移，包装箱边缘与荷载配置不再一条线上，但运输还是稳定的。
	Internal 内部	Same as Type 1. 与类型1一致。	Same as Type 1. 与类型1一致。

Table 1 – Acceptable & Unacceptable Containment Damage

表 1——接受和不可接受的损坏类型

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7.0 GRAPHIC REQUIREMENTS

图形要求

Vollrath packaging graphics are generally Low Visibility - for commercial products that may be displayed occasionally where there is little retail presence. The Vollrath representative you are working with will advise on the correct packaging graphics design or will provide more detailed information. Vollrath branded graphics requirements can be found at: <http://Vollrath.com/Graphics and Bar Code Labeling Requirements/index.htm>

沃华夫包装图形通常能见度较低——对于商用产品有时可能会有少量显示。与你一起工作的沃华夫代表将会向你提供正确包装图形设计的建议，或提供更为详细的信息。沃华夫品牌图形要求可以在下述链接中找到：<http://Vollrath.com/Graphics and Bar Code Labeling Requirements/index.htm>

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7.1 Acceptance Criteria for Graphics

图形验收标准

The tables below identify acceptable and unacceptable cosmetic defects as they relate to printing of Vollrath shipping containers

下表对沃华夫运输包装箱打印情况可接受和不可接受的外观缺陷进行了鉴别

TYPE OF FLAW 缺陷类型	ACCEPTABLE 可接受的	UNACCEPTABLE 不可接受的
Print Registration 打印队列	Misregistration of artwork to scores up to 6 mm (0.25 in) 打印未对准导致原图向上移6 mm (0.25 in)	Misregistration between colors more than 0.2 mm (0.008 in) or two rows of dots. 打印未对准，颜色之间差异超过0.2 mm (0.008 in) 或两排圆点
Hickies and Spots (Dirt, Ink, Dry Grease) 脏点 (灰尘、墨迹、干油腻)	Up to three defects ≤ 1 mm (.03 in) in size per panel if no graphic distortion. 每一面达到三处缺陷 ≤ 1 mm (.03 in)，但图案未变形。 One defect > 1 mm (.03 in) but < 3 per panel if no graphic distortion on minor flaps. 每一面一处缺陷 > 1 mm (.03 in)但 < 3 ，且在小折边处图案未变形。	Any defect in the Vollrath logo. 沃华夫商标有缺陷。
Wet Grease and Water Damage 湿油腻和水污	No. 不得出现	Any trace. 任何痕迹。
Scratches, Smears and Streaks 划伤、污迹和划痕	One defect ≤ 1 mm (.03 in) x the length of the panel or major flap per box if no graphic distortion. 每一个包装箱有一处缺陷 ≤ 1 mm (.03 in) x长边或主折边，但图案未变形。 One defect ≤ 1 mm x 10 mm (.03 x .38 in) per panel or major flap if no graphic distortion. 每一面或主折边有一处缺陷 ≤ 1 mm x 10 mm (.03 x .38 in) 但图案未变形。 Defect ≤ 1 mm (.03 in) x the length of the flap on minor flaps. 缺陷 ≤ 1 mm (.03 in) x较小折边的折边长度	Any defect in the Vollrath logo. 沃华夫商标有缺陷。
Glue Tracks 胶水痕迹	Clear glue tracks if no graphic distortion. 无污垢的痕迹且图案未变形。 One track with any color, Kraft, or foreign particles ≤ 1 mm (.03 in) in width if no graphic distortion 宽度 ≤ 1 mm (.03 in) 的带任何颜色、牛皮纸或杂质的痕迹，但图案未	Any tracks in Vollrath logo. 在沃华夫商标上有任何痕迹。

	变形。	
Score Checking and Score Cracking 压线开裂与压线断裂	Score checking along the length of the score when box is set up. 当包装箱装妥的时候，压线沿着长边开裂 Score cracking if ≤ 2 mm (.06 in) for no more than 50% of the score when then box is set up, on no more than two outside edges of the box. 当包装箱装妥当时，压线断裂 ≤ 2 mm (.06 in) 且不超过50%，在包装箱上不超过两个外缘。	Score cracking is > 2 mm (.062 in) or ≤ 2 mm for more than 50% of the score when the box is set up. 在包装箱装妥当时，压线断裂 > 2 mm (.062 in)或 ≤ 2 mm但超过50%。
Wrinkles 折皱	One wrinkle per box if no graphic distortion. 每个箱子一处折皱但图案未变形。 Defects on minor flaps. 缺陷出现在小的折边上。	Defect in Vollrath logo. 沃华夫商标缺陷。
Label Tears 标识泪状物	One defect ≤ 5 mm x 10mm (.19 x .38 in) where Kraft shows through per box if no graphic distortion. 包装箱牛皮纸上有一处缺陷 ≤ 5 mm x 10mm (.19 x .38 in)，但图案未变形。 One defect where Kraft shows through ≤ 20 mm x 5mm (.75 x .06 in) on each minor flap. 每一处小折边上有一处 ≤ 20 mm x 5mm (.75 x .06 in) 的牛皮纸缺陷。	Defect in Vollrath logo, barcode or part number. 沃华夫商标、条形码或零件号缺陷。 No tears thru barcode. 条形码上不得有泪状物。
Label Delamination 标识脱层	One area of label delamination that exposes the Kraft ≤ 25 mm x 5mm (1.00 x .18 in) on the edge of each major flap long as it does not interfere with automated taping equipment. 一处标识脱层导致每个主折边上牛皮纸暴露 ≤ 25 mm x 5mm (1.00 x .18 in)，但不会妨碍自动封装机的。 Two areas of delamination that expose Kraft ≤ 90 mm x 20mm (3.50 x .75 in) on each minor flap. 两处标识脱层导致每个小折边上的牛皮纸暴露 ≤ 90 mm x 20mm (3.50 x .75 in)。	Defect at manufacturer's joint. 制造商粘接处有缺陷。
Corrugated Delamination 褶皱脱层	One area of liner separation ≤ 20 mm x 5mm (.75 x .06 in) on each minor flap and inside surfaces of box. 每个小折边和内包装表面有一处 ≤ 20 mm x 5mm (.75 x .06 in)的衬垫剥离	Separation of liner from medium on all panels and major flaps. 衬垫从所有面板中间或主折边上剥离。

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Acceptance Criteria for Graphics – Continued

图案的验收标准——续

TYPE OF FLAW 缺陷类型	ACCEPTABLE 可接受的	UNACCEPTABLE 不可接受的
Bent or Crushed Flaps 弯曲或压碎的折边	<p>One area of damage $\leq 20\text{mm} \times 120\text{mm}$ (.75 x 4.75 in) on one major flap if it does not interfere with automated taping equipment. 主折边上有一处缺陷$\leq 20\text{mm} \times 120\text{mm}$ (.75 x 4.75 in) , 但该缺陷不会影响自动封装机的。</p> <p>One area of damage $\leq 20\text{mm} \times 120\text{mm}$ (.75 x 4.75 in) on each minor flap. 每一个小折边上有一处$\leq 20\text{mm} \times 120\text{mm}$ (.75 x 4.75 in)的缺陷。</p> <p>Bent hand holes. 弯曲的提手孔。</p>	
Exposed Kraft at Manufacturer's Joint 制造商粘合处暴露的牛皮纸	<p>$\leq 2\text{mm}$ (.06 in) x the length of the joint $\leq 2\text{mm}$ (.06 in) x 粘合处长度</p> <p>$\leq 3\text{mm}$ (.12 in) up to the length of the joint. $\leq 3\text{mm}$ (.12 in)至粘合处范围内</p>	
Excess Glue at Manufacturer's Joint 制造商粘合处胶水过多	<p>Clear glue $\leq 2\text{mm}$ (.06 in) in width the length of the joint. 粘合处范围内无污迹胶水宽度$\leq 2\text{mm}$ (.06 in)</p> <p>Glue with any color, Kraft, or foreign particles $\leq 1\text{mm}$ (.03 in) in width the length of the joint, or $\leq 2\text{mm}$ (.06 in) in width up to 1/3 the length of the joint. 粘合处范围内带任何颜色、牛皮纸或杂质的胶水宽度$\leq 1\text{mm}$ (.03 in) , 或在粘合处1/3范围内宽度$\leq 2\text{mm}$ (.06 in)</p> <p>There should be sufficient glue to hold the manufacturer's joint together when the box is set up. 包装箱装妥之后制造商的粘合处应当有足量的胶水。</p> <p>For specific details, see section 6 of General Specification, Corrugated Containers & Components 若需具体的细节 , 参见第6章中瓦楞纸箱和组件的一般规格</p>	<p>Excess glue seepage that causes the box to be glued shut or boxes to be glued together is unacceptable 过多的胶水渗漏可能会导致包装箱打不开或包装箱粘在一起 , 这是不允许的。</p>
Variance in the Manufacturer's Joint 制造商粘合处不一致	<p>The amount of gap at the manufacturer's joint, when measured at the flap score lines, shall not vary more than one board thickness from the specified slot gap. 在对折边压线进行测量时 , 制造商粘合处具体裂痕的裂口变化不得有超过一个纸板的厚度。</p> <p>Variations in the width of gap at the manufacturer's joint on the same box (skew, top to bottom) shall not exceed 3mm (.12 in) when measured at the two flap score lines. 在对两处折边的压线进行测量的时候 , 制造商生产的包装盒 (顶部至底部歪斜的) 粘合处裂口的变化不得超过3mm (.12 in)。</p>	

	<p>For specific details, see section 6 of General Specification, Corrugated Containers & Components 若需具体的细节，参见第6章中瓦楞纸箱和组件的一般规格。</p>	
<p>Incomplete Die Cut 不完整的修边</p>	<p>One area of uncut top corrugated liner $\leq 5\text{mm} \times 2\text{mm}$ (.19 x .06 in) on the manufacturer's joint. 制造商粘合处有一处未切到的或瓦楞纸板$\leq 5\text{mm} \times 2\text{mm}$ (.19 x .06 in)的毛边。</p> <p>One area of uncut label and/or top corrugated liner $\leq 25\text{mm} \times 5\text{mm}$ (1.00 x .19 in) on each major flap. 在每一个主折边上有一处未切到的$\leq 25\text{mm} \times 5\text{mm}$ (1.00 x .19 in)的毛边和/或瓦楞纸板。</p> <p>Two areas of uncut label and/or top corrugated liner $\leq 40\text{mm} \times 10\text{mm}$ (1.58 x .38 in) on each minor flap. 每一个小折边上有两处未切到的$\leq 40\text{mm} \times 10\text{mm}$ (1.58 x .38 in) 的毛边和/或瓦楞纸板。</p>	
<p>Strapping Marks 捆绑的痕迹</p>	<p>The outer liner is not cut through more than 2mm (.06 in). 没切开的外纸板超过2mm (.06 in)。</p> <p>Damage due to insufficient dunnage on the pallet if the outer liner is not cut through more than 2mm (.06 in) and meets the criteria stated above regarding hickies, spots, scratches, smears and streaks. ，如果外纸板未切开处没超过2mm (.06 in) ，且达到上述标准中关于脏点、划伤、污迹和划痕的要求，则损坏是由于托盘上的衬板不够造成的。</p>	
<p>Warp 扭曲</p>	<p>Maximum is 6mm per 300mm (.25 per 11.81 in), 12mm per 600mm, and (.50 x 23.63 in) etc. The container will be measured on a flat surface as a blank so the warp rises in the middle. The distance from the middle of the container to the flat surface will then be measured. 最大值为每300mm (.25 per 11.81 in)为6mm，每600mm为12mm(.50 x 23.63 in)等。包装箱将会把空白处作为平整表面来进行测量，这样扭曲处就会在中央，测量包装箱中部到平整表面的距离。</p>	
<p>False Scores 错误的压线</p>	<p>No. 无</p>	<p>Any trace. 任何痕迹。</p>

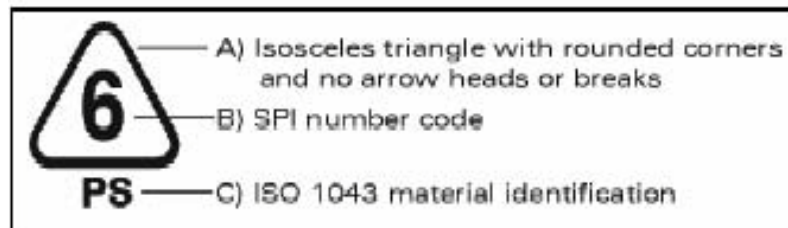
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8.0 MATERIAL MARKING REQUIREMENTS

材料标识要求

8.1 Plastic Resin Identification Marking ISO 1043 (the code for resin recycling) and the SPI resin-recycling symbol and numbering must be embossed or ink stamped on the material

ISO1043 (树脂循环使用编码) 塑料树脂识别码和 SPI 树脂循环使用号, 以及编码必须压印或油印在材料上。



Recycling Symbol
循环使用符号

- The outline figure is an isosceles triangle with rounded corners
- 外轮廓线是一个圆角等腰三角形。
- The SPI number code is located inside the triangle.
- SPI 编码位于三角形的中央。
- The ISO 1043 material identification acronym is located underneath the triangle. In cases where hybrid resin materials are used but are not covered or identified by ISO 1043, the base monomer or standard industry acronyms should be used, for example, RPET, PETG and HIPS.
- ISO 1043 材料识别的缩写位于三角形下方, 若使用了 ISO 1043 中未包括或确认的混合树脂材料, 则应使用碱单体或标准行业缩写, 如: RPET, PETG 和 HIPS。

Material 材质	ISO 1043 Acronym ISO 1043缩写	SPI Number SPI编号
Polyethylene Terephthalate 聚对苯二甲酸乙二酯	PET	1
Polyethylene α High Density (HDPE)	PE-HD	2

高密度聚乙烯		
Polyvinyl Chloride (vinyl) 聚氯乙烯	PVC	3
Polyethylene of Low Density (LDPE) 低密度聚乙烯	PE-LD	4
Polypropylene 聚丙烯	PP	5
Polystyrene 聚苯乙烯	PS	6
Polycarbonate 聚碳酸酯	PC	
Acrylonitrile/butadiene/styrene 丙烯腈-丁二烯-苯乙烯共聚物	ABS	

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9.0 LABELING REQUIREMENTS

标识要求

Product labels are distinct from product information, which can be included in the printed graphics, by virtue of being data that is known at or after manufacturing. Product labels include such things as product number, version, date code, options, and serial number.

产品标识与产品信息截然不同，借助在制造过程中或之后已知的数据，可以在印刷图案中出现。产品标识包括诸如产品号码，版本，日期码，配件以及序列号这样的信息。

9.1 Product/Bar Code Label:

产品/条形码标识：

The Vollrath representative will advise the supplier of the Product/Bar Code Labeling requirements or will provide more detailed information. Information on the Vollrath for packaging can be found at: <http://Vollrath.com/Graphics and Bar Code Labeling Requirements/index.htm>

与你一起工作的沃华夫代表将会向供货商提供正确的产品/条形码标识要求或提供更为详细的信息。沃华夫包装的信息可在下述链接中找到：<http://Vollrath.com/Graphics and Bar Code Labeling Requirements/index.htm>

9.2 Shipping Label Placement and Orientation:

运输标识的位置及方向

The following considerations should be addressed when determining the most appropriate location for the label:

在为标识确定适当的位置时，应当对下述的问题进行考虑：

- Interference with preprinted graphics (on the carton);
- 与预先印刷 (在包装箱上) 的图案有干涉
- Accessibility of location;
- 位置的可达性 ;
- Type of container (e.g. carton, pallet, truck);
- 包装箱的类型 (如 : 纸箱、托盘、卡车用包装) ;
- Survivability of the label;
- 标签的耐受性
- Label application (manual/automatic, label/tag/direct marking).
- 标签应用 (手动/自动 , 贴标/挂标/直接标注) 。

Labels should be placed no closer than 1.25 inches (32 mm) from any package edge. Label placement towards the center of the sides of rectangular, corrugated packages should be avoided due to risk of excessive abrasion damage during transportation effectively making the label useless. Labels shall be applied to the container and shall not be placed in or on the poly-pouch containing the packing list. More specific details can be found at: <http://Vollrath.com/Graphics and Bar Code Labeling Requirements/index.htm>

标签与任何包装边缘的距离不得少于 1.25 inches (32 mm) , 标签的位置应当是在侧长方形的中间 , 避免运输过程中瓦楞包装的过度磨损从而导致标签失效。标签应当贴在包装箱上 , 而不是放置在塑料袋中与装箱单放在一起。更多具体细节可以在下述链接中找到 : <http://Vollrath.com/Graphics and Bar Code Labeling Requirements/index.htm>

10.0 PALLETIZED SHIPMENT REQUIREMENT

托盘运输要求

The palletization requirements for inbound/outbound Vollrath and/or 3rd party shipments are detailed below. The supplier is responsible for providing Vollrath with a shipping container which is free of damage and cosmetic imperfections.

用于国内和国际的沃华夫和/或第三方托盘运输要求见下述详细说明。供货商负责向沃华夫提供未损坏且外观良好的运输包装箱。

10.1 Unitization, Wrapping and Banding

单元化包装 , 卷包 , 和用包装带捆

10.1.1 Pallets must be unitized to provide Vollrath with a shipping container free of damage and cosmetic imperfections allowing for reshipment in the original packaging – unless otherwise specified.

除非另有所述 , 托盘必须一致 , 向沃华夫提供未损坏且外观良好的运输包装以便于产品可用原始包装重新进行发运。

Unitize: Bringing several cartons together to form a single stable load

单元化包装：将多个包装箱放置到一起形成一个稳定的单元化载荷。

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10.1.2 Stretch wrapping is required to secure the load and provide protection from dirt.

要求进行拉伸裹包以使产品稳定，并提供灰尘防护。

10.1.3 In addition to stretch wrapping, one or more of the following methods may be required depending on the distribution environment, to ensure a damage free delivery.

除了进行拉伸裹包以外，基于分销环境的情况，有可能会要求采取下述的一个或多个方法来确保货物在运输过程中免受损坏。

- Top pallet caps shall be used to provide protection from dirt and promote better stacking of pallets
- 有可能使用托盘顶盖以提供灰尘防护，同时也更易于托盘的叠加。
- Plastic/steel banding shall be used to stabilize the load and to prevent carriers from breaking down the pallet load. Plastic PET strapping is preferred.
- 可使用塑料/铁绑带来固定装载物，以防止承运人拆散装载物，优先选择塑料 PET 绑带。
- If banding is used without a top pallet cap, edge guards shall be used to prevent the banding from damaging the load.
- 若使用了绑带但未使用托盘顶盖，必须使用保护缘，以防止绑带损坏装载物。
- If required - corner guards shall be used to provide additional compressive strength and to protect the carton corners from damage.
- 若有要求——应使用保护角以提供额外的耐压强度，并保护包装箱角受到损坏。
- All inbound palletized products shall be on a 48" x 40" (1220 x 1000mm) – 4 way pallet with a maximum unit height of 56" (1422mm). No overhang on any side is permitted.
- 所有国内托盘化产品都必须使用 48" x 40" (1220 x 1000mm) 的四向进叉托盘，最大的单品高度为 56" (1422mm)，任何一侧都不得有悬挂物。

11.0 PALLET & CRATING MATERIAL TREATMENT

托盘和板条箱材料处理

If any non-manufactured wood is used in the construction of the pallet and/or crate, it must meet the following requirements to be certified for international use. These requirements may be superseded by International Regulations.

所有用来制作托盘和/或板条箱的未经加工的木制包装材料 (NMWP) 都必须达到下述的要求，经过认证后用于国际运输。这些要求有可能会被国际规则所取代。

11.1 All wood components must be bark free, and otherwise meet or exceed the quality criteria of “multiple-use“ as described in ASME MH1-Part 3 - Wood Pallets.

所有木制品都不得有树皮，达到或超过 ASME MH1 中第 3 部分——木托盘中“多种使用”所述的质量标准。

11.2 Non-Manufactured Wood Packaging (NMWP) made from Coniferous Species (trade term “Softwood“) and/or Non-Coniferous Species (trade term “Hardwood“): If the pallet contains any amount of non-manufactured wood (regardless of species), those components must be heat treated to a minimum temperature of 56°C (133°F) for a minimum of 30 minutes.

由松柏科树木（贸易术语“软木”）和/或非松柏科树木（贸易术语“硬木”）制作成的未经加工的木制包装材料（NMWP），若托盘含有任何未经加工的木制包装材料（不论是哪类树木），则这些材料都必须经过最低处理温度为 56°C (133°F)，至少 30 分钟的热处理。

12.0 PALLET & CRATING MATERIAL MARKING

托盘和板条箱材料标记

12.1.1 Marking Procedure

注标程序

12.1.2 The marking shall consist of the pest free symbol where justified (HT only at this time), (or bug free symbol), the country of manufacture, and the supplier /facility designation.

标记应当包含合理的无害虫符号（当前仅用 HT），（或无臭虫符号），制造国家，以及供货商/工厂名称。

12.1.3 Mark the pallet, skid, crate or other wooden packaging assembly a minimum of one time on an exterior vertical surface. Duplicate information on the opposite exterior surface is recommended in 托盘、垫木、板条箱或其它木包装上，在其外面的垂直表面至少作一处标注，建议在外表面的对面复制该信息。

12.1.4 Use 19mm (0.75 in) minimum high characters. Printing may be done with ink jet printing, heat stamping, paint stencil, or other similar permanent and indelible method. The default color should be black or other maximum contrasting color if appropriate. Do not use red or orange since these colors are used with labeling of dangerous goods.

字体至少为 19mm (0.75 in)高，可使用喷墨印刷，热冲压，镭花涂装，或其它永久或擦抹不掉的方法进行印刷。默认的颜色是黑色，若适用，可使用其它对比度最高的颜色。不要使用红色或橙色，因为这样的颜色通常用于危险性物品的标注。

12.1.5 If vertical surfaces provide insufficient space for the markings then scale the characters accordingly or apply them to a top horizontal surface provided that at a minimum the treatment initials and pest free symbol (if appropriate) is repeated on two opposite vertical surfaces. It is

also permitted to print the information on multiple lines or break up the information, for instance spread across three separate blocks on a block style pallet.

如垂直表面不能提供足够的空间来进行标注，则相应地缩小字体或将其印在水平表面，且至少在两个垂直的相对表面印刷无害虫符号（若适用）。同时也允许将信息进行分行印刷，或将信息断开，如在托盘上印刷三组齐头式的信息。

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12.2 Material Classification Requirements

材料分类要求

An item must only carry one classification regardless of how many different materials are included in the construction. Following the list below - in sequence; the item should carry the marking of the first scenario that matches exactly. Careful consideration must be given for assemblies which contain a mixture of materials as explained further:

不管在制作过程中使用了多少种不同的材料，一个产品只能使用一个分类。根据下述的清单——按顺序，产品应当使用与第一种描述完全匹配的标识。必须仔细考虑该产品都包含了哪些混合的材料，以作更进一步的说明：

12.2.1 Untreated Non-Manufactured Wood Packaging (NMWP) or if Material Composition is Unknown (XX)

未经加工的木制包装材料 (NMWP) 或材料构成未知 (XX)

Must Contain: ANY amount of non-manufactured wood components which have definitely been untreated or the treatment history is unknown - Example: old pallets or crates or those which have been refurbished with a variety of reused pallet components.

必须包含：任何未经加工的木质材料，且完全未经过热处理或其处理情况未知的情况——如：旧托盘或板条箱，或那些用已用过的托盘材料来翻新的产品。

May Contain: Any amount less than 100% to total composition of treated wood of any species - MWPM, and/or non-wooden material.

有可能会包含：任何小于 100%或所有的混合物都是处理过的木材或任何经过加工的木材，和/或非木制材料。

Must NOT Contain: Not Applicable.

不得包含：不适用。

Example:

例如：

No Marking or XX

The pest free symbol must not be used for untreated non-manufactured wood or materials in which the composition cannot be confirmed.

Important: Vollrath does not accept untreated non-manufactured wood in packaging used for shipments regardless of origin or destination. This is so that any pallet could be reused and re-exported if needed. Thus, this mark (XX or no mark) should only exist on inventory that predates this specification.

重要提示：不论是在发运地还是收货地，沃华夫公司的运输包装不接受任何未经加工的木质材料，这是为了让任意的托盘在需要的时候都可以重复使用或复出口。故早于本规范的该标记（XX 或无标记）仅会在库房出现。

Important: Painted over symbols or no symbols at all are signals that the particular item requires additional treatment prior to export.

重要提示：涂掉符号或根本没有符号的意味着这些产品要求在出口之前进行额外的处理。

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12.2.2 Non-Manufactured Wood Packaging (NMWP), Heat Treated (HT or HT-DB)

未经加工的木制包装材料 (NMWP) ，热处理 (HT 或 HT-DB)

Must Contain: ANY amount of properly heat treated non-manufactured wood which by definition has been heated to a core temperature of at least 56°C (133°F) for a minimum of 30 minutes and that documentation certifying that fact has been provided by the treatment facility to the package/pallet manufacturer and can be traced to the production of that specific package, pallet, etc.

必须包含：任何经过适当热处理的未经加工的木制包装材料，用定义来说即是指至少经过中心温度为 56°C (133°F)，30 分钟热处理的材料，证明文件证明了包装/托盘制造商的产品由热处理厂进行热处理的事实，同时也能够对具体的包装和托盘等的生产进行追溯。

May Contain: Any amount of MWPM and/or non-wooden material.

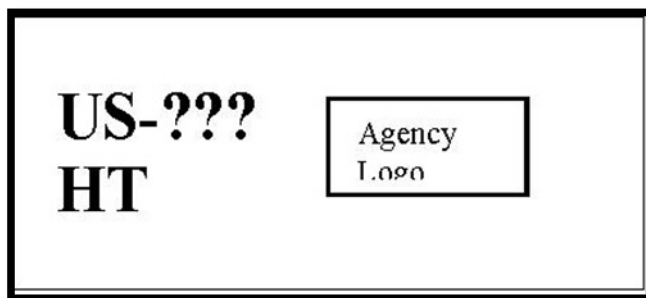
有可能会包含：任何经过加工的木制包装材料和/或非木制材料。

Must NOT Contain: Any amount of untreated non-manufactured wood (Coniferous or Non-Coniferous).

不得包含：任何未经处理的未加工的木材 (松柏科或非松柏科) 。

Example:

范例：



Important: The “???” is to be replaced by the officially assigned facility code or supplier initials. Do not actually mark “???”.

重要提示：“???”必须由官方指定的工厂编号或供货商首字母缩略词来代替，不得使用“???”符号。

Secondary Qualification Marking: The initials “DB” should follow the mandatory treatment marking for all wood that has been “debarked” (ex: “HT-DB). This should always be the case for Vollrath wooden pallets or crates.

次级认证标识：带字母“DB”的所有木材是强制性处理符号，所有的木材都应当“去除树皮”的（如：“HT-DB”），对于沃华夫の木托盘或板条箱来说，应该一直都是如此。

Note: Use of kiln dried **lumber** is acceptable provided that it meets the temperature and duration requirements (56C for 30 minutes) to meet the definition of “heat treated”. Such materials are usually mill stamped “KD-HT” or “HT”. Dry lumber alone is not a reliable indication of proper heat treatment nor are materials mill stamped “KD”.

注意：若能够达到温度和时间(56C，30分钟)所定义的“热处理”要求，木材使用窑内烘干是可以接受的。这些材料通常使用压印“KD-HT”或“HT”的符号，干燥木材本身和压印了“KD”的材料并不是一个适当的热处理指标。

12.2.3 Non-Manufactured Wood Packaging (NMWP), Fumigated with Methyl Bromide (MB or MB-DB)

未经加工的木制包装材料 (NMWP) ， 溴甲烷熏蒸 (MB 或 MB-DB)

Must Contain: ANY amount of properly fumigated non-manufactured wood and that documentation certifying that fact has been provided by the treatment facility to the package/pallet manufacturer and can be traced to the production of that specific package, pallet, etc.

必须包含：任何适当的经过溴甲烷熏蒸的未加工木制包装材料，证明文件证明了包装/托盘制造商的产品由溴甲烷熏蒸处理厂进行溴甲烷熏蒸处理的事实，同时也能够对具体的包装和托盘等的生产进行追溯。

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May Contain: Any amount of MWPM and/or non-wooden material.

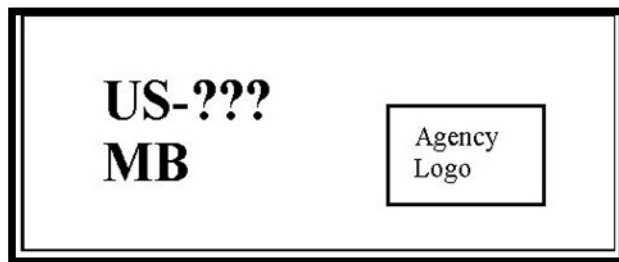
可能包含：任何加工的木制包装材料与非木制材料。

Must NOT Contain: Any amount of untreated non-manufactured wood (Coniferous or Non-coniferous)

不得包含：任何未经处理的未加工的木材（松柏科或非松柏科）。

Example:

范例：



Important: The “???” is to be replaced by the officially assigned facility code or supplier initials.

Do not actually mark “???”.

重要提示：“???”必须由官方指定的工厂编号或供货商首字母缩略词来代替，不得使用“???”符号。

Secondary Qualification Marking: The initials “DB” should follow the mandatory marking “MB” if the wood has been “debarked” prior to prior to treatment.

次级认证标识：如果木材在处理之前就已“去除树皮”，则字母“DB”应当跟在“MB”符号的后面。

12.2.4 Manufactured Wood Packaging Material (MWPM)

加工过的木材包装材料 (MWPM)

Must Contain: ANY amount of manufactured/processed wood components. Example, a pallet or crate made with any amount of Oriented Strand board (OSB), plywood, strawboard, masonite, particle board, paper overlaid veneer (POV), laminated veneer lumber (LVL) or combination of these. These all meet the definition of manufactured wood packing materials as defined by the Animal and Plant Health Inspection Service (APHIS). Such materials are not regulated.

必须包含：已制造/加工过的木材成分，如：含定向结构刨花板 (OSB)、胶合板、硬纸板、纤维板、木屑板、复模纸板 (POV)、的托盘和板条箱，单板层积材 (LVL) 或这些材料的组合所生产的托盘或板条箱。这些能够达到动植物卫生检验局 (APHIS) 定义的已加工木制包装材料的要求，此类材料不进行控制。

May Contain: Any amount of non-wooden material.

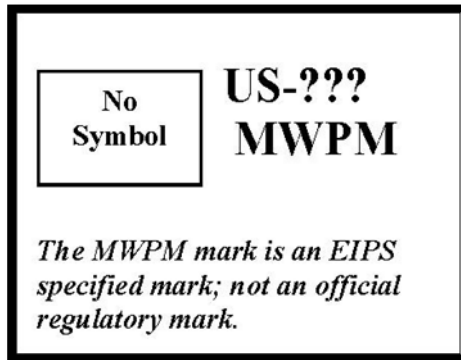
可能包含：任何非木制材料。

Must NOT Contain: Any amount of non-manufactured wood of any type whether treated or not.

不得包含：任何类型的不论是否处理过的未加工木材。

Example:

范例：



Important: The “???” is to be replaced by the officially assigned facility code or supplier initials. Do not actually mark “???”.

重要提示：“???”必须由官方指定的工厂编号或供货商首字母缩略词来代替，不得使用“???”符号。

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Note: Plywood/OSB/Masonite and so on are considered “manufactured wood” because it has been processed under extreme heat and pressure. It is irrelevant what wood species is used in the manufacture of these materials (can be coniferous and/or non-coniferous). Assembling a pallet from cut lumber is not considered “manufactured” with regard to pest migration regulations.

注意：胶合板 / 含定向结构刨花板 / 纤维板通常被视为“加工过的木材”，因为它们在加工过程中经过高温和高压的处理，这跟制造这些材料所使用的木材种类无关（可以是松柏类和 / 或非松柏类）。从这些木料上切割下来装配托盘不得视为害虫侵袭规章中所述的“加工过”的材料。

12.2.5 Additional Requirements

其它的要求

A. Supplier/Manufacturing Facility Designation

供货商 / 制造商名称

An official facility registration number (3 characters) provided by the National Plant Protection Organization must be used if available. If this process is not yet established in your country or location, one of the following must be used instead:

如果有，必须使用国家工厂保护组织所提供的官方厂家登记号（3 个字母），若该系统在您所在的国家和地区尚未建立，则必须使用下述情况中的一种：

- A minimum 5 character abbreviation of the supplier's name.
- 供货商名称缩写，至少五个字母。
- A minimum 3 digit abbreviation followed by 2 numeric digits to distinguish unique manufacturing facilities of that supplier.
- 用以区分制造工厂和供货商的 3 个数字缩写与 2 个数字码。
- The supplier's logo if this can be easily distinguished. The logo may also be followed by a 2 digit number to identify a specific facility of that supplier.
- 若供货商商标能够轻易地辨识出来，可使用供货商商标，另加 2 个数字码以确认供货商具体的生产工厂。
- The full name of the supplier if this can be accommodated in the space available.
- 如果位置够用，可使用供货商全称。
- The name shall be that of the final assembly location which built the pallet or package and shipped it for use.
- 使用最终生产托盘或包装以及发运产品的装配厂名称。

Caution: The code chosen must not resemble one of the material classifications.

警告：代码的选择不得与任何一种材料分类码类似。

B. Part Number

零件号

Use the alpha-numeric part number of the pallet or crate (usually 7 characters) which is specified by the pallet purchaser/user. The part number should be 19mm (0.75 in) characters.

托盘或板条箱应使用文字+数字零件号（通常为 7 个字母），一般由托盘采购商/使用人指定。零件号字母的大小应当为 19mm (0.75 in)。

C. Pest Free Symbol

无害虫符号

Use the approved marking for regulated non-manufactured wood packing materials (NMWP) that have been properly treated by an authorized **agent**. Its appearance on a pallet indicates full compliance to all international regulations aimed at preventing pest migration. It shall be printed as large as practical but at least 38mm (1.50 in) (equivalent to the total height of the test portion of the markings.)

使用经过认可的制剂进行处理过的，规定的未经加工的木制材料（NMWP）已认可的符号。托盘外观满足所有关于害虫侵袭要求的国际标准，应当按惯例进行印刷，但不得低于38mm (1.50 in)的高度（与标识测试部分的总高度相当）。

Important: *This symbol is NOT to be used at this time for non-regulated materials even if they are inherently pest free.*

重要提示：*尽管受管制的材料本身就是无害虫危害的，但在此处仍不得使用该符号。*

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13.0 Appendix A: Protective Package Test Check List

附录 A：保护性包装测试一览表

Product: 产品		Date: 日期	
No. of Units: 产品件数：		Mass: 毛重：	()kg ()lb ()公斤 ()磅
ODM/OEM Name & Contact Details: 原始设计商/原始生产商名称及联系细节			
Test Requester: 测试提交人：		Tel: 电话：	
(Check one) (勾1项)		Type 1 – Boxed product, not palletized 类型1——盒装产品，非托盘装运	
		Type 2 – Single product, palletized 类型2——单品托盘装运	
		Type 3 – Multiple products, unitized 类型3——多个产品托盘装运	
Tests Required: 测试要求		Per ASTM Test 按ASTM测试	Comments: 结论：
Random Vibration 随机振动		D880	
Fixed Displacement Vibration 固定振幅振动		D642	
Impact/Free Fall Drop 冲击/自由跌落		D4728	
Compression 压缩试验		D999	
Rotational Edge Drop 旋转边跌落测试		D6179 Method A D6179 方法 A	
Rotational Corner 旋转角跌落测试		D6179 Method B D6179 方法 B	
Rotational Flat Drop 旋转平落测试		D6179 Method C D6179 方法 C	
Tip Test 倾斜测试		D6179 Method F D6179 方法 F	
Tipover 翻倒测试		D6179 Method G D6179 方法 G	

Field Shipment 实地试验			
Other: 其它			