



Standard Practice for Sampling and Accepting a Single Lot of Paper, Paperboard, Fiberboard, and Related Product¹

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1. Scope

1.1 This practice covers a procedure for obtaining a sample to represent a lot of paper or paperboard, fiberboard, or related product, including converted paper products (all hereafter referred to as *paper*).

1.2 Prior to purchase, there should be agreement between buyer and seller on the size of the lot to be sampled (5.1), on details of the sampling procedure, the required physical and chemical properties, dimensional tolerances, etc., and the test methods to be employed.

1.3 Appendix X1 and Appendix X2, which provide useful, statistical criteria for accepting individual lots of paper on the basis of the number of defective test units, can assist the buyer and the seller in selecting an agreed-upon sampling and acceptance procedure.

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 ASTM Standards:

D 528 Test Method for Machine Direction of Paper and Paperboard²

D 1968 Terminology Relating to Paper and Paper Products²

D 5039 Test Methods for Identification of Wire Side of Paper²

2.2 ISO Standard:

ISO 186 Paper and Board—Sampling for Testing³

2.3 Military Standards:

MIL-STD-105D Sampling Procedures and Tables for Inspection by Attributes⁴

MIL-STD-414 Sampling Procedure and Table for Inspection by Variables for Percent Defective⁴

¹ This practice is under the jurisdiction of ASTM Committee D-6 on Paper and Paper Products and is the direct responsibility of Subcommittee D 06.92 on Test Methods.

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² *Annual Book of ASTM Standards*, Vol 15.09.

³ Available from American National Standards Institute, 11 W. 42nd St., 13th Floor, New York, NY 10036.

⁴ Available from Standardization Documents Order Desk, Bldg. 4 Section D, 700 Robbins Ave., Philadelphia, PA 19111-5094, Attn: NPODS.

3. Terminology

3.1 *Definitions*—Definitions shall be in accordance with Terminology D 1968 and the *Dictionary of Paper*.⁵

4. Significance and Use

4.1 If a lot of paper is to be accepted or rejected on the basis of a series of tests made on the paper, it is important to sample the paper in a way that will give a test result that is representative of the lot of paper.

5. Establishing the Lot

5.1 *General Considerations*—Avoid grouping together as a lot batches of paper likely to differ significantly from each other in raw materials or manufacture. If the shipment is small or consists of a large number of batches, it may be uneconomical or impracticable to form lots conforming with the definition (3.1). If this is the case, divide the shipment into portions, to be designated “sublots,” in which each portion conforms to the definition of *lot*. Before starting the sampling, obtain a complete understanding of the paper to be sampled, including the composition and size of lots and sublots, rolls, skids, etc.

5.2 Location of Sampling:

5.2.1 *Sampling at the Paper Mill*—When paper is to be delivered in large rolls or skids, if agreed, have the sample taken at the paper mill and delivered to the purchaser for examination and testing. Include in the purchase agreement a definition of the number of rolls or skids constituting a lot and details of the sampling procedure to ensure compliance with the rules in selecting the sample in accordance with Section 6. Especially indicate whether the sample was taken from mill reels or from the finished rolls or skids.

5.2.2 *Sampling in Transit or Warehouse*—It may be necessary to take a sample at a dock or warehouse en route between the supplier and the purchaser, especially for international shipments or in referee sampling for testing. Sampling in transit or warehouse can be quite expensive and should be avoided whenever possible, because of the problem of resealing. Arranging to inspect the shipment prior to unloading is recommended on inspection in transit. Establish the size of each lot and determine which rolls or skids will be sampled, and arrange to sample and reseal the rolls or skids as they are

⁵ Available from the Technical Association of the Pulp and Paper Industry, Technology Park, P.O. Box 105113, Atlanta, GA 30348.