**Machine finished Kraft Paper for dry foods —Specification**

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**Machine finished Kraft Paper for packaging of dry food —Specification**

**KENYA BUREAU OF STANDARDS (KEBS)**

**Head Office:** P.O. Box 54974, Nairobi-00200, Tel.: (+254 020) 605490, 602350, Fax: (+254 020) 604031

E-Mail: info@kebs.org, Web:http://www.kebs.org

**Coast Region Lake Region Rift Valley Region**

P.O. Box 99376, Mombasa-80100 P.O. Box 2949, Kisumu-40100 P.O. Box 2138, Nakuru-20100

Tel.: (+254 041) 229563, 230939/40 Tel.: (+254 057) 23549, 22396 Tel.: (+254 051) 210553, 210555

Fax: (+254 041) 229448 Fax: (+254 057) 21814

**Foreword**

This Kenya Standard was prepared by the Technical Committee on Packaging (053) under the guidance of the Standards Projects Committee, and it is in accordance with the procedures of the Kenya Bureau of Standards.

Machine finished Kraft paper is one that is treated mechanically on the paper or board machine to improve the smoothness and uniformity of appearance on both sides. The pulping process utilizes Kraft pulp yielding its natural brown color. Bleached Kraft Paper under goes a treatment using bleach and other additives to produce white colour.

In the manufacturing sector, machine finished Kraft paper is used for packaging of sugar, flour and dry food carrier bags.

This standard shall be useful to manufacturers dry foods, converters, fast food outlets, importers, exporters, standards enforcement agencies and other stakeholders.

Parameters covered in the standard include Stretch, tensile strength, tensile energy absorption, burst index, tear strength, pH, cobb, dimension Limits of heavy metals and organic contaminants, Microbiological requirements among others.

During the preparation of this standard, reference was made to the following document:

**Information from the packaging Industry**

Acknowledgement is hereby made for the assistance derived from this source.

**Machine finished Kraft Paper for packaging of dry food —Specification**

**1 Scope**

This Kenya Standard specifies the requirements and methods of sampling and test for Machine finished Kraft Paper used for packaging of dry food such as sugar, flour and dry food carrier bags

**2 Normative references**

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

*EAS 880, Waxed paper for packaging of confectionery — Specification*

*EAS 930 Paper and board food contact packaging material — Specification*

*EAS 933, Paper and board intended to come into contact with foodstuffs — Determination of formaldehyde in an aqueous extract*

[*ISO 186 Paper and board -- sampling to determine average quality*](https://www.iso.org/contents/data/standard/03/42/34233.html)

*ISO 216 Writing paper and certain classes of printed matter -- Trimmed sizes -- A and B series, and indication of machine direction*

*ISO 536 Paper and board -- Determination of grammage*

*ISO 2758 Paper -- Determination of bursting strength*

*ISO 1974 Paper -- Determination of tearing resistance -- Elmendorf method*

*ISO 1924-3, Paper and board — Determination of tensile properties — Part 3: Constant rate of elongation method (100 mm/min)*

*ISO 187 Paper and board -- Conditioning of samples*

*ISO 9184-1**Paper, board and pulps -- Fibre furnish analysis -- Part 1: General method*

[*ISO 4046-1*](http://www.iso.org/iso/home/store/catalogue_tc/catalogue_detail.htm?csnumber=29836) *Paper, board, pulps and related terms -- Vocabulary -- Part 1: Alphabetical index*

*ISO 4046-2. Defines terms related to pulping, in both English and French.*

*ISO 4046-3: Defines terms related to paper making, in both English and French*

*ISO 4046-4: Defines terms related to paper and board grades and converted products, in both English and French.*

*ISO 5637 Paper and Board -- Determination of water absorption after immersion in water*

*ISO 6588-1 Paper, board and pulps — Determination of pH of aqueous extracts — Part 1: Cold extraction*

*ISO 8784-1, Pulp, paper and board — Microbiological examination — Part 1: Total count of bacteria, yeast, mould based on disintegration*

*ISO 16532-3 Paper and Board -- Determination of grease resistance -- Part 3: turpentine test for voids in glassine and greaseproof papers*

*ISO 3781 Paper and Board -- Determination of tensile strength after immersion in water*

**3. Terms and definition**

For the purposes of this standard the terminologies given in KS ISO 4046 part 1 to 5 and others below shall apply.

**3.1**

**machine finished Kraft paper or board**

paper or board treated mechanically on the paper board machine to improve the smoothness and uniformity of appearance on both sides

**4 Requirements**

**4.1 General requirements**

The fibre used shall be purely virgin pulp and shall be machine finished Kraft paper and free from visible specks, creases, cuts holes and other paper defects.

**5. Specific requirements**

**5.1 Specific requirements for machine finished Kraft paper**

Machine finished Kraft Paper for packaging of dry food shall meet the physical requirements as specified in table 1

Table 1 — Physical requirements for Machine finished Kraft Paper for packaging of dry food

|  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **S/No.** | **Characteristic** | | **Requirement** | | | | | | **Test method** |
|  | Grammage, g/m2, min, ± 5 % | | 70 | 80 | 90 | 100 | 110 | 120 | KS ISO 536 |
|  | Moisture content, %, range | | 5 — 8.5 | | |  | | | KS ISO 287 |
|  | Tensile strength, kN/m, min | MD | 5.9 | 6.8 | 7.6 | 8.5 | 9.3 | 10.2 | KS ISO 1924-3 |
| CD | 2.9 | 3.4 | 3.8 | 4.2 | 4.6 | 5.1 |
|  | Stretch, %, min | MD | 1.8 | 1.8 | 2 | 2 | 2.1 | 2.1 | KS ISO 1924-3 |
| CD | 5 | 5 | 5 | 5 | 5 | 5 |
|  | Burst Strength, Kpa, min | | 245 | 280 | 315 | 350 | 385 | 420 | KS ISO 1924-3 |
|  | Burst Index,Kpa.m2/g,min | | 3.5 | | | | | | *KS ISO 2758* |
|  | Tear Strength, mN, min. | MD | 450 | 525 | 600 | 675 | 750 | 825 | KS ISO 1924-3 |
| CD | 525 | 600 | 675 | 750 | 825 | 900 |
|  | TEA, j/m2,min | MD | 77 | 88 | 99 | 110 | 121 | 132 | KS ISO 1924-3 |
| CD | 112 | 128 | 144 | 160 | 176 | 192 |
|  | TEA index, j/g, min | MD | 1.1 | | | | | | KS ISO 1924-3 |
| CD | 1.6 | | | | | |
|  | pH | 5 —8.5 | | | | | |  | KS ISO 6588- |
|  | Cobb (60s),max | 35 | | | | | |  | *KS ISO 5637* |

|  |
| --- |
|  |

**5.2 Limits of heavy metals and organic contaminants for** machine finished Kraft paper

Machine finished Kraft paper shall meet the Limits of heavy metals and organic contaminants as specified in EAS 930

**5.3 Microbiological requirements for** machine finished Kraft paper

Machine finished Kraft paper shall meet the microbial requirements as specified in EAS 930

**5.4 Dimension**

**5.4.1** When tested in accordance with ISO 216 the dimensions (length and width) of the sheet shall be as specified in the marking within a tolerance of ± 0.5 %.

**5.4.2** For machine finished Kraft paper supplied in reels, the width and diameter of the reel shall be as declared and the diameter shall be within a tolerance of ± 6 mm when tested in accordance with Annex A.

**6 Packaging and Labelling**

**6.1 Packaging**

**6.1.1** Machined finished Kraft paper shall be packed in suitable materials that prevents it from damage, contamination during l handling, storage and transportation.

**6.2 Labelling**

**6.2.1 Bulk package**

The bulk package of machine finished Kraft paper shall be legibly and indelibly marked with the following information.

1. Manufacturer’s name, address and /or registered trade mark.
2. Description of goods, “machine finished Kraft paper ”.
3. Dimensions.
4. Batch number or code
5. Instruction for correct use
6. Instruction for storage and disposal.
7. The declaration, ‘country of origin.

**6.2.2 Machine finished Kraft Paper for packaging of dry food**

The Machine finished Kraft paper shall be legibly and indelibly marked with the following information

1. Manufacturer’s name, address and /or registered trade mark.
2. Batch number or code
3. Instruction for correct use, storage and disposal.

**7 Sampling**

Sampling of the machined finished Kraft paper shall be done in accordance to ISO 186

Annex A  
  
(normative)  
Measurement of dimensions

**A.1** Measure to the nearest 0.5 mm, the width, (parallel to the cross direction of the paper) of each five test specimen taken across full width of five separate rolls and record the average of the results.

**A.2** Measure to the nearest 1 mm, the diameter of each of the five rolls and record the results. Check for compliance with 5.4.2.