

Chapter 6.5

Provisions for the construction and testing of intermediate bulk containers (IBCs)

6.5.1 General requirements

6.5.1.1 Scope

6.5.1.1.1 The provisions of this chapter apply to IBCs intended for the transport of certain dangerous substances and materials.

6.5.1.1.2 IBCs and their service equipment not conforming strictly to the provisions herein, but conforming to acceptable alternatives, may be considered by the competent authority concerned for approval. In order to take into account progress in science and technology, the use of alternative arrangements which offer at least an equivalent degree of safety in transport in respect of compatibility with the substances to be loaded therein and an equivalent or superior resistance to handling impact, and fire, may be considered by the competent authority concerned.

6.5.1.1.3 The construction, equipment, testing, marking and operation of IBCs shall be subject to acceptance by the competent authority of the country in which the IBCs are approved.

6.5.1.1.4 Manufacturers and subsequent distributors of IBCs shall provide information regarding procedures to be followed and a description of the types and dimensions of closures (including required gaskets) and any other components needed to ensure that IBCs as presented for transport are capable of passing the applicable performance tests of this chapter.

6.5.1.2 Definitions

Body (for all categories of IBCs other than composite IBCs) means the receptacle proper, including openings and their closures, but does not include service equipment.

Handling device (for flexible IBCs) means any sling, loop, eye or frame attached to the body of the IBC or formed from a continuation of the IBC body material.

Maximum permissible gross mass means the mass of the IBC and any service or structural equipment together with the maximum net mass.

Plastics material, when used in connection with inner receptacles for composite IBCs, is taken to include other polymeric materials such as rubber.

Protected (for metal IBCs) means the IBC being provided with additional protection against impact, the protection taking the form of, for example, a multi-layer (sandwich) or double-wall construction or a frame with a metal latticework packaging.

Service equipment means filling and discharge devices and, according to the category of IBC, pressure relief or venting, safety, heating and heat-insulating devices and measuring instruments.

Structural equipment (for all categories of IBCs other than flexible IBCs) means the reinforcing, fastening, handling, protective or stabilizing members of the body, including the base pallet for composite IBCs with plastics inner receptacle, fibreboard and wooden IBCs.

Woven plastics (for flexible IBCs) means a material made from stretched tapes or monofilaments of a suitable plastics material.

6.5.1.3 Categories of IBCs

6.5.1.3.1 *Metal* IBCs consist of a metal body together with appropriate service and structural equipment.

6.5.1.3.2 *Flexible* IBCs consist of a body constituted of film, woven fabric or any other flexible material or combinations thereof, and if necessary an inner coating or liner, together with any appropriate service equipment and handling devices.

6.5.1.3.3 *Rigid plastics* IBCs consist of a rigid plastics body, which may have structural equipment together with appropriate service equipment.

- 6.5.1.3.4 *Composite* IBCs consist of structural equipment in the form of a rigid outer packaging enclosing a plastics inner receptacle together with any service or other structural equipment. The IBC is so constructed that the inner receptacle and outer packaging, once assembled, form, and are used as, an integrated single unit to be filled, stored, transported or emptied as such.
- 6.5.1.3.5 *Fibreboard* IBCs consist of a fibreboard body with or without separate top and bottom caps, if necessary, an inner liner (but no inner packagings) and appropriate service and structural equipment.
- 6.5.1.3.6 *Wooden* IBCs consist of a rigid or collapsible wooden body together with an inner liner (but no inner packagings) and appropriate service and structural equipment.

6.5.1.4 Designatory code system for IBCs

6.5.1.4.1 The code shall consist of two Arabic numerals as specified in .1 followed by one or more capital letters as specified in .2; followed, when specified in an individual section, by an Arabic numeral indicating the category of IBC.

.1

Type	For solids, filled or discharged		For liquids
	by gravity	under pressure of more than 10 kPa (0.1 bar)	
Rigid	11	21	31
Flexible	13	–	–

.2 Materials

- A Steel (all types and surface treatments)
- B Aluminium
- C Natural wood
- D Plywood
- F Reconstituted wood
- G Fibreboard
- H Plastics material
- L Textile
- M Paper, multiwall
- N Metal (other than steel or aluminium)

6.5.1.4.2 For a composite IBC, two capital letters in Latin characters shall be used in sequence in the second position of the code. The first shall indicate the material of the inner receptacle of the IBC and the second that of the outer packaging of the IBC.

6.5.1.4.3 The following types and codes of IBCs are assigned:

Material	Category	Code	Paragraph
<i>Metal</i>			6.5.5.1
A Steel	for solids, filled or discharged by gravity for solids, filled or discharged under pressure for liquids	11A 21A 31A	
B Aluminium	for solids, filled or discharged by gravity for solids, filled or discharged under pressure for liquids	11B 21B 31B	
N Other than steel or aluminium	for solids, filled or discharged by gravity for solids, filled or discharged under pressure for liquids	11N 21N 31N	
<i>Flexible</i>			6.5.5.2
H Plastics	woven plastics without coating or liner woven plastics, coated woven plastics with liner woven plastics, coated and with liner plastics film	13H1 13H2 13H3 13H4 13H5	
L Textile	without coating or liner coated with liner coated and with liner	13L1 13L2 13L3 13L4	

Material	Category	Code	Paragraph
<i>Flexible</i> (continued) M Paper	multiwall multiwall, water-resistant	13M1 13M2	6.5.5.2
H Rigid plastics	for solids, filled or discharged by gravity, fitted with structural equipment for solids, filled or discharged by gravity, freestanding for solids, filled or discharged under pressure, fitted with structural equipment for solids, filled or discharged under pressure, freestanding for liquids, fitted with structural equipment for liquids, freestanding	11H1 11H2 21H1 21H2 31H1 31H2	6.5.5.3
HZ Composite with plastics inner receptacle*	for solids, filled or discharged by gravity, with rigid plastics inner receptacle for solids, filled or discharged by gravity, with flexible plastics inner receptacle for solids, filled or discharged under pressure, with rigid plastics inner receptacle for solids, filled or discharged under pressure, with flexible plastics inner receptacle for liquids, with rigid plastics inner receptacle for liquids, with flexible plastics inner receptacle	11HZ1 11HZ2 21HZ1 21HZ2 31HZ1 31HZ2	6.5.5.4
G Fibreboard	for solids, filled or discharged by gravity	11G	6.5.5.5
<i>Wooden</i> C Natural wood	for solids, filled or discharged by gravity, with inner liner	11C	6.5.5.6
D Plywood	for solids, filled or discharged by gravity, with inner liner	11D	
F Reconstituted wood	for solids, filled or discharged by gravity, with inner liner	11F	


* The code shall be completed by replacing the letter 'Z' by a capital letter in accordance with 6.5.1.4.1.2 to indicate the nature of the material used for the outer packaging.

6.5.1.4.4 The letter 'W' may follow the IBC code. The letter 'W' signifies that the IBC, although of the same type as indicated by the code, is manufactured to a specification different from those in section 6.5.3 and is considered equivalent in accordance with the provisions in 6.5.1.1.2.

6.5.2 Marking

6.5.2.1 Primary marking

6.5.2.1.1 Each IBC manufactured and intended for use according to these provisions shall bear durable marks which are legible and placed in a location so as to be readily visible. Letters, numbers and symbols shall be at least 12 mm high and shall show:

- .1 the United Nations packaging symbol: 

This symbol shall not be used for any purpose other than certifying that a packaging, a flexible bulk container, a portable tank or a MEGC complies with the relevant requirements in chapters 6.1, 6.2, 6.3, 6.5, 6.6, 6.7 or 6.9. For metal IBCs on which the mark is stamped or embossed, the capital letters "UN" may be applied instead of the symbol;

- .2 the code designating the type of IBC according to 6.5.1.4;
- .3 a capital letter designating the packing group(s) for which the design type has been approved:
 - "X" for packing groups I, II and III (IBCs for solids only);
 - "Y" for packing groups II and III; or
 - "Z" for packing group III only;
- .4 the month and year (last two digits) of manufacture;
- .5 the State authorizing the allocation of the marks, indicated by the distinguishing sign used on vehicles in international road traffic;*

* Distinguishing sign of the State of registration used on motor vehicles and trailers in international road traffic, e.g. in accordance with the Geneva Convention on Road Traffic of 1949 or the Vienna Convention on Road Traffic of 1968.

- .6 the name or symbol of the manufacturer and other identifications of the IBC as specified by the competent authority;
- △ .7 the stacking test load in kilograms. For IBCs not designed for stacking, the figure “0” shall be shown;
- .8 the maximum permissible gross mass in kilograms.

The primary marks required above shall be applied in the sequence of the subparagraphs above. The marks required by 6.5.2.2 and any further mark authorized by a competent authority shall still enable the primary marks to be correctly identified.

Each mark applied in accordance with .1 to .8 and with 6.5.2.2 shall be clearly separated, e.g. by a slash or space, so as to be easily identifiable.

6.5.2.1.2 Examples of marks for various types of IBCs in accordance with .1 to .8 above:



11A/Y/02 99/
NL/...* 007/
5500/1500

For a metal IBC for solids discharged by gravity and made from steel/ for packing groups II and III/ manufactured in February 1999/ authorized by the Netherlands/ manufactured by . . . *(name of manufacturer) and of a design type to which the competent authority has allocated serial number 007/ the stacking test load in kilograms/ and the maximum permissible gross mass in kilograms.



13H3/Z/03 01/
F/...* 1713/
0/1500

For a flexible IBC for solids discharged by gravity and made from woven plastics with a liner/ not designed to be stacked.



31H1/Y/04 99/
GB/...* 9099/
10800/1200

For a rigid plastics IBC for liquids made from plastics with structural equipment withstanding the stack load.



31HA1/Y/05 01/
D/...* 1683/
10800/1200

For a composite IBC for liquids with a rigid plastics inner receptacle and steel outer packaging.



11C/X/01 02/
S/...* 9876/
3000/910

For a wooden IBC for solids with an inner liner and authorized for packing group I solids.



11G/Z/06 02/
I/...* 962/
0/500

For a fibreboard IBC/ not designed to be stacked.



11D/Y/07 02/
E/...* 261/
3240/600

For a plywood IBC with inner liner.

- 6.5.2.1.3 Where an IBC conforms to one or more than one tested IBC design type, including one or more than one tested packaging or large packaging design type, the IBC may bear more than one mark to indicate the relevant performance test requirements that have been met. Where more than one mark appears on an IBC, the marks shall appear in close proximity to one another and each mark shall appear in its entirety.

6.5.2.2 Additional marking

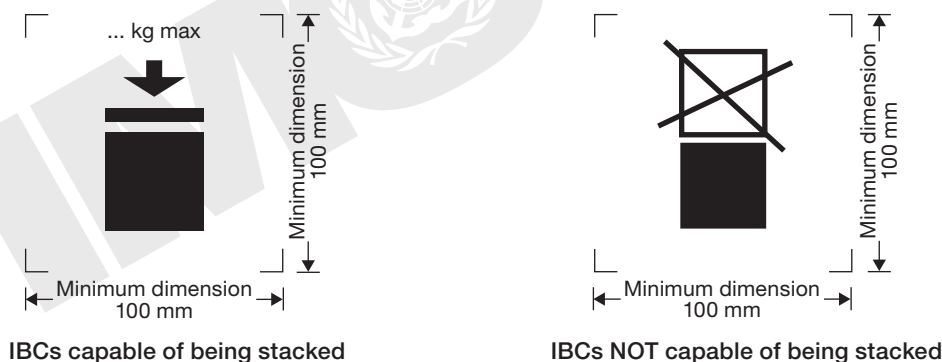
6.5.2.2.1 Each IBC shall bear the marks required in 6.5.2.1 and, in addition, the following information, which may appear on a corrosion-resistant plate permanently attached in a place readily accessible for inspection:

Note: For metal IBCs, this plate shall be a corrosion-resistant metal plate.

Additional marks	Category of IBC				
	Metal	Rigid plastics	Composite	Fibreboard	Wooden
Capacity in litres ^a at 20°C	X	X	X		
Tare mass in kg ^a	X	X	X	X	X
Test (gauge) pressure, in kPa or bar, ^a if applicable		X	X		
Maximum filling/discharge pressure in kPa or bar, ^a if applicable	X	X	X		
Body material and its minimum thickness in mm	X				
Date of last leakproofness test, if applicable (month and year)	X	X	X		
Date of last inspection (month and year)	X	X	X		
Serial number of the manufacturer	X				

^a The unit used shall be indicated.

△ 6.5.2.2.2 The maximum permitted stacking load applicable shall be displayed on a symbol as shown in the figures below. The symbol shall be durable and clearly visible.



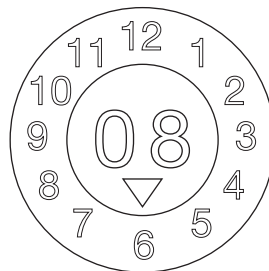
The minimum dimensions shall be 100 mm x 100 mm. The letters and numbers indicating the mass shall be at least 12 mm high. The area within the printer's marks indicated by the dimensional arrows shall be square. Where dimensions are not specified, all features shall be in approximate proportion to those shown. The mass marked above the symbol shall not exceed the load imposed during the design type test (see 6.5.6.6.4) divided by 1.8.

Note: The provisions of 6.5.2.2.2 shall apply to all IBCs manufactured, repaired or remanufactured as from 1 January 2011. The provisions of 6.5.2.2.2 of the IMDG Code (amendment 36-12) may continue to be applied to all IBCs manufactured, repaired or remanufactured between 1 January 2011 and 31 December 2016.

6.5.2.2.3 Each flexible IBC may also bear a pictogram or pictograms indicating the recommended lifting methods.

△ 6.5.2.2.4 Inner receptacles that are of composite IBC design type shall be identified by the application of the marks indicated in 6.5.2.1.1.2, .3, .4 where this date is that of the manufacture of the plastics inner receptacle, .5 and .6. The UN packaging symbol shall not be applied. The marks shall be applied in the sequence shown in 6.5.2.1.1. They shall be durable, legible and placed in a location so as to be readily accessible for inspection after assembling the inner receptacle in the outer casing. When the marks on the inner receptacle are not readily accessible for inspection due to the design of the outer casing, a duplicate of the required marks on the inner receptacle shall be placed on the outer casing preceded by the wording "Inner receptacle". This duplicate shall be durable, legible and placed in a location so as to be readily accessible for inspection.

- △ The date of the manufacture of the plastics inner receptacle may alternatively be marked on the inner receptacle adjacent to the remainder of the marks. In such a case, the date may be waived from the remainder of the marks. An example of an appropriate marking method is:



Note 1: Other methods that provide the minimum required information in a durable, visible and legible form are also acceptable.

Note 2: The date of manufacture of the inner receptacle may be different from the marked date of manufacture (see 6.5.2.1), repair (see 6.5.4.5.3) or remanufacture (see 6.5.2.4) of the composite IBC.

- 6.5.2.2.5 Where a composite IBC is designed in such a manner that the outer packaging is intended to be dismantled for transport when empty (such as for return of the IBC for re-use to the original consignor), each of the parts intended to be detached when so dismantled shall be marked with the month and year of manufacture and the name or symbol of the manufacturer and other identification of the IBC as specified by the competent authority (see 6.5.2.1.1.6).

6.5.2.3 Conformity to design type

The marks indicate that the IBCs correspond to a successfully tested design type and that the provisions referred to in the certificate have been met.

6.5.2.4 Marking of remanufactured composite IBCs (31HZ1)

The marks specified in 6.5.2.1.1 and 6.5.2.2 shall be removed from the original IBC or made permanently illegible and new marks shall be applied to an IBC remanufactured in accordance with these provisions of this Code.

6.5.3 Construction requirements

6.5.3.1 General requirements

- 6.5.3.1.1 IBCs shall be resistant to or adequately protected from deterioration due to the external environment.
- 6.5.3.1.2 IBCs shall be so constructed and closed that none of the contents can escape under normal conditions of transport, including the effects of vibration, or by changes in temperature, humidity or pressure.
- 6.5.3.1.3 IBCs and their closures shall be constructed of materials compatible with their contents, or be protected internally, so that they are not liable:
- .1 to be attacked by the contents so as to make their use dangerous;
 - .2 to cause the contents to react or decompose, or form harmful or dangerous compounds with the IBCs.
- 6.5.3.1.4 Gaskets, where used, shall be made of materials not subject to attack by the contents of an IBC.
- 6.5.3.1.5 All service equipment shall be so positioned or protected as to minimize the risk of escape of the contents owing to damage during handling and transport.
- 6.5.3.1.6 IBCs, their attachments and their service and structural equipment shall be designed to withstand, without loss of contents, the internal pressure of the contents and the stresses of normal handling and transport. IBCs intended for stacking shall be designed for stacking. Any lifting or securing features of IBCs shall be of sufficient strength to withstand the normal conditions of handling and transport without gross distortion or failure and shall be so positioned that no undue stress is caused in any part of the IBC.
- 6.5.3.1.7 Where an IBC consists of a body within a framework, it shall be so constructed that:
- .1 the body does not chafe or rub against the framework so as to cause material damage to the body,
 - .2 the body is retained within the framework at all times,
 - .3 the items of equipment are fixed in such a way that they cannot be damaged if the connections between body and frame allow relative expansion or movement.

6.5.3.1.8 Where a bottom discharge valve is fitted, it shall be capable of being made secure in the closed position and the whole discharge system shall be suitably protected from damage. Valves having lever closures shall be able to be secured against accidental opening and the open or closed position shall be readily apparent. For IBCs containing liquids, a secondary means of sealing the discharge aperture shall also be provided, such as by a blank flange or equivalent device.

6.5.4 Testing, certification and inspection

6.5.4.1 Quality assurance

IBCs shall be manufactured, remanufactured, repaired and tested under a quality assurance programme which satisfies the competent authority, in order to ensure that each manufactured, remanufactured or repaired IBC meets the provisions of this chapter.

Note: ISO 16106:2006, *Packaging – Transport packages for dangerous goods – Dangerous goods packagings, intermediate bulk containers (IBCs) and large packagings – Guidelines for the application of ISO 9001*, provides acceptable guidance on procedures which may be followed.

6.5.4.2 Test provisions

IBCs shall be subjected to design type tests and, if applicable, to initial and periodic inspections and tests in accordance with 6.5.4.4.

6.5.4.3 Certification

In respect of each design type of IBC, a certificate and mark (as in 6.5.2) shall be issued attesting that the design type, including its equipment, meets the test provisions.

6.5.4.4 Inspection and testing

Note: See also 6.5.4.5 for tests and inspections on repaired IBCs.

6.5.4.4.1 Every metal, rigid plastics and composite IBC shall be inspected to the satisfaction of the competent authority:

.1 before it is put into service (including after remanufactured), and thereafter at intervals not exceeding five years, with regard to:

- .1 conformity to the design type, including marks;
- .2 internal and external condition; and
- .3 proper functioning of service equipment.

Thermal insulation, if any, need be removed only to the extent necessary for a proper examination of the body of the IBC.

.2 at intervals of not more than two and a half years with regard to:

- .1 external condition; and
- .2 proper functioning of service equipment.

Thermal insulation, if any, need be removed only to the extent necessary for a proper examination of the body of the IBC.

Each IBC shall correspond in all respects to its design type.

6.5.4.4.2 Every metal, rigid plastics and composite IBC for liquids, or for solids which are filled or discharged under pressure, shall undergo a suitable leakproofness test. This test is part of a quality assurance programme as stipulated in 6.5.4.1 which shows the capability of meeting the appropriate test level indicated in 6.5.6.7.3:

- (a) before it is first used for transport;
- (b) at intervals of not more than two and a half years.

For this test the IBC shall be fitted with the primary bottom closure. The inner receptacle of a composite IBC may be tested without the outer casing, provided the test results are not affected.

6.5.4.4.3 A report of each inspection and test shall be kept by the owner of the IBC at least until the next inspection or test. The report shall include the results of the inspection and test and shall identify the party performing the inspection and test (see also the marking requirements in 6.5.2.2.1).

6.5.4.4.4 The competent authority may at any time require proof, by tests in accordance with this chapter, that the IBCs meet the provisions of the design type tests.

6.5.4.5 Repaired IBCs

- 6.5.4.5.1** When an IBC is impaired as a result of impact (e.g. accident) or any other cause, it shall be repaired or otherwise maintained (see definition of “Routine maintenance of IBCs” in 1.2.1), so as to conform to the design type. The bodies of rigid plastics IBCs and the inner receptacles of composite IBCs that are impaired shall be replaced.
- 6.5.4.5.2** In addition to any other testing and inspection requirements in this Code, an IBC shall be subjected to the full testing and inspection requirements set out in 6.5.4.4, and the required reports shall be prepared, whenever it is repaired.
- 6.5.4.5.3** The party performing the tests and inspections after the repair shall durably mark the IBC near the manufacturer’s UN design type marks to show:
- .1 the State in which the tests and inspections were carried out;
 - .2 the name or authorized symbol of the party performing the tests and inspections; and
 - .3 the date (month, year) of the tests and inspections.
- 6.5.4.5.4** Tests and inspections performed in accordance with 6.5.4.5.2 may be considered to satisfy the requirements for the 2.5- and 5-year periodic tests and inspections.

6.5.5 Specific provisions for IBCs**6.5.5.1 Specific provisions for metal IBCs**

- 6.5.5.1.1** These provisions apply to metal IBCs for the transport of liquids and solids. There are three categories of metal IBCs:
- .1 those for solids which are filled and discharged by gravity (11A, 11B, 11N);
 - .2 those for solids which are filled and discharged at a gauge pressure greater than 10 kPa (21A, 21B, 21N); and
 - .3 those for liquids (31A, 31B, 31N).
- 6.5.5.1.2** Bodies shall be made of suitable ductile metal in which the weldability has been fully demonstrated. Welds shall be skilfully made and afford complete safety. Low-temperature performance shall be taken into account when appropriate.
- 6.5.5.1.3** Care shall be taken to avoid damage by galvanic action due to the juxtaposition of dissimilar metals.
- 6.5.5.1.4** Aluminium IBCs intended for the transport of flammable liquids shall have no movable parts, such as covers, closures, etc., made of unprotected steel liable to rust, which might cause a dangerous reaction by coming into frictional or percussive contact with the aluminium.
- 6.5.5.1.5** Metal IBCs shall be made of metals which meet the following provisions:
- .1 For steel, the elongation at fracture, per cent, shall not be less than $10,000/R_m$ with an absolute minimum of 20%, where R_m = guaranteed minimum tensile strength of the reference steel to be used, in N/mm².
 - .2 For aluminium and aluminium alloys, the elongation at fracture, per cent, shall not be less than $10,000/6R_m$ with an absolute minimum of 8%.

Specimens used to determine the elongation at fracture shall be taken transversely to the direction of rolling and be so secured that:

$$L_o = 5d, \text{ or}$$

$$L_o = 5.65\sqrt{A}$$

where :

L_o = gauge length of the specimen before the test;

d = diameter; and

A = cross-sectional area of the test specimen.

6.5.5.1.6 **Minimum wall thickness**

- Metal IBCs with a capacity of more than 1,500 L shall comply with the following minimum wall thickness requirement:

.1 For a reference steel having a product of $R_m \times A_0 = 10,000$, the wall thickness shall not be less than:

△

Wall thickness (T) in mm			
Types 11A, 11B, 11N		Types 21A, 21B, 21N, 31A, 31B, 31N	
Unprotected	Protected	Unprotected	Protected
$T = C/2,000 + 1.5$	$T = C/2,000 + 1.0$	$T = C/1,000 + 1.0$	$T = C/2,000 + 1.5$

where: A_0 = minimum elongation (as a percentage) of the reference steel to be used on fracture under tensile stress (see 6.5.5.1.5).

C = Capacity in Litres

.2 For metals other than the reference steel described in .1, the minimum wall thickness is given by the following equivalence formula:

$$e_1 = \frac{21.4 \times e_0}{\sqrt[3]{R_{m1} \times A_1}}$$

where:

- e_1 = required equivalent wall thickness of the metal to be used (in mm);
- e_0 = required minimum wall thickness for the reference steel (in mm);
- R_{m1} = guaranteed minimum tensile strength of the metal to be used (in N/mm²) (see .3); and
- A_1 = minimum elongation (as a percentage) of the metal to be used on fracture under tensile stress (see 6.5.5.1.5).

However, in no case shall the wall thickness be less than 1.5 mm.

.3 For purposes of the calculation described in .2, the guaranteed minimum tensile strength of the metal to be used (R_{m1}) shall be the minimum value according to national or international material standards.

However, for austenitic steels, the specified minimum value for R_m according to the material standards may be increased by up to 15% when a greater value is attested in the material inspection certificate. When no material standard exists for the material in question, the value of R_m shall be the minimum value attested in the material inspection certificate.

6.5.5.1.7 **Pressure relief provisions**

IBCs for liquids shall be capable of releasing a sufficient amount of vapour in the event of fire engulfment to ensure that no rupture of the shell will occur. This can be achieved by conventional pressure relief devices or by other constructional means. The start-to-discharge pressure shall not be higher than 65 kPa and no lower than the total gauge pressure experienced in the IBC (i.e. the vapour pressure of the filling substance plus the partial pressure of the air or other inert gases, minus 100 kPa) at 55°C, determined on the basis of a maximum degree of filling as defined in 4.1.1.4. The pressure relief devices shall be fitted in the vapour space.

6.5.5.2 **Specific provisions for flexible IBCs**

6.5.5.2.1 These provisions apply to flexible IBCs of the following types:

- 13H1 woven plastics without coating or liner
- 13H2 woven plastics, coated
- 13H3 woven plastics with liner
- 13H4 woven plastics, coated and with liner
- 13H5 plastics film
- 13L1 textile without coating or liner
- 13L2 textile, coated
- 13L3 textile with liner
- 13L4 textile, coated and with liner
- 13M1 paper, multiwall
- 13M2 paper, multiwall, water-resistant.

Flexible IBCs are intended for the transport of solids only.

6.5.5.2.2 Bodies of IBCs shall be manufactured from suitable materials. The strength of the material and the construction of a flexible IBC shall be appropriate to its capacity and its intended use.



- 6.5.5.2.3 All materials used in the construction of flexible IBCs of types 13M1 and 13M2 shall, after complete immersion in water for not less than 24 hours, retain at least 85% of the tensile strength as measured originally on the material conditioned to equilibrium at 67% relative humidity or less.
- 6.5.5.2.4 Seams of IBCs shall be formed by stitching, heat sealing, gluing or any equivalent method. All stitched seam-ends shall be secured.
- 6.5.5.2.5 Flexible IBCs shall provide adequate resistance to ageing and to degradation caused by ultraviolet radiation, by climatic conditions, or by the substance contained within which would thereby render them unsuitable for their intended use.
- 6.5.5.2.6 For plastics flexible IBCs where protection against ultraviolet radiation is required, it shall be provided by the addition of carbon black or other suitable pigments or inhibitors. These additives shall be compatible with the contents and remain effective throughout the life of the body of the IBC. Where use is made of carbon black, pigments or inhibitors other than those used in the manufacture of the tested design type, retesting may be waived if changes in the carbon black content, the pigment content or the inhibitor content do not adversely affect the physical properties of the material of construction.
- 6.5.5.2.7 Additives may be incorporated into the material of the body to improve the resistance to ageing or to serve other purposes, provided that these do not adversely affect the physical or chemical properties of the material.
- 6.5.5.2.8 No material recovered from used receptacles shall be used in the manufacture of IBC bodies. Production residues or scrap from the same manufacturing process may, however, be used. Component parts such as fittings and pallet bases may also be used provided such components have not in any way been damaged in previous use.
- 6.5.5.2.9 When filled, the ratio of height to width shall be not more than 2:1.
- 6.5.5.2.10 The liner shall be made of a suitable material. The strength of the material used and the construction of the liner shall be appropriate to the capacity of the IBC and the intended use. Joints and closures shall be sift-proof and capable of withstanding pressures and impacts liable to occur under normal conditions of handling and transport.
- 6.5.5.3 **Specific provisions for rigid plastics IBCs**
- 6.5.5.3.1 These provisions apply to rigid plastics IBCs for the transport of solids or liquids. Rigid plastics IBCs are of the following types:
- 11H1 fitted with structural equipment designed to withstand the whole load when IBCs are stacked, for solids which are filled or discharged by gravity
 - 11H2 freestanding, for solids which are filled or discharged by gravity
 - 21H1 fitted with structural equipment designed to withstand the whole load when IBCs are stacked, for solids which are filled or discharged under pressure
 - 21H2 freestanding, for solids which are filled or discharged under pressure
 - 31H1 fitted with structural equipment designed to withstand the whole load when IBCs are stacked, for liquids
 - 31H2 freestanding, for liquids.
- 6.5.5.3.2 The body shall be manufactured from suitable plastics material of known specifications and be of adequate strength in relation to its capacity and to the service it is required to perform. The material shall be adequately resistant to ageing and to degradation caused by the substance contained within or, where relevant, by ultraviolet radiation. Low-temperature performance shall be taken into account when appropriate. Any permeation of the substance contained within shall not constitute a danger under normal conditions of transport.
- 6.5.5.3.3 Where protection against ultraviolet radiation is required, it shall be provided by the addition of carbon black or other suitable pigments or inhibitors. These additives shall be compatible with the contents and remain effective throughout the life of the body of the IBC. Where use is made of carbon black, pigments or inhibitors other than those used in the manufacture of the tested design type, retesting may be waived if changes in the carbon black content, the pigment content or the inhibitor content do not adversely affect the physical properties of the material of construction.
- 6.5.5.3.4 Additives may be incorporated in the material of the body to improve the resistance to ageing or to serve other purposes, provided that these do not adversely affect the physical or chemical properties of the material.
- 6.5.5.3.5 No used material other than production residues or regrind from the same manufacturing process may be used in the manufacturing of rigid plastics IBCs.

6.5.5.4 Specific provisions for composite IBCs with plastics inner receptacles

6.5.5.4.1 These provisions apply to composite IBCs for the transport of solids or liquids of the following types:

- 11HZ1 composite IBCs with a rigid plastics inner receptacle, for solids filled or discharged by gravity
- 11HZ2 composite IBCs with a flexible plastics inner receptacle, for solids filled or discharged by gravity
- 21HZ1 composite IBCs with a rigid plastics inner receptacle, for solids filled or discharged under pressure
- 21HZ2 composite IBCs with a flexible plastics inner receptacle, for solids filled or discharged under pressure
- 31HZ1 composite IBCs with a rigid plastics inner receptacle, for liquids
- 31HZ2 composite IBCs with a flexible plastics inner receptacle, for liquids.

This code shall be completed by replacing the letter 'Z' by a capital letter in accordance with 6.5.1.4.1.2 to indicate the nature of the material used for the outer packaging.

6.5.5.4.2 The inner receptacle is not intended to perform a containment function without its outer packaging. A "rigid" inner receptacle is a receptacle which retains its general shape when empty without closures in place and without the benefit of the outer packaging. Any inner receptacle that is not "rigid" is considered to be "flexible".

6.5.5.4.3 The outer packaging normally consists of rigid material formed so as to protect the inner receptacle from physical damage during handling and transport, but is not intended to perform the containment function. It includes the base pallet where appropriate.

6.5.5.4.4 A composite IBC with a fully enclosing outer packaging shall be so designed that the integrity of the inner receptacle may be readily assessed following the leakproofness and hydraulic tests.

6.5.5.4.5 IBCs of type 31HZ2 shall be limited to a capacity of not more than 1,250 L.

6.5.5.4.6 The inner receptacle shall be manufactured from suitable plastics material of known specifications and be of adequate strength in relation to its capacity and to the service it is required to perform. The material shall be adequately resistant to ageing and to degradation caused by the substance contained and, where relevant, by ultraviolet radiation. Low-temperature performance shall be taken into account when appropriate. Any permeation of the substance contained shall not constitute a danger under normal conditions of transport.

6.5.5.4.7 Where protection against ultraviolet radiation is required, it shall be provided by the addition of carbon black or other suitable pigments or inhibitors. These additives shall be compatible with the contents and remain effective throughout the life of the inner receptacle. Where use is made of carbon black, pigments or inhibitors other than those used in the manufacture of the tested design type, re-testing may be waived if changes in carbon black content, the pigment content or the inhibitor content do not adversely affect the physical properties of the material of construction.

6.5.5.4.8 Additives may be incorporated in the material of the inner receptacle to improve the resistance to ageing or to serve other purposes, provided that these do not adversely affect the physical or chemical properties of the material.

6.5.5.4.9 No used material other than production residues or regrind from the same manufacturing process may be used in the manufacture of inner receptacles.

6.5.5.4.10 The inner receptacle of IBCs of type 31HZ2 shall consist of at least three plies of film.

6.5.5.4.11 The strength of the material and the construction of the outer packaging shall be appropriate to the capacity of the composite IBC and its intended use.

6.5.5.4.12 The outer packaging shall be free of any projection that might damage the inner receptacle.

6.5.5.4.13 Outer packagings of steel or aluminium shall be constructed of a suitable metal of adequate thickness.

6.5.5.4.14 Outer packagings of natural wood shall be of well-seasoned wood, commercially dry and free from defects that would materially lessen the strength of any part of the packaging. The tops and bottoms may be made of water-resistant reconstituted wood such as hardboard, particle board or other suitable type.

6.5.5.4.15 Outer packagings of plywood shall be made of well-seasoned rotary-cut, sliced or sawn veneer plywood, commercially dry and free from defects that would materially lessen the strength of the packaging. All adjacent plies shall be glued with water-resistant adhesive. Other suitable materials may be used in conjunction with plywood for the construction of packagings. Packagings shall be firmly nailed or secured to corner posts or ends or be assembled by equally suitable devices.

6.5.5.4.16 The walls of outer packagings of reconstituted wood shall be made of water-resistant reconstituted wood such as hardboard, particle board or other suitable type. Other parts of the packagings may be made of other suitable material.

- 6.5.5.4.17 For fibreboard outer packagings, strong and good-quality solid or double-faced corrugated fibreboard (single or multiwall) shall be used appropriate to the capacity of the packaging and to its intended use. The water resistance of the outer surface shall be such that the increase in mass, as determined in a test carried out over 30 minutes by the Cobb method of determining water absorption, is not greater than 155 g/m² – see ISO 535:1991. It shall have proper bending qualities. Fibreboard shall be cut, creased without scoring, and slotted so as to permit assembly without cracking, surface breaks or undue bending. The fluting of corrugated fibreboard shall be firmly glued by water-resistant adhesive to the facings.
- 6.5.5.4.18 The ends of fibreboard outer packagings may have a wooden frame or be entirely of wood. Reinforcements of wooden battens may be used.
- 6.5.5.4.19 Manufacturing joins in the fibreboard outer packagings shall be taped, lapped and glued, or lapped and stitched with metal staples. Lapped joins shall have an appropriate overlap. Where closing is effected by gluing or taping, a water-resistant adhesive shall be used.
- 6.5.5.4.20 Where the outer packagings are of plastics material, the relevant provisions of 6.5.5.4.6 to 6.5.5.4.9 shall apply.
- 6.5.5.4.21 The outer packagings of IBCs of type 31HZ2 shall enclose the inner receptacle on all sides.
- 6.5.5.4.22 Any integral pallet base forming part of the IBC or a detachable pallet shall be suitable for mechanical handling with the IBC filled to its maximum permissible gross mass.
- 6.5.5.4.23 The pallet or integral base shall be designed so as to avoid any protrusion of the base of the IBC that might be liable to damage in handling.
- 6.5.5.4.24 The outer packagings shall be secured to a detachable pallet to ensure stability in handling and transport. Where a detachable pallet is used, its top surface shall be free from sharp protrusions that might damage the IBC.
- 6.5.5.4.25 Strengthening devices such as timber supports to increase stacking performance may be used but shall be external to the inner receptacle.
- 6.5.5.4.26 Where IBCs are intended for stacking, the bearing surfaces shall be such as to distribute the load in a safe manner. Such IBCs shall be designed so that the load is not supported by the inner receptacle.
- 6.5.5.5 Specific provisions for fibreboard IBCs**
- 6.5.5.5.1 These provisions apply to fibreboard IBCs for the transport of solids which are filled or discharged by gravity. Fibreboard IBCs are of the following type: 11G.
- 6.5.5.5.2 Fibreboard IBCs shall not incorporate top lifting devices.
- 6.5.5.5.3 The body shall be made of strong and good-quality solid or double-faced corrugated fibreboard (single or multiwall), appropriate to the capacity of the IBC and to its intended use. The water resistance of the outer surface shall be such that the increase in mass, as determined in a test carried out over a period of 30 minutes by the Cobb method of determining water absorption, is not greater than 155 g/m² – see ISO 535:1991. It shall have proper bending qualities. Fibreboard shall be cut, creased without scoring, and slotted so as to permit assembly without cracking, surface breaks or undue bending. The fluting of corrugated fibreboard shall be firmly glued to the facings.
- 6.5.5.5.4 The walls, including top and bottom, shall have a minimum puncture resistance of 15 J, measured according to ISO 3036:1975.
- 6.5.5.5.5 Manufacturing joins in the body of IBCs shall be made with an appropriate overlap and shall be taped, glued, stitched with metal staples or fastened by other means at least equally effective. Where joins are effected by gluing or taping, a water-resistant adhesive shall be used. Metal staples shall pass completely through all pieces to be fastened and be formed or protected so that any inner liner cannot be abraded or punctured by them.
- 6.5.5.5.6 The liner shall be made of suitable material. The strength of the material used and the construction of the liner shall be appropriate to the capacity of the IBC and its intended use. Joins and closures shall be sift-proof and capable of withstanding pressure and impacts liable to occur under normal conditions of handling and transport.
- 6.5.5.5.7 Any integral pallet base forming part of the IBC or any detachable pallet shall be suitable for mechanical handling with the IBC filled to its maximum permissible gross mass.
- 6.5.5.5.8 The pallet or integral base shall be designed so as to avoid any protrusion of the base of the IBC that might be liable to damage in handling.
- 6.5.5.5.9 The body shall be secured to any detachable pallet to ensure stability in handling and transport. Where a detachable pallet is used, its top surface shall be free from sharp protrusions that might damage the IBC.

- 6.5.5.5.10 Strengthening devices such as timber supports to increase stacking performance may be used but shall be external to the liner.
- 6.5.5.5.11 Where IBCs are intended for stacking, the bearing surface shall be such as to distribute the load in a safe manner.
- 6.5.5.6 Specific provisions for wooden IBCs**
- 6.5.5.6.1 These provisions apply to wooden IBCs for the transport of solids which are filled or discharged by gravity. Wooden IBCs are of the following types:
- 11C natural wood with inner liner
 - 11D plywood with inner liner
 - 11F reconstituted wood with inner liner.
- 6.5.5.6.2 Wooden IBCs shall not incorporate top lifting devices.
- 6.5.5.6.3 The strength of the materials used and the method of construction shall be appropriate to the capacity and intended use of the IBC.
- 6.5.5.6.4 Natural wood shall be well seasoned, commercially dry and free from defects that would materially lessen the strength of any part of the IBC. Each part of the IBC shall consist of one piece or be equivalent thereto. Parts are considered equivalent to one piece, when:
- a suitable method of glued assembly, as for instance Lindermann joint, tongue and groove joint, ship lap or rabbet joint is used; or
 - a butt joint with at least two corrugated metal fasteners at each joint is used; or
 - other methods at least equally effective are used.
- 6.5.5.6.5 Bodies of plywood shall be at least three-ply. It shall be made of well-seasoned rotary-cut, sliced or sawn veneer, commercially dry and free from defects that would materially lessen the strength of the body. All adjacent plies shall be glued with water-resistant adhesive. Other suitable materials may be used with plywood for the construction of the body.
- 6.5.5.6.6 Bodies of reconstituted wood shall be made of water-resistant reconstituted wood such as hardboard, particle board or other suitable type.
- 6.5.5.6.7 IBCs shall be firmly nailed or secured to corner posts or ends or be assembled by equally suitable devices.
- 6.5.5.6.8 The liner shall be made of a suitable material. The strength of the material used and the construction of the liner shall be appropriate to the capacity of the IBC and its intended use. Joins and closures shall be sift-proof and capable of withstanding pressure and impacts liable to occur under normal conditions of handling and transport.
- 6.5.5.6.9 Any integral pallet base forming part of the IBC or any detachable pallet shall be suitable for mechanical handling with the IBC filled to its maximum permissible gross mass.
- 6.5.5.6.10 The pallet or integral base shall be designed so as to avoid any protrusion of the base of the IBC that might be liable to damage in handling.
- 6.5.5.6.11 The body shall be secured to any detachable pallet to ensure stability in handling and transport. Where a detachable pallet is used, its top surface shall be free from sharp protrusions that might damage the IBC.
- 6.5.5.6.12 Strengthening devices such as timber supports to increase stacking performance may be used but shall be external to the liner.
- 6.5.5.6.13 Where IBCs are intended for stacking, the bearing surface shall be such as to distribute the load in a safe manner.

6.5.6 Test provisions for IBCs

6.5.6.1 Performance and frequency of tests

- 6.5.6.1.1 Each IBC design type shall successfully pass the tests prescribed in this chapter before being used. An IBC design type is defined by the design, size and material and thickness, manner of construction and means of filling and discharging, but may include various surface treatments; it also includes IBCs which differ from the design type only in their lesser external dimensions.
- 6.5.6.1.2 Tests shall be carried out on IBCs as prepared for transport. IBCs shall be filled as indicated in the relevant section. The substances to be transported in the IBCs may be replaced by other substances except where this would invalidate the results of the tests. For solids, when another substance is used, it shall have the

same physical characteristics (mass, grain size, etc.) as the substance to be transported. It is permissible to use additives, such as bags of lead shot, to achieve the requisite total package gross mass, so long as they are placed so that the test results are not affected.

6.5.6.2 Design type tests

6.5.6.2.1 One IBC of each design type, size, wall thickness and manner of construction shall be submitted to the tests in the order shown in 6.5.6.3.5 and as set out in 6.5.6.4 to 6.5.6.13. These design type tests shall be carried out as required by the competent authority.

6.5.6.2.2 The competent authority may permit the selective testing of IBCs which differ only in minor respects from the tested type, such as with small reductions in external dimensions.

6.5.6.2.3 If detachable pallets are used in the tests, the test report issued in accordance with 6.5.6.14 shall include a technical description of the pallets to be used.

6.5.6.3 Preparation of IBC for testing

6.5.6.3.1 Paper and fibreboard IBCs and composite IBCs with fibreboard outer packagings shall be conditioned for at least 24 hours in an atmosphere having a controlled temperature and relative humidity (r.h.). There are three options, one of which shall be chosen. The preferred atmosphere is $23^{\circ}\text{C}\pm 2^{\circ}\text{C}$ and $50\%\pm 2\%$ r.h. The two other options are $20^{\circ}\text{C}\pm 2^{\circ}\text{C}$ and $65\%\pm 2\%$ r.h. or $27^{\circ}\text{C}\pm 2^{\circ}\text{C}$ and $65\%\pm 2\%$ r.h.

Note: Average values shall fall within these limits. Short-term fluctuations and measurement limitations may cause individual measurements to vary by up to $\pm 5\%$ relative humidity without significant impairment of test reproducibility.

6.5.6.3.2 Additional steps shall be taken to ascertain that the plastics material used in the manufacture of rigid plastics IBCs of types 31H1 and 31H2 and composite IBCs of type 31HZ1 and 31HZ2 complies with the provisions of 6.5.5.3.2 to 6.5.5.3.4 and 6.5.5.4.6 to 6.5.5.4.9.

6.5.6.3.3 This may be done, for example, by submitting sample IBCs to a preliminary test extending over a long period, for example six months, during which the samples would remain filled with the substances they are intended to contain or with substances which are known to have at least as severe a stress-cracking, weakening or molecular degradation influence on the plastics materials in question, and after which the samples shall be submitted to the applicable tests listed in the table in 6.5.6.3.5.

6.5.6.3.4 Where the behaviour of the plastics material has been established by other means, the above compatibility test may be dispensed with.

6.5.6.3.5 Design type tests required in sequential order:

Type of IBC	Vibration ^f	Bottom lift	Top lift ^a	Stacking ^b	Leak-proofness	Hydraulic pressure	Drop	Tear	Topple	Righting ^c
Metal:										
11A, 11B, 11N	–	1st ^a	2nd	3rd	–	–	4th ^e	–	–	–
21A, 21B, 21N	–	1st ^a	2nd	3rd	4th	5th	6th ^e	–	–	–
31A, 31B, 31N	1st	2nd ^a	3rd	4th	5th	6th	7th ^e	–	–	–
Flexible^d	–	–	x ^c	x	–	–	x	x	x	x
Rigid plastics:										
11H1, 11H2	–	1st ^a	2nd	3rd	–	–	4th	–	–	–
21H1, 21H2	–	1st ^a	2nd	3rd	4th	5th	6th	–	–	–
31H1, 31H2	1st	2nd ^a	3rd	4th	5th	6th	7th	–	–	–
Composite:										
11HZ1, 11HZ2	–	1st ^a	2nd	3rd	–	–	4th ^e	–	–	–
21HZ1, 21HZ2	–	1st ^a	2nd	3rd	4th	5th	6th ^e	–	–	–
31HZ1, 31HZ2	1st	2nd ^a	3rd	4th	5th	6th	7th ^e	–	–	–
Fibreboard	–	1st	–	2nd	–	–	3rd	–	–	–
Wooden	–	1st	–	2nd	–	–	3rd	–	–	–

^a When IBCs are designed for this method of handling.

^b When IBCs are designed to be stacked.

^c When IBCs are designed to be lifted from the top or the side.

^d Required test indicated by “x”; an IBC which has passed one test may be used for other tests, in any order.

^e Another IBC of the same design may be used for the drop test.

^f Another IBC of the same design may be used for the vibration test.

6.5.6.4 Bottom lift test

6.5.6.4.1 *Applicability*

For all fibreboard and wooden IBCs and for all types of IBCs which are fitted with means for lifting from the base, as a design type test.

6.5.6.4.2 *Preparation of the IBC for test*

The IBC shall be filled. A load shall be added and evenly distributed. The mass of filled IBC and the load shall be 1.25 times its maximum permissible gross mass.

6.5.6.4.3 *Method of testing*

The IBC shall be raised and lowered twice by a forklift truck with the forks centrally positioned so that the space between them is three quarters of the length of the side of entry (unless the points of entry are fixed). The forks shall penetrate to three quarters of the depth in the direction of entry. The test shall be repeated from each possible direction of entry.

6.5.6.4.4 *Criteria for passing the test*

No permanent deformation which renders the IBC, including the base pallet, if any, unsafe for transport and no loss of contents.

6.5.6.5 Top lift test

6.5.6.5.1 *Applicability*

For all types of IBCs which are designed to be lifted from the top, and for flexible IBCs designed to be lifted from the top or the side, as a design type test.

6.5.6.5.2 *Preparation of the IBC for test*

Metal, rigid plastics and composite IBCs shall be filled. A load shall be added and evenly distributed. The mass of filled IBC and the load shall be twice the maximum permissible gross mass. Flexible IBCs shall be filled with a representative material and then shall be loaded to six times their maximum permissible gross mass, the load being evenly distributed.

6.5.6.5.3 *Method of testing*

Metal and flexible IBCs shall be lifted in the manner for which they are designed until clear of the floor and maintained in that position for a period of five minutes.

Rigid plastics and composite IBCs shall be lifted:

- .1 by each pair of diagonally opposite lifting devices, so that the hoisting forces are applied vertically, for a period of five minutes; and
- .2 by each pair of diagonally opposite lifting devices, so that the hoisting forces are applied towards the centre at 45° to the vertical, for a period of five minutes.

6.5.6.5.4 Other methods of top-lift testing and preparation at least equally effective may be used for flexible IBCs.

6.5.6.5.5 *Criteria for passing the test*

- .1 Metal, rigid plastics and composite IBCs: the IBC remains safe for normal conditions of transport, there is no observable permanent deformation of the IBC, including the base pallet, if any, and no loss of contents.
- .2 Flexible IBCs: no damage to the IBC or its lifting devices which renders the IBC unsafe for transport or handling and no loss of contents.

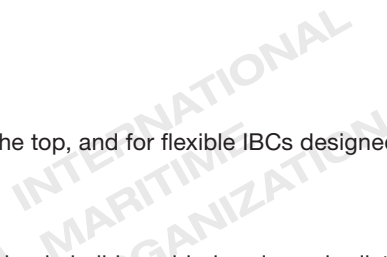
6.5.6.6 Stacking test

6.5.6.6.1 *Applicability*

For all types of IBCs which are designed to be stacked on each other, as a design type test.

6.5.6.6.2 *Preparation of the IBC for test*

The IBC shall be filled to its maximum permissible gross mass. If the specific gravity of the product being used for testing makes this impracticable, the IBC shall additionally be loaded so that it is tested at its maximum permissible gross mass, the load being evenly distributed.



6.5.6.6.3 Method of testing

- .1 The IBC shall be placed on its base on level hard ground and subjected to a uniformly distributed superimposed test load (see 6.5.6.6.4). IBCs shall be subjected to the test load for a period of at least:
 - 5 minutes, for metal IBCs;
 - 28 days at 40°C, for rigid plastics IBCs of types 11H2, 21H2 and 31H2 and for composite IBCs with outer packagings of plastics material which bear the stacking load (i.e. types 11HH1, 11HH2, 21HH1, 21HH2, 31HH1 and 31HH2);
 - 24 hours, for all other types of IBCs.
- .2 The load shall be applied by one of the following methods:
 - one or more IBCs of the same type, filled to the maximum permissible gross mass, stacked on the test IBC;
 - appropriate mass loaded on to either a flat plate or a reproduction of the base of the IBC, which is stacked on the test IBC.

6.5.6.6.4 Calculation of superimposed test load

The load to be placed on the IBC shall be 1.8 times the combined maximum permissible gross mass of the number of similar IBCs that may be stacked on top of the IBC during transport.

6.5.6.6.5 Criteria for passing the test

- .1 All types of IBCs other than flexible IBCs: no permanent deformation which renders the IBC, including the base pallet, if any, unsafe for transport and no loss of contents.
- .2 Flexible IBCs: no deterioration of the body which renders the IBC unsafe for transport and no loss of contents.

6.5.6.7 Leakproofness test**6.5.6.7.1 Applicability**

For those types of IBCs used for liquids, or for solids filled or discharged under pressure, as a design type test and a periodic test.

6.5.6.7.2 Preparation of the IBC for test

The test shall be carried out before the fitting of any thermal insulation equipment. Vented closures shall either be replaced by similar non-vented closures or the vent shall be sealed.

6.5.6.7.3 Method of testing and pressure to be applied

The test shall be carried out for a period of at least 10 minutes, using air at a gauge pressure of not less than 20 kPa (0.2 bar). The airtightness of the IBC shall be determined by a suitable method such as air-pressure differential test or by immersing the IBC in water, or for metal IBCs, by coating the seams and joints with a soap solution. In the latter case, a correction factor shall be applied for the hydrostatic pressure.

6.5.6.7.4 Criterion for passing the test

No leakage of air.

6.5.6.8 Hydraulic pressure test**6.5.6.8.1 Applicability**

For those types of IBCs used for liquids or for solids filled or discharged under pressure, as a design type test.

6.5.6.8.2 Preparation of the IBC for test

The test shall be carried out before the fitting of any thermal insulation equipment. Pressure relief devices shall be removed and their apertures plugged, or shall be rendered inoperative.

6.5.6.8.3 Method of testing

The test shall be carried out for a period of at least ten minutes, applying a hydraulic pressure of not less than that indicated in 6.5.6.8.4. The IBC shall not be mechanically restrained during the test.

6.5.6.8.4 Pressures to be applied

6.5.6.8.4.1 Metal IBCs:

- .1 For IBCs of types 21A, 21B and 21N, for packing group I solids, a 250 kPa (2.5 bar) gauge pressure;
- .2 For IBCs of types 21A, 21B, 21N, 31A, 31B and 31N, for packing groups II or III substances, a 200 kPa (2 bar) gauge pressure;
- .3 In addition, for IBCs of types 31A, 31B and 31N, a 65 kPa (0.65 bar) gauge pressure. This test shall be performed before the 200 kPa (2 bar) test.

6.5.6.8.4.2 Rigid plastics and composite IBCs:

- .1 For IBCs of types 21H1, 21H2, 21HZ1 and 21HZ2: 75 kPa (0.75 bar) gauge;
- .2 For IBCs of types 31H1, 31H2, 31HZ1 and 31HZ2: whichever is the greater of two values, the first as determined by one of the following methods:
 - the total gauge pressure measured in the IBC (i.e. the vapour pressure of the filling substance and the partial pressure of the air or other inert gases, minus 100 kPa) at 55°C multiplied by a safety factor of 1.5; this total gauge pressure shall be determined on the basis of a maximum degree of filling in accordance with 4.1.1.4 and a filling temperature of 15°C; or
 - 1.75 times the vapour pressure at 50°C of the substance to be transported minus 100 kPa, but with a minimum test pressure of 100 kPa; or
 - 1.5 times the vapour pressure at 55°C of the substance to be transported minus 100 kPa, but with a minimum test pressure of 100 kPa;and the second as determined by the following method:
 - twice the static pressure of the substance to be transported, with a minimum of twice the static pressure of water.

6.5.6.8.5 Criteria for passing the test(s)

- .1 For IBCs of types 21A, 21B, 21N, 31A, 31B and 31N, when subjected to the test pressure specified in 6.5.6.8.4.1.1 or .2: no leakage;
- .2 For IBCs of types 31A, 31B and 31N, when subjected to the test pressure specified in 6.5.6.8.4.1.3: neither permanent deformation which would render the IBC unsafe for transport nor leakage; and
- .3 For rigid plastics and composite IBCs: no permanent deformation which would render the IBC unsafe for transport and no leakage.

6.5.6.9 Drop test

6.5.6.9.1 Applicability

For all types of IBCs, as a design type test.

6.5.6.9.2 Preparation of the IBC for test

- .1 Metal IBCs: the IBC shall be filled to not less than 95% of its maximum capacity for solids or 98% of its maximum capacity for liquids. Pressure relief devices shall be rendered inoperative or shall be removed and their apertures sealed.
- .2 Flexible IBCs: the IBC shall be filled to the maximum permissible gross mass, the contents being evenly distributed.
- .3 Rigid plastics and composite IBCs: the IBC shall be filled to not less than 95% of its maximum capacity for solids or 98% of its maximum capacity for liquids. Arrangements provided for pressure relief may be removed and sealed or rendered inoperative. Testing of IBCs shall be carried out when the temperature of the test sample and its contents has been reduced to –18°C or lower. Where test samples of composite IBCs are prepared in this way, the conditioning specified in 6.5.6.3.1 may be waived. Test liquids shall be kept in the liquid state, if necessary by the addition of anti-freeze. This conditioning may be disregarded if the materials in question are of sufficient ductility and tensile strength at low temperatures.
- .4 Fibreboard and wooden IBCs: the IBC shall be filled to not less than 95% of its maximum capacity.

6.5.6.9.3 Method of testing

The IBC shall be dropped on its base onto a non-resilient, horizontal, flat, massive and rigid surface in conformity with the requirements of 6.1.5.3.4, in such a manner as to ensure that the point of impact is that part of the base of the IBC considered to be the most vulnerable. IBCs of 0.45 m³ or less capacity shall also be dropped:

- .1 Metal IBCs: on the most vulnerable part other than the part of the base of the IBC tested in the first drop;
- .2 Flexible IBCs: on the most vulnerable side;

.3 Rigid plastics, composite, fibreboard and wooden IBCs: flat on a side, flat on the top and on a corner.

The same IBC or a different IBC of the same design may be used for each drop.

6.5.6.9.4 Drop height

For solids and liquids, if the test is performed with the solid or liquid to be transported or with another substance having essentially the same physical characteristics:

Packing group I	Packing group II	Packing group III
1.8 m	1.2 m	0.8 m

For liquids, if the test is performed with water:

(a) where the substances to be transported have a relative density not exceeding 1.2:

Packing group II	Packing group III
1.2 m	0.8 m

(b) where the substances to be transported have a relative density exceeding 1.2, the drop heights shall be calculated on the basis of the relative density (d) of the substance to be transported rounded up to the first decimal as follows:

Packing group II	Packing group III
$d \times 1.0$ m	$d \times 0.67$ m

6.5.6.9.5 Criteria for passing the test(s)

- .1 Metal IBCs: no loss of contents.
- .2 Flexible IBCs: no loss of contents. A slight discharge, such as from closures or stitch holes, upon impact shall not be considered to be a failure of the IBC provided that no further leakage occurs after the IBC has been raised clear of the ground.
- .3 Rigid plastics, composite, fibreboard and wooden IBCs: no loss of contents. A slight discharge from a closure upon impact shall not be considered to be a failure of the IBC provided that no further leakage occurs.
- .4 All IBCs: no damage which renders the IBC unsafe to be transported for salvage or for disposal, and no loss of contents. In addition, the IBC shall be capable of being lifted by an appropriate means until clear of the floor for five minutes.

Note: The criterion in 6.5.6.9.5.4 applies to design types for IBCs manufactured as from 1 January 2011.

6.5.6.10 Tear test

6.5.6.10.1 Applicability

For all types of flexible IBCs, as a design type test.

6.5.6.10.2 Preparation of the IBC for test

The IBC shall be filled to not less than 95% of its capacity and to its maximum permissible gross mass, the contents being evenly distributed.

6.5.6.10.3 Method of testing

Once the IBC is placed on the ground, a 100 mm knife score, completely penetrating the wall of a wide face, is made at a 45° angle to the principal axis of the IBC, halfway between the bottom surface and the top level of the contents. The IBC shall then be subjected to a uniformly distributed superimposed load equivalent to twice the maximum permissible gross mass. The load shall be applied for at least five minutes. An IBC which is designed to be lifted from the top or the side shall then, after removal of the superimposed load, be lifted until it is clear of the floor and maintained in that position for a period of five minutes.

6.5.6.10.4 Criterion for passing the test

The cut shall not propagate more than 25% of its original length.

6.5.6.11 **Topple test**

6.5.6.11.1 **Applicability**

For all types of flexible IBCs, as a design type test.

6.5.6.11.2 **Preparation of the IBC for test**

The IBC shall be filled to not less than 95% of its capacity and to its maximum permissible gross mass, the contents being evenly distributed.

6.5.6.11.3 **Method of testing**

The IBC shall be caused to topple onto any part of its top onto a rigid, non-resilient, smooth, flat and horizontal surface.

6.5.6.11.4 **Topple height**

Packing group I	Packing group II	Packing group III
1.8 m	1.2 m	0.8 m

6.5.6.11.5 **Criterion for passing the test**

No loss of contents. A slight discharge, such as from closures or stitch holes, upon impact shall not be considered to be a failure of the IBC provided that no further leakage occurs.

6.5.6.12 **Righting test**

6.5.6.12.1 **Applicability**

For all flexible IBCs designed to be lifted from the top or side, as a design type test.

6.5.6.12.2 **Preparation of the IBC for test**

The IBC shall be filled to not less than 95% of its capacity and its maximum permissible gross mass, the contents being evenly distributed.

6.5.6.12.3 **Method of testing**

The IBC, lying on its side, shall be lifted at a speed of 0.1 m/s to an upright position, clear of the floor, by one lifting device or by two lifting devices when four are provided.

6.5.6.12.4 **Criterion for passing the test**

No damage to the IBC or its lifting devices which renders the IBC unsafe for transport or handling.

6.5.6.13 **Vibration test**

6.5.6.13.1 **Applicability**

For all IBCs used for liquids, as a design type test.

Note: This test applies to design types for IBCs manufactured as from 1 January 2011.

6.5.6.13.2 **Preparation of the IBC for test**

A sample IBC shall be selected at random and shall be fitted and closed as for transport. The IBC shall be filled with water to not less than 98% of its maximum capacity.

6.5.6.13.3 **Test method and duration**

6.5.6.13.3.1 The IBC shall be placed in the centre of the test machine platform with a vertical sinusoidal, double amplitude (peak-to-peak displacement) of 25 mm ± 5%. If necessary, restraining devices shall be attached to the platform to prevent the specimen from moving horizontally off the platform without restricting vertical movement.

6.5.6.13.3.2 The test shall be conducted for one hour at a frequency that causes part of the base of the IBC to be momentarily raised from the vibrating platform for part of each cycle to such a degree that a metal shim can be completely inserted intermittently at, at least, one point between the base of the IBC and the test platform. The frequency may need to be adjusted after the initial set point to prevent the packaging from going into

resonance. Nevertheless, the test frequency shall continue to allow placement of the metal shim under the IBC as described in this paragraph. The continuing ability to insert the metal shim is essential to passing the test. The metal shim used for this test shall be at least 1.6 mm thick, 50 mm wide, and be of sufficient length to be inserted between the IBC and the test platform a minimum of 100 mm to perform the test.

6.5.6.13.4 Criteria for passing the test

No leakage or rupture shall be observed. In addition, no breakage or failure of structural components, such as broken welds or failed fastenings, shall be observed.

6.5.6.14 Test report

6.5.6.14.1 A test report containing at least the following particulars shall be drawn up and shall be available to the users of the IBC:

- .1 name and address of the test facility;
- .2 name and address of applicant (where appropriate);
- .3 a unique test report identification;
- .4 date of the test report;
- .5 manufacturer of the IBC;
- .6 description of the IBC design type (such as dimensions, materials, closures, thickness, etc.), including method of manufacture (such as blow-moulding), and which may include drawing(s) and/or photograph(s);
- .7 maximum capacity;
- .8 characteristics of test contents, such as viscosity and relative density for liquids and particle size for solids. For rigid plastics and composite IBCs subject to the hydraulic pressure test in 6.5.6.8, the temperature of the water used;
- .9 test descriptions and results; and
- .10 signature, with the name and status of the signatory.

6.5.6.14.2 The test report shall contain statements that the IBC, prepared as for transport, was tested in accordance with the appropriate provisions of this chapter and that the use of other packaging methods or components may render it invalid. A copy of the test report shall be available to the competent authority.