Checking the Net Contents

of Packaged Goods

*as adopted by the 104th National Conference on Weights and Measures 2019*

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This publication is available free of charge from:

<https://doi.org/10.6028/NIST.HB.133-2020>

**November 2019**



**U.S. Department of Commerce**

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**National Institute of Standards and Technology**

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| NIST Handbook | 133 |

2020 Edition

Supersedes NIST Handbook 133, 2019 Edition

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National Institute of Standards and Technology Handbook 133, 2020 Edition Natl. Inst. Stand. Technol. Handb. 133, 2020 Ed. 272 Pages (Nov. 2019)

CODEN: NIHAE2

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| Foreword |

This handbook has been prepared as a procedural guide for the compliance testing of net content statements on packaged goods. Compliance testing of packaged goods is the determination of the conformance of the- results of the packaging, distribution, and retailing process (the packages) to specific legal requirements for net content declarations. This handbook has been developed primarily for the use of government officials. However, it should also be useful to commercial and industrial establishments in the areas of packaging, distribution, and sale of commodities.

In conducting compliance testing, the conversion of quantity values from one measurement system to another (e.g., from the metric system to the avoirdupois system) should be handled with careful regard to the implied correspondence between the accuracy of the data and the number of digits displayed. In all conversions, the number of significant digits retained should ensure that accuracy is neither sacrificed nor exaggerated. For this 2020 edition of NIST Handbook 133 all dimensions for test procedures, devices, or environments have been rounded to two significant digits (e.g., 2.5 cm to 1.0 in) or to a precision level applicable to the test equipment (e.g., 200 kPa for 25 psi and 35 MPa for 5,000 psi).

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| **Acronym** | **Term** | **Acronym** | **Term** |
| --- | --- | --- | --- |
| AAP | Average Adjusted Purge | HB 133 | NIST Handbook 133, “Checking the Net Contents of Packaged Goods” |
| AOSA | Association of Official Seed Analysts | HB 44 | NIST Handbook 44, “Specifications, Tolerances, and Other Technical Requirements for Weighing and Measuring Devices” |
| ASTM | ASTM International | MAV | Maximum Allowable Variation |
| CFR | Code of Federal Regulations | NCWM | National Conference on Weights and Measures |
| CGA | Compressed Gas Association | NIST | National Institute of Standards and Technology |
| EPA | Environmental Protection Agency | PSEL | Purge Sample Error Limit |
| FDA | Food and Drug Administration | SCF | Sample Correction Factor |
| FDCA | Food, Drug, and Cosmetic Act | SEL | Sample Error Limit |
| FPLA | Fair Packaging and Labeling Act | TTB | Alcohol and Tobacco Tax and Trade Bureau |
| FSIS | USDA, Food Safety and Inspection Service | UPLR | Uniform Packaging and Labeling Regulation |
| FTC | Federal Trade Commission | USDA | U.S. Department of Agriculture |
| HB 130 | NIST Handbook 130, “Uniform Laws and Regulations in the areas of Legal Metrology and Fuel Quality” |  | |

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| 2019 Amendments |

The following table indicates the items amended by the 104th (2019) National Conference on Weights and Measures (NCWM). As appropriate, the text on the cited pages indicates the changes to a Handbook 133 section, or paragraph as “Added 2019” or “Amended 2019.” Unless otherwise noted, the effective date of the regulations added or amended in 2019 is January 1, 2020.

| **Chapter** | **L&R Committee Item No.** | **Section** | **Action** | **Page** |
| --- | --- | --- | --- | --- |
| Chapter 3. Test Procedures – For Packages Labeled by Volume | NET-4 | 3.4. Volumetric Test Procedures for Viscous Fluids - Headspace | Amended | 50 |
| NET-5 | 3.7. Volumetric Test Procedure for Paint, Varnish, and Lacquers – Non-Aerosol | Amended | 55 |
| Chapter 4. Test Procedures – Packages Labeled by Count, Linear Measure, Area, Thickness, and Combinations of Quantities | NET-6 | 4.8. Procedure for Checking the Area Measurement of Chamois | Amended | 132 |
| NET-7 | 4.11. Softwood Lumber | Added | 143 |
| NET-8 | 4.10. Structural Plywood and Wood-Based Structural Panels | Added | 137 |

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| 2019 Editorial Changes |

The following items were deemed editorial in nature based on the following criteria: 1) the modified text did not change the meaning or procedure outlined, 2) modified text corrected an omission or clarified how the text was written, or 3) the item itself was reformatted and relocated in the text to make the organization of the content more meaningful.

**Note:**  For the purposes of this table, the **bold, underscored** text indicates new language added and **bold, ~~strikeout~~** text indicates deleted text.

| **Chapter** | **Section** | **Action** | **Page** |
| --- | --- | --- | --- |
| Introduction | A. Source | Updated URL and E-mail | 1 |
| C. Amendments | Updated URL’s | 1 |
| H. The International System of Units | Updated acronym for General Conference on Weights and Measures (**~~GIPM~~ CGPM**) | 2 |
| Chapter 1. General Information | 1.3. Sampling Plans | Clarified the instruction to read acceptable lots a **~~97~~95** % probability of passing. | 9 |
| Chapter 2. Test Procedures – Packages Labeled by Weight | 2.2.5. Other Test Equipment Requirements | 1. Mass Standards – Use NIST Handbook 105-1, “Specifications and Tolerances for **~~Reference Standards and~~** Field Standard Weights **~~and Measures – Field Standard Weights (NIST Class F)”~~** ~~(~~**~~1990)~~ (2019)** | 17 |
| Chapter 3. Test Procedures – For Packages Labeled by Volume | Table 3-1 | Added acronym to title. Code of Federal Regulation **(CFR**) Reference\* | 46 |
| Table 3-8. Test Measures for Animal Bedding | Corrected title: Rectangular and Square Test Measures | 101 |
| Table 3-9. Illustrations of Depth Determinations with Cylindrical Test Measures | (its internal radius is 151**.77515** mm and its height is 610 mm) | 106 |
| The volume was calculated using:  *Volume in liters* = *(πr2h* ***Pi****) 3.14159265****(Pi)***× *23035.69 mm* × *130.12 mm* = *9.41 L\** | 106 |
| 3.15.3. Evaluation of the Test Results and Determination of Pass or Fail | 2. If the Average Error is a negative value go to Step **~~4~~3**. on the Inspection Worksheet. | 113 |
| Chapter 4. Test Procedures – Packages Labeled by Count, Linear Measure, Area, Thickness, and Combinations of Quantities | 4.9. Procedure for Checking the contents of Specific Agriculture Seed Packages Labeled by Count | **~~4.2.3.~~** **4.9.3.** Evaluation of Results | 137 |
| Appendix C. Model Inspection Report Forms | Measurement Grid and Package Error Worksheet  for Cylindrical and Square or Rectangular Test Measures | Editorial change:  C. Average Depth (Sum of Measurements ÷ **~~26~~9**): | 185 |
| Appendix E. General Tables of Units of Measurement | Footnote 9 and 10 | Added notice regarding deprecation of U.S. survey foot. | 219 and 221 |
| Appendix F. Glossary | Sample Correction Factor | The factor as computed is the ratio of the **~~97.5~~** **95th** quantile of the student’s t distribution (one-sided) with (n 1) degrees of freedom and the square root of n where n is the sample size. | 240 |
| Sample Error Limit (SEL) | The SEL value allows for the uncertainty between the average error of the sample and the average error of the inspection lot with an approximately **~~97.5~~ 95** % level of confidence. | 240 |

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| Introduction |

1. Source.

The information and procedures in this handbook comprise all of those adopted by the National Conference on Weights and Measures, Inc. (NCWM). Contact NCWM at:

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The NCWM is supported by the National Institute of Standards and Technology (NIST), which provides its Executive Secretary and publishes its documents. NIST also develops technical publications for use by weights and measures agencies; these publications may subsequently be endorsed or adopted by the NCWM or its members.

This handbook is recommended by NCWM for adoption by states when reviewing or amending their official laws and regulations on testing the net contents of packaged goods. A similar recommendation is made with regard to the local jurisdictions within a state in the absence of the promulgation of such laws and regulations at the state level.

(Amended 2019)

1. Purpose.

This handbook has been prepared as a procedural guide for the compliance testing of net content statements on packaged goods. Compliance testing of packaged goods is the determination of the conformance of the results of the packaging, distribution, and retailing process (the packages) to specific legal requirements for net content declarations. This handbook has been developed primarily for the use of government officials. However, commercial and industrial establishments packaging, distributing, and selling commodities will find this handbook useful.

In conducting compliance testing, the conversion of quantity values from one measurement system to another (e.g., from the metric system to the U.S. customary system) should be handled with careful regard to the implied correspondence between the accuracy of the data and the number of digits displayed. In all conversions, the number of significant digits retained should ensure that accuracy is neither sacrificed nor exaggerated. For this 2020 edition of NIST Handbook 133, “Checking the Net Content of Packaged Goods” all dimensions for test procedures, devices, or environments have been rounded to two significant digits (e.g., 2.5 cm to 1.0 in) or to a precision level applicable to the test equipment (e.g., 200 kPa for 25 psi and 35 MPa for 5000 psi).

1. Amendments

Amendments to NIST Handbook 133 are deliberated and developed by NCWM’s Committee on Laws and Regulations before presentation to the general membership for a vote. In some instances, amendments that significantly affect other NIST Handbooks may be processed jointly by two or more committees.

Amendments to the handbooks are made in accordance with NCWM procedures and policies. The process begins at the regional weights and measures association meetings in the fall of each year and is culminated at the NCWM Annual Meeting in July. After passing through one or more of the regional associations, the proposed amendment is placed on the agenda of the appropriate NCWM committee for consideration at the NCWM’s Interim Meeting in January. After final deliberation and development by the committee, the amendment may be presented to the membership for a vote at the NCWM Annual Meeting in July. The NCWM policy provides for exceptions to the process to accommodate urgent or priority items. NIST staff provides technical assistance and advice throughout the process.

The policy is available on the NCWM website at [**www.ncwm.com**](http://www.ncwm.com/). For information on the regional weights and measures associations, visit[**www.ncwm.com/other-links**](https://www.ncwm.com/other-links).

1. Revisions to the Handbook

NIST publishes a new edition of this handbook after significant changes are made. If NIST determines that amendments made by NCWM were minor or editorial in nature an annual publication will not be published. Instead, NIST will issue a notice that the current edition is still valid and will publish a list of the changes on the NIST website.

1. Annotation

Beginning in 1971, amendments or additions to sections in the handbook are annotated at the end of each section (e.g., “Amended 1982”) as a service to those states that are planning to update their own laws or regulations. The references to each revision and the year will enable government officials and industry members to trace the rationale for the changes by referring to the “Report of the XXX National Conference on Weights and Measures (also known as the NCWM Annual Report) for the year indicated and make decisions regarding adoptions and amendments to their laws and regulations.

1. Effective Enforcement Dates of Regulations

Unless otherwise specified, new or amended sections are intended to become effective and subject to enforcement on January 1 of the year following adoption by NCWM.

1. Section References

In most references made to specific sections or subsections in this handbook, the word “Section” followed by the section number is used.

1. The International System of Units

The “International System of Units,” “SI,” or “SI Units” means the modernized metric system as established in 1960 by the General Conference on Weights and Measures (CGPM). In 1988, Congress amended the Metric Conversion Act of 1975 (see Section 5164 of Public Law 100-418) to declare that it is the policy of the United States to designate the metric system of measurement as the preferred measurement system for U.S. trade and commerce, and it further defined “the metric system of measurement” to be the International System as established by the CGPM and as interpreted or modified for the United States by the Secretary of Commerce. (see Metric Conversion Law 15 U.S.C. 205; NIST Special Publication (SP) 330, “The International System of Units (SI); NIST SP 814, “Guide for the Use of the International System of Units (SI); Interpretation of the International System of Units [the Metric System of Measurement] for the United States in the “Federal Register” of May 16, 2008, [“Federal Register” Vol. 73, No. 96] or subsequent revisions). In 1992, Congress amended the Federal Fair Packaging and Labeling Act (FPLA) to require certain consumer commodities to include the appropriate SI units along with the customary inch-pound units in their quantity statements.

(Amended 2019)

I. “Mass” and “Weight.” [***NOTE 1***, page 3]

The mass of an object is a measure of the object’s inertial property or the amount of matter it contains. The weight of an object is a measure of the force exerted on the object by gravity or the force needed to support it. The pull of gravity on the earth gives an object a downward acceleration of about 9.8 m/s2. In trade and commerce and everyday use, the term “weight” is often used as a synonym for “mass.” The “net mass” or “net weight” declared on a label indicates that the package contains a specific amount of commodity exclusive of wrapping materials. The use of the term “mass” is predominant throughout the world and is becoming increasingly common in the United States.

J. Use of the Terms “Mass” and “Weight.” [***NOTE 1***, page 3]

When used in this handbook, the term “weight” means “mass.” The term “weight” appears when U.S. customary units are cited or when both inch-pound and SI units are included in a requirement. The terms “mass” or “masses” are used when only SI units are cited in a requirement. The following note appears where the term “weight” is first used in a law or regulation.

***NOTE 1:*** *When used in this law (or regulation), the term “weight” means “mass.” (see paragraphs I. “Mass” and Weight and J. Use of the Terms “Mass” and “Weight” in the Introduction section of NIST Handbook 133 for an explanation of these terms.)*

(Introduction added 2015)

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# General Information

## Scope

The procedures in this handbook are recommended for use to verify the net quantity of contents of packages kept, offered, or exposed for sale, or sold by weight, measure (including volume, and dimensions), or count at any location (e.g., at the point-of-pack, in storage warehouses, retail stores, and wholesale outlets).

### When and Where to Use Package Checking Procedures

An effective program will typically include testing at each of the following levels.

1. Point-of-Pack

Testing packages at the “point-of-pack” has an immediate impact on the packaging process. Usually, a large number of packages of a single product are available for testing at one place. This allows the inspector to verify that the packer is following current good packaging practices. Inspection at the point-of-pack also provides the opportunity to educate the packer about the legal requirements that products must meet, and may permit resolution of any net content issues or other problems that arise during the testing. Point-of-pack testing is not always possible because packing locations can be in other states or countries. Work with other state, county, and city jurisdictions to encourage point-of-pack inspection on products manufactured in their geographic jurisdictions. Point-of-pack inspections cannot entirely replace testing at wholesale or retail outlets, because this type of inspection does not include imported products or the possible effects of product distribution and moisture loss. Point-of-pack inspections only examine the manufacturing process. Therefore, an effective testing program will also include testing at wholesale and retail outlets.

1. Wholesale

Testing packages at a distribution warehouse is an alternative to testing at the point-of-pack with respect to being able to test large quantities of, and a variety of products. Wholesale testing is a very good way to monitor products imported from other countries and to follow up on products suspected of being under filled or underweight based on consumer complaints or findings made during other inspections, including those done at retail outlets.

1. Retail

Testing packages at retail outlets evaluates the soundness of the manufacturing, distributing, and retailing processes of the widest variety of goods at a single location. It is acceptable and practical for weights and measures jurisdictions to monitor packaging procedures and to detect present or potential problems. Generally, retail package testing is not conducive to checking large quantities of individual products of any single production lot. Therefore, follow-up inspections of a particular brand or lot code number at a number of retail and wholesale outlets, and ultimately at the point-of-pack are extremely important aspects in any package-checking scheme. After the evaluation of an inspection lot is completed, the jurisdiction should consider what, if any, further investigation or follow-up is warranted. At the point-of-sale, a large number of processes may affect the quality or quantity of the product. Therefore, there may be many reasons for any inspection lot being out of compliance. A shortage in weight or measure may result from mishandling the product in the store or the retailer’s failure to rotate stock. Shortages may also be caused through mishandling by a distributor or failure of some part of the packaging process. Shortages may also be caused by moisture loss (desiccation) if the product is packaged in permeable media. Therefore, being able to determine the cause of an error in order to correct defects is more difficult when retail testing is used.

(Amended 2010)

### Selecting a Product for Testing

Any commodity sold by weight, measure, or count may be tested. The product to be tested may be chosen in several ways. The decision may be based on different factors, such as (1) marketplace surveys (e.g., jurisdiction-wide surveys of all soft drinks or breads), (2) surveys based on sales volume, or (3) audit testing (see Section 1.3. “Sampling Plans”) to cover as large a product variety as possible at food, farm, drug, hardware stores, or specialty outlets, discount and department stores. Follow-up of possible problems detected in audit testing or in review of past performance tends to concentrate inspection resources on particular commodity types, brand names, retail or wholesale locations, or even particular neighborhoods. The expected benefits for the public must be balanced against the cost of testing. Expensive products should be tested because of their cost per unit. However, inexpensive items should also be tested because the overall cost to individual purchasers may be considerable over an extended period of time. Store packaged items, which are usually perishable and not subject to other official monitoring, should be routinely tested because they are offered for sale where they are packed. Products on sale and special products produced for local consumption should not be overlooked because these items sell quickly in large amounts.

Regardless of where the test occurs, remember that it is the inspector’s presence in the marketplace through routine unannounced testing that ensures equity and fair competition in the manufacturing and distribution process. Finally, always follow-up on testing to ensure that the problems are corrected; otherwise, the initial testing may be ineffective.

## Package Requirements

The net quantity of content statement must be “accurate,” but reasonable variations are permitted. Variations in package contents may be a result of deviations in filling. The limits for acceptable variations are based on current good manufacturing practices in the weighing, measuring, and packaging process. The first requirement is that accuracy is applied to the average net contents of the packages in the lot. The second requirement is applied to negative errors in individual packages. These requirements apply simultaneously to the inspection of all lots of packages except as specified in Section 1.2.5. “Exceptions to the Average and Individual Package Requirements.”



### Inspection Lot

An “inspection lot” (called a “lot” in this handbook) is defined as a collection of identically labeled (except for quantity or identity in the case of random packages) packages available for inspection at one time. The inspection lot will pass or fail as a whole based on the results of tests on a sample drawn from the lot in accordance with Section 1.3. “Sampling Plans” and Section 2.3.4. “Random Sample Selection.” This handbook describes procedures to determine if the packages in an “inspection lot” contain the declared net quantity of contents and if the individual packages’ variations are within acceptable limits.

(Amended 2017)

### Average Requirement

In general, the average net quantity of contents of packages in a lot must at least equal the net quantity of contents declared on the label. Plus or minus variations from the declared net weight, measure, or count are permitted when they are caused by unavoidable variations in weighing, measuring, or counting the contents of individual packages that occur in current good manufacturing practice. Such variations must not be permitted to the extent that the average of the quantities in the packages of a particular commodity or a lot of the commodity that is kept, offered, exposed for sale, or sold, is below the stated quantity. (See Section 3.6. “Pressed and Blown Glass Tumblers and Stemware” and Section 4.2.1. “Packages Labeled with 50 Items or Fewer” for exceptions to this requirement.)

(Refer to Section 1.4.1. Net Quantity of Contents Requirements for Pesticides Labeled with Minimum Net Quantity of Contents Declarations.)

(Amended 2018)

### Individual Package Requirement

The variation of individual package contents from the labeled quantity must not be “unreasonably large.” In this handbook, packages that are under filled by more than the Maximum Allowable Variation (MAV) specified for the package are considered unreasonable errors. Unreasonable shortages are not generally permitted, even when overages in other packages in the same lot, shipment, or delivery compensate for such shortage. This handbook does not specify limits of overfilling (with the exception of textiles), which is usually controlled by the packer for economic, compliance, and other reasons.

(Amended 2010)

### Maximum Allowable Variation

The limit of the “reasonable minus variation” for an under filled package is called a “Maximum Allowable Variation” (MAV). An MAV is a deviation from the labeled weight, measure, or count of an individual package beyond which the deficiency is considered an unreasonable minus error. Each sampling plan limits the number of negative package errors permitted to be greater than the MAV.

(Amended 2010)

### Exceptions to the Average and Individual Package Requirements

There is an exemption from the average requirement for packages labeled by count with 50 items or fewer. The reason for this exemption is that the package count does not follow a “normal” distribution even if the package is designed to hold the maximum count indicated by the label declaration (e.g., egg cartons and packages of chewing gum). Another exception permits an “allowable difference” in the capacity of glass tumblers and stemware because the capacities of glass molds do not follow a normal distribution.

### Deviations Caused by Moisture Loss or Gain

Deviations from the net quantity of contents caused by the loss or gain of moisture from the package are permitted when they are caused by ordinary and customary exposure to conditions that normally occur in good distribution practice and that unavoidably result in change of weight or measure. According to regulations adopted by the U.S. Environmental Protection Agency, no moisture loss is recognized on pesticides. (see Code of Federal Regulations [**40 CFR 156.10**](https://www.govinfo.gov/app/details/CFR-2009-title40-vol23/CFR-2009-title40-vol23-sec156-10).)



#### Applying a Moisture Allowance

Some packaged products may lose or gain moisture and, therefore, lose or gain weight or volume after packaging. The amount of moisture loss depends upon the nature of the product, the packaging material, the length of time it is in distribution, environmental conditions, and other factors. Moisture loss may occur even when manufacturers follow good distribution practices. Loss of weight “due to exposure” may include solvent evaporation, not just loss of water. For loss or gain of moisture, the moisture allowances may be applied before or after the package errors are determined.

To apply an allowance before determining package errors, adjust the Nominal Gross Weight (see Section 2.3.6. “Determine Nominal Gross Weight and Package Errors”), so the package errors are increased by an amount equal to the moisture allowance. This approach is used to account for moisture loss in both the average and individual package errors.

It is also permissible to apply the moisture allowances after individual package errors and average errors are determined.

**Example:**

*A sample of a product that could be subject to moisture loss might fail because the average error is minus or the error in several of the sample packages are found to be unreasonable errors (i.e., the package error is greater than the Maximum Allowable Variation (MAV) permitted for the package’s labeled quantity).*

You may apply a moisture allowance after determining the package errors by adding the allowance to the Sample Error Limit (SEL) and then, comparing the average error to the SEL to determine compliance. The moisture allowance must be added to the MAV before evaluating sample errors to identify unreasonable minus errors**.**

(Amended 2010)

This handbook provides “moisture allowances” for some meat and poultry products, flour, pasta, and dry pet food. (see Chapter 2, Table 2-3. “Moisture Allowances”) These allowances are based on the premise that when the average net weight of a sample is found to be less than the labeled weight, but not by an amount that exceeds the allowable limit, either the lot is declared to be within the moisture allowance or more information must be collected before deciding lot compliance or noncompliance.

Test procedures for flour, some meat, and poultry are based on the concept of a “moisture allowance” also known as a “gray area” or “no decision” area (see Section 2.3.8. “Moisture Allowances”). When the average net weight of a sample is found to be less than the labeled weight, but not more than the boundary of the “gray area,” the lot is said to be in the “gray” or “no decision” area. The gray area is not a tolerance. More information must be collected before lot compliance or noncompliance can be decided. Appropriate enforcement should be taken on packages found short weight and outside of the “moisture allowance” or “gray area.”

(Amended 2002)

## Sampling Plans

This handbook contains two sampling plans used to inspect packages: “Category A” and “Category B.” Use the “Category B” Sampling Plans to test meat and poultry products at point-of-pack locations that are subject to U.S. Department of Agriculture Food Safety and Inspection Service (FSIS) requirements. When testing all other packages, use the “Category A” Sampling Plan.

Inspections by weights and measures officials must provide the public with the greatest benefit at the lowest possible cost. Sampling reduces the time to inspect a lot of packages, so a greater number of items can be inspected. Net content inspection, using sampling plans for marketplace surveillance, protects consumers who cannot verify the net quantity of contents of the package they purchase. This ensures fair trade practices and maintains a competitive marketplace. It also encourages manufacturers, distributors, and retailers to follow good manufacturing and distribution practices.

Testing a “sample” of packages from a lot instead of every package is efficient, but the test results have a “sampling variability” that must be corrected before determining if the lot passes or fails. The “Category A” sampling plans give acceptable lots a 95 % probability of passing. An “acceptable” lot is defined as one in which the “average” net quantity of contents of the packages equals or exceeds the labeled quantity. The “Category B” sampling plans give acceptable lots at least a 50 % probability of passing. The sampling plans used in this handbook are statistically valid. That means the test acceptance criteria are statistically adjusted, so they are both valid and legally defensible. This handbook does not discuss the statistical basis, risk factors, or provide the operating characteristic curves for the sampling plans. For information on these subjects, see explanations on “acceptance sampling” in statistical reference books.

A randomly selected sample is necessary to ensure statistical validity and reliable data. This is accomplished by using random numbers to determine which packages are chosen for inspection. Improper collection of sample packages can lead to bias and unreliable results.



### Audit Tests

Audits may be used to speed the process of detecting possible net content violations. These audit procedures may include:

• using smaller sample sizes;

• using tare lists provided by manufacturers to spot check; or

• selecting samples without collecting a random sample.

These audit procedures allow spot checking of more products than is possible with the more structured techniques, but do not take the place of “Category A” or “Category B” testing.

Do not take enforcement action using audit test results. If, after an audit test, there is suspicion that the package lot is not in compliance, use the appropriate “Category A” or “Category B” sampling plan to determine if the lot complies with the package requirements.

## Other Regulatory Agencies Responsible for Package Regulations and Applicable Requirements

In the United States, several federal agencies issue regulations regarding package labeling and net contents. The U.S. Department of Agriculture (USDA) regulates meat and poultry. The Food and Drug Administration (FDA) regulates food, drugs, cosmetic products, tobacco, and medical devices under the Food, Drug, and Cosmetic Act (FDCA) and the Fair Packaging and Labeling Act (FPLA). The Federal Trade Commission (FTC) regulates most non-food consumer packaged products as part of the agency’s responsibility under the FPLA. The Environmental Protection Agency (EPA) regulates pesticides. The Alcohol and Tobacco Tax and Trade Bureau (TTB) in the U.S. Department of the Treasury promulgates regulations for beer, wine, and distilled spirits as part of its responsibility under the Federal Alcohol Administration Act.

Packaged goods produced for distribution and sale also come under the jurisdiction of state and local weights and measures agencies that adopt their own legal requirements for packaged goods. Federal statutes set requirements that pre-empt state and local regulations that are or may be less stringent or not identical to federal regulation depending on the federal law that authorizes the federal regulation. The application of Handbook 133 procedures occurs in the context of the concurrent jurisdiction among federal, state, and local authorities. Therefore, all agencies using this handbook should keep abreast of the revisions to federal agency regulations that may contain sampling or testing information not in the regulations at the time of publication of this handbook. (See Appendix A, Table 1‑1. “Agencies Responsible for Package Regulations and Applicable Requirements” for information on the responsible agencies for package regulations.) The requirements of this handbook must be used when testing products concurrently subject to federal regulations.



### Net Quantity of Contents Requirements for Pesticides Labeled with Minimum Net Quantity of Contents Declarations

The Environmental Protection Agency (EPA) permits packers of pesticides the option of declaring the net quantity of contents using either the average or the minimum package fill systems. If the manufacturer uses the minimum system, the term “minimum” must appear adjacent to the quantity declaration. If the packer uses the average system, the procedures in Section 2.3.7. “Evaluate for Compliance” are used to determine compliance. Use the procedures in Section 2.3. “Basic Test Procedure for Gravimetric Testing of Net Weight” to select and test a sample and use the following compliance procedure to determine if the sample passes or fails the minimum package fill requirements.

Compliance Requirements for Packaged Pesticides (e.g., antimicrobial wipes, insect repellent wipes, towelettes, liquid or dry products)

* 1. The net weight or measure of quantity shall be exclusive of wrappers or other materials and shall be the average quantity unless there is an explicit statement on the Principal Display Panel (PDP) in conjunction with the quantity declaration that the package was filled under the minimum system of fill [e.g., minimum weight 500 g (1 lb 1 oz).]
  2. A Maximum Allowable Variation (MAV) is not applied.
  3. Variation above minimum content is permissible only to the extent that it represents deviation unavoidable in good manufacturing practice.
  4. Variation below the declared minimum quantity is NOT permitted.
  5. Compliance Procedure and Requirements**:**

1. After the samples are tested, the individual package errors are determined. The average error is not calculated.
2. Review the individual package errors:

* If a minus package error is found, the sample fails.
* If no minus package errors are found, the sample passes (e.g., the errors are 0 or plus)

(Added 2018)

## Assistance in Testing Operations

If the storage, display, or location of any lot of packages requires special equipment or an abnormal amount of labor for inspection, the owner or the operator of the business must supply the equipment and/or labor as required by the weights and measures official.

## Health and Safety

This handbook cannot address all of the health and safety issues associated with its use. The inspector is responsible for determining the appropriate safety and health practices and procedures before starting an inspection (e.g., contact the establishment’s health and safety official). Comply with all handling, health, and safety warnings on package labels and those contained in any associated Safety Data Sheets (SDS). The inspector must also comply with federal, state, and local health and safety laws, and other appropriate requirements in effect at the time and location of the inspection. Contact your supervisor to obtain information regarding your agency’s health and safety policies and to obtain appropriate safety equipment.

## Good Measurement Practices

The procedures in this handbook are designed to be technically sound and represent good measurement practices. To assist in documenting tests, we have included “model” inspection report forms designed to record the information.



### Traceability Requirements for Measurement Standards and Test Equipment

Each test procedure presented in this handbook includes a list of the equipment needed to perform the inspection. The scales and other measurement standards used (e.g., balances, mass standards, volumetric, and linear measures) to conduct any test must be traceable to the International System of Units (SI), usually through the National Institute of Standards and Technology (NIST). Standards must be used in the manner for which they were designed and calibrated.

### Certification Requirements for Standards and Test Equipment

All measurement standards and test equipment identified in this handbook or associated with the test procedures must be calibrated or standardized before initial use. This must be done according to the calibration procedures and other instructions found on NIST’s Laboratory Metrology and Calibration Procedures website at [**www.nist.gov/pml/weights-and-measures/laboratory-metrology/calibration-procedures**](http://www.nist.gov/pml/weights-and-measures/laboratory-metrology/calibration-procedures) or using other recognized procedures (e.g., those adopted for use by a state weights and measures laboratory). After initial certification, the standards must be routinely recertified according to your agency’s measurement assurance policies.

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# Test Procedures for Packages Labeled by Weight – Gravimetric Testing



## Scope

The gravimetric test method uses weight measurement to determine the net quantity of contents of packaged goods. This chapter includes general test methods to determine the net quantity of contents of packages labeled in terms of weight. Gravimetric testing is the preferred method of testing most products because it reduces destructive testing and improves measurement accuracy.

## Measurement Standards and Test Equipment

### Scale Requirements

Use a scale (for this handbook the term “scale” includes balances) that has at least 100 scale divisions. It must have a load-receiving element of sufficient size and capacity to hold the packages during weighing. It also requires a scale division no larger than 1/6 of the Maximum Allowable Variation (MAV) for the package size being weighed. The MAV/6 requirement ensures that the scale has adequate resolution to determine the net contents of the packages. Subsequent references to product test results requiring the agreement to within one scale division are based on scale divisions that are equal to or only slightly smaller than the MAV/6. (see Appendix A, Table 2‑5. “Maximum Allowable Variations (MAVs) for Packages Labeled by Weight.”)

**Example:**

*The MAV for packages labeled with a net weight 113 g (0.25 lb) is 7.2 g (0.016 lb). Divide (*÷*) the MAV by 6 to obtain the maximum scale division that can be used to determine the gross, tare and net weights for a package size.*

*7.2 g (0.016) ÷ 6 = 1.2 g (0.002 lb)*

*In this example, a 1 g (0.002 lb) scale division would be the maximum scale division appropriate for weighing these packages.*

(Amended 2010)

### Scale Accuracy

Verify the accuracy of a scale before each initial daily use, each use at a new location, or when there is any indication of abnormal equipment performance (e.g., erratic indications). Recheck the scale accuracy if it is found that the sample does not pass, so there can be confidence that the test equipment is not at fault.

Scales used to check packages must meet the acceptance tolerances specified for their accuracy class in the current edition of NIST Handbook 44 (HB 44) “Specifications, Tolerances, and Other Technical Requirements for Weighing and Measuring Devices.” The tolerances for Class II and Class III scales are presented in NIST HB 44, Section 2.20. Scales, “T.N. Tolerances Applicable to Devices Marked I, II, III, III L, and IIII.”

**Note:** If the package checking scale is not marked with a “class” designation, use Table 2‑1. “Class of Scale” to determine the applicable tolerance.

Always use good weighing and measuring practices. For example, be sure to use weighing and measuring equipment according to the manufacturer’s instructions and make sure the environment is suitable. Place scales and other measuring equipment (e.g., flasks and volumetric measures) on a rigid support and maintain them in a level condition if being level is required to ensure accuracy.

### Scale Tolerance

Follow this procedure to determine the scale tolerance:

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
|  | | | | | |
| 1. Determine the total number of divisions (i.e., the minimum increment or graduation indicated by the scale) of the scale by dividing the scale’s capacity by the minimum division. | | | | | |
|  | | | | | |
| **Example:**  *A scale with a capacity of 5000 g and a minimum division of 0.1 g has 50 000 divisions.*  *5000* ÷ *0.1 g* = *50 000 division* | | | | | |
|  | | | | | |
| 1. From Table 2-1. “Class of Scale”, determine the class of the scale using the minimum scale division and the maximum number of scale divisions.   **Example:**  *On a scale with a minimum division of 0.1 g and 50 000 total scale divisions the appropriate class is “II.”* | | | | | |
|  | | | | | |
| **Note:** If a scale is used where the number of scale divisions is between 5001 and 10 000 and the division size is 0.1 g or greater and is not marked with an accuracy Class II marking, Class III scale tolerances apply. | | | | | |
|  | | | | | |
| 1. Determine the number of divisions for any test load by dividing the value of the mass standard being applied by the minimum division indicated by the scale. | | | | |
|  | | | | |
| 1. Determine the tolerance from Table 2‑2. “Acceptance Tolerances for Class of Scale Based on Test Load in Divisions” in divisions appropriate for the test load and class of scale | | | | | |
|  | | | | | |
| **Example:**  *If the scale has a minimum division of 0.1 g and a 1500 g mass standard is applied, the test load is equal to 15 000 divisions (1500/0.1). On a Class II scale with a test load between 5001 and 20 000 divisions, Table 2‑2. “Acceptance Tolerances for Class of Scale Based on Test Load in Divisions” indicates the tolerance is plus or minus one division.* | | | | | |
| **Table 2-1.**  **Class of Scale** | | | | |
| **Value of Scale Division1** | | **Minimum and Maximum Number of Divisions** | | **Class of Scale** |
| **Minimum** | **Maximum** |
| 1 mg to 0.05 g | | 100 | 100 000 | II |
| 0.1 g or more | | 5000 | 100 000 | II |
| 0.1 g to 2 g  0.000 2 lb to 0.005 lb  0.005 oz to 0.125 oz | | 100 | 10 000 | III |
| 5 g or more  0.01 lb or more  0.25 oz or more | | 500 | 10 000 | III |
| 1On some scales, manufacturers designated and marked the scale with a verification division (e) for testing purposes (e = 1 g and d = 0.1 g). For scales marked Class II, the verification division is larger than the minimum displayed division. The minimum displayed division must be differentiated from the verification scale division by an auxiliary reading means such as a vernier, rider, or at least a significant digit that is differentiated by size, shape, or color. Where the verification division is less than or equal to the minimum division, use the verification division instead of the minimum division. Where scales are made for use with mass standards (e.g., an equal arm balance without graduations on the indicator), the smallest mass standard used for the measurement is the minimum division. | | | | |

|  |  |  |
| --- | --- | --- |
| **Table 2‑2.**  **Acceptance Tolerances for Class of Scale Based on Test Load in Divisions** | | |
| **Test Load in Divisions** | | **Tolerance** |
| **Class II Scale** | **Class III Scale** |
| 0 to 5000 | 0 to 500 | Plus or Minus 0.5 Division |
| 5001 to 20 000 | 501 to 2000 | Plus or Minus 1.0 Division |
| 20 001 or more | 2001 to 4000 | Plus or Minus 1.5 Divisions |
| Not Applicable | 4001 or more | Plus or Minus 2.5 Divisions |

### Scale Verification

Use the following procedures to verify the scale. These procedures, which are based on those required in NIST Handbook 44, have been modified to reduce the amount of time required for testing scales in field situations.

Do not use a scale if it has an error that exceeds the specified tolerance in Table 2-2. “Acceptance Tolerances for Class of Scale Based on Test Load in Divisions” in any of the performance tests described in the following section.

#### Increasing-Load Test

Use certified mass standards to conduct an “increasing-load test” with all test loads centered on the load-receiving element. Start the test with the device on zero and progress with increasing test loads to a “maximum test load” of at least 10 % more than the gross weight of the packages to be tested. Use at least three different test loads of approximately equal value to test the device up to the “maximum test load.” Verify the accuracy of the device at each test load. Include the package tare weight as one of the test points.

#### Decreasing-Load Test

For all types of scales, other than one with a beam indicator or equal-arm balance, conduct a “decreasing-load test” with all test loads centered on the load-receiving element. Use the same test loads used in the “increasing-load test” of this section, and start at the “maximum test load.” Remove the test loads in the reverse order of the increasing-load test until all test loads are removed. Verify the accuracy of the scale at each test load.

#### Shift Test

When conducting a Shift Test on Bench Scales or Balances, use a test load equal to one-third of the “maximum test load” used for the “increasing-load test.” For bench scales (see Figure 2-1. “Bench Scales or Balances”) apply the test load as nearly as possible at the center of each quadrant of the load receiving element as shown in Figure 2-1. “Bench Scale or Balances.”

For Equal-Arm Balances, use a test load equal to one-half capacity centered successively at four points positioned equidistance between the center and the front, left, back, and right edges of each pan as shown (see Figure 2-2. “Equal-Arm Balance”). For example, where the load-receiving element is a rectangular or circular shape, place the test load in the center of the area represented by the shaded area.

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| |  |  |  |  |  |  |  |  | | --- | --- | --- | --- | --- | --- | --- | --- | |  |  | | |  |  |  |  | |  | |  | |  | |  | Position 1 |  | Position 2 |  | |  | |  | |  | |  | |  | |  |  |  | |  | |  | |  |  | | |  |  |  |  | |  | |  | |  | Position 4 |  | Position 3 |  | |  | |  | |  | |  | |  | |  | | | |  |  | |  | |  | |  | | **Graphic of Balance Scale** |

**Figure 2-1. Bench Scales or Balances Figure 2-2. Equal-Arm Balance**

(Amended 2010)

#### Return to Zero

Conduct the return to zero test whenever all the test weights from the scale are removed; check to ensure that it returns to a zero indication.

### Other Test Equipment Requirements

Specifications, tolerances, and other technical requirements for the other measurement standards and test equipment cited in this handbook are specified in the following NIST publications. These publications may be obtained from the Office of Weights and Measures ([**www.nist.gov/pml/weights-and-measures/publications/nist-handbooks/other-nist-handbooks/other-nist-handbooks-2**](http://www.nist.gov/pml/weights-and-measures/publications/nist-handbooks/other-nist-handbooks/other-nist-handbooks-2)).

1. Mass Standards – Use NIST Handbook 105‑1, “Specifications and Tolerances for Field Standard Weights” (2019)
2. Volumetric Flasks and Cylinders – Use NIST Handbook 105‑2, “Specifications and Tolerances for Reference Standards and Field Standard Weights and Measures – Field Standard Measuring Flasks” (1996)
3. Stopwatches – Use NIST Handbook 105‑5, “Specifications and Tolerances for Reference Standards and Field Standard Weights and Measures – Field Standard Stopwatches” (1997)
4. Thermometers – Use NIST Handbook 105‑6, “Specifications and Tolerances for Reference Standards and Field Standard Weights and Measures – Specifications and Tolerances for Thermometers” (1997)

## Basic Test Procedure for Gravimetric Testing of Net Weight

The following steps apply when gravimetrically testing any type of packaged product except borax and glazed or frozen foods. If the tested products contain borax, refer to Section 2.4. “Borax.” If encased-in-ice or ice glazed food is tested, refer to Section 2.6. “Determining the Net Weight of Encased-in-Ice and Ice Glazed Products.”

|  |
| --- |
| * Identify and define the inspection lot. |
|  |
| * Select the sampling plan. * Record inspection data using an official inspection report. |
|  |
| * Select the random sample. * Select and determine tare. |
|  |
| * Determine nominal gross weight and package errors. |
|  |
| * Evaluate compliance with the Maximum Allowable Variation (MAV) requirement and the average requirement. |
|  |
| Each step will be described in more detail in the following sections. |

### Define the Inspection Lot

The official defines which packages are to be tested and the size of the inspection lot. The lot may be smaller or larger than the production lot defined by the packer. Only take action on the packages contained in the lot that has been defined.

Lots may be made up of either standard or random weight packages. Standard packages are those with identical net content declarations such as containers of soda in 2 L bottles and 2.26 kg (5 lb) packages of flour. “Random packages” are those with differing or no fixed pattern of weight, such as packages of meat, poultry, fish, or cheese.

**Notes:**

1. Normally, there will never be access to the entire “production lot” from a manufacturer. The “inspection lot” is selected from packages that are available for inspection/test at any location in the distribution chain.
2. When packages are tested in retail stores, it is not necessary to sort by lot code. If lot codes are mixed during retail testing, be sure to record the lot codes for all of the packages included in the sample so that the inspector and other interested parties can follow up on the information. For special reasons, such as a large number of packages or the prior history of problems with the product or store, the inspector may choose to define a lot as only one type of packaged product (e.g., ground beef). Another reason to narrowly define the lot is if the results of an audit test indicate the possibility of a shortage in one particular lot code within a particular product.

**Example:**

*An inspection lot should consist of all of the cans of a single brand of peach halves, labeled with a net quantity of 453 g (1 lb).*

### Select Sampling Plans

This handbook contains two sampling plans used to inspect packages: “Category A” and “Category B.” Use the “Category B” Sampling Plans to test meat and poultry products at point-of-pack locations that are subject to U.S. Department of Agriculture (USDA) Food Safety and Inspection Service (FSIS) requirements. When testing all other packages, use the “Category A” Sampling Plan.

Use Appendix A, Table 2‑1. “Sampling Plans for Category A,” to conduct “Category A” inspections.

Use Appendix A, Table 2‑2. “Sampling Plans for Category B,” to conduct “Category B” inspections.

### Record Inspection Data

Use an official inspection report to record information. Attach additional worksheets, test notes, and other information as needed. This handbook provides random and standard packaged products model inspection report forms in Appendix C, “Model Inspection Report Forms.” (Refer to Appendix C for instructions on how to complete the forms’ box numbers.) Modify the model reports and the box numbers to meet your agency’s needs. Other formats that contain more or less information may be acceptable. The procedure below describes how to record inspection data using the “Model Inspection Report Forms” in Appendix C. The same information should be recorded regardless of the form used.

**Note:** Inspection reports should be legible and complete. Good recordkeeping practices typically include record retention for a specified period of time.

#### Procedure for Recording Data

|  |
| --- |
| 1. Record the product identity, packaging description, lot code, location of test, and other pertinent data. |
|  |
| 1. Record the labeled net quantity of contents in Box 1. Record both metric and U.S. customary declarations if they are provided on the package label. |
|  |
| **Example:**  *If the labeled weight is 453 g (1 lb), record this in Box 1.* |
| **Note:** When the declaration of net quantity on the package includes both the International System of Units (SI) (metric) and U.S. customary units, the larger of the two declarations must be verified. The rounding rules in NIST Handbook 130, “Uniform Packaging and Labeling Regulations” permit packers to round declarations up or down based on their knowledge of their package filling targets and the accuracy of packaging equipment. |
| 1. Determine the larger of the values by converting the SI declaration to U.S. customary units, or vice versa, using conversion factors that are accurate to at least six places. Compare the values, and use the larger value in computing the nominal gross weight (see later steps). Indicate on the report which of the declarations is being verified when packages labeled with two units of measure are encountered. |
|  |
| **Example:**  *If the net weight declared on a package is 1 lb, the metric equivalent (accurate to six significant digits) is 453.592 g. Do not round down or truncate values in the calculations until the nominal gross weight is determined and recorded. If the package is labeled 454 g, then the metric declaration is larger than the U.S. customary declaration and should be used to verify the net contents of the package.*   1. Record the unit of measure in Box 2. The unit of measure is the minimum division of the unit of measurement used to conduct the test. If a scale is used that reads to thousandths of a pound, the unit of measure is 0.001 lb even if the scale division is 0.002 lb or 0.005 lb. |
|  |
| **Examples:**  *If the scale has a scale division of 0.5 g, the unit of measure is 0.1 g. If a weighed package that has an error of “*−*0.5 g,” record the error as “*−*5” using “dimensionless units.”*  −*0.5 g* ÷ *0.1* = *5 dimensionless units*  *If the scale indicates in increments of 0.002 lb, the unit of measure is 0.001 lb. If a weighed package has an error of “*+*0.016,” record the error as “*+*16” using “dimensionless units.”*  *0.016 lb* ÷ *0.001* = *16 dimensionless units*  **Notes:**   1. When using dimensionless units, multiply package errors by the unit of measure to obtain the package error in weight. 2. The Basic Test Procedure does not prohibit the use of units of weight instead of dimensionless units when recording package errors, nor does it prohibit the use of software programs to determine product compliance. Refer to Appendix F. “Glossary,” for the definition of dimensionless units. |
|  |
| 1. Enter the appropriate MAV value in Box 3 for the type of package (weight, volume, etc.), the labeled net contents, and the unit of measure using Appendix A. Tables 2-5 through 2-10. |
|  | |
| 1. Determine the MAV in dimensionless units and record in Box 4 on the Standard Package Report Form (a dimensionless unit is obtained by dividing the MAV recorded in Box 3 by the unit of measure recorded in Box 2). | |
|  | |
| 1. Determine how many minus package errors are permitted to exceed the MAV, (errors known as unreasonable minus errors [UMEs]), see Column 4 in either Table 2‑1. “Sampling Plans for Category A” or Table 2‑2. “Sampling Plans for Category B” (refer to Appendix A). Record this number in Box 8. | |

### Random Sample Selection

It is important to select a random sample when conducting an official package inspection. Follow the steps below to select your sample. If the sample packages for the sample are not randomly selected, the test results may not be statistically valid.

|  |
| --- |
| 1. Count the number of packages comprising the inspection lot or estimate the size to within 5 % and record the inspection lot size in Box 5. |
|  |
| 1. Determine sample size using Appendix A, Table 2-1, “Sampling Plans for Category A” or Table 2‑2, “Sampling Plans for Category B.” In Column 1, find the size of the inspection lot (the number recorded in Box 5 of the report form). Read across from Column 1 to find the appropriate sample size in Column 2 and record this number in Box 6 of the report form. |
|  |
| 1. Randomly select a sample from the inspection lot. Random number tables (see Appendix B. “Random Number Tables”) or a calculator that is able to generate random numbers may be used to identify the sample. |

**Note:** If the inspector and the party that is ultimately responsible for the packing and declaration of net weight for the product agree to an alternative method of sample selection, document how the sample packages were selected as part of the inspection record.

### Procedures for Determining Tare

There are three types of tare for the inspection of packaged goods. The tare weight may vary considerably from package to package as compared with the variability of the package net contents, even for packages in the same production lot. The basic test procedure in this handbook considers the variation for all tare materials.

1. Used Dry Tare

Used Dry Tare is used tare material that has been air dried, or dried in some manner to simulate the unused tare weight. It includes all packaging materials that can be separated from the packaged product, either readily (e.g., by shaking) or by washing, scraping, ambient air drying, or other techniques involving more than “normal” household recovery procedures, but not including laboratory procedures like oven drying. Labels, wire closures, staples, prizes, decorations, and such are considered tare. Used Dry Tare is available regardless of where the packages are tested. The net content verification procedures described in this handbook reference Used Dry Tare.

**Note:** When testing frozen foods with Used Dry Tare, the frost found inside frozen food packages is included as part of the net contents, except in instances in which glazed or frozen foods are tested according to Section 2.6. “Net Weight of Encased-in-Ice and Ice Glazed Products.”

1. Unused Dry Tare

Unused Dry Tare is all unused packaging materials (including glue, labels, ties, etc.) that contain or enclose a product. It includes prizes, gifts, coupons, or decorations that are not part of the product. If testing packages in retail store locations where they are packaged, and sold in small quantities to the ultimate consumers, the basic test procedure may be modified by using samples of the packaging material available in the store.

1. Wet Tare

Wet Tare is used tare material where no effort is made to dry the tare material. Free-flowing liquids are considered part of the tare weight.

Wet tare procedures must not be used to verify the labeled net weight of packages of meat and poultry packed at an official United States Department of Agriculture (USDA) facility and bearing a USDA seal of inspection. The USDA Food Safety and Inspection Service (FSIS) adopted specific sections of the 2005 4th Edition of NIST Handbook 133 by reference in 2008 but not the “wet tare” method for determining net weight compliance. FSIS considers the free-flowing liquids in packages of meat and poultry products, including single-ingredient, raw poultry products, to be integral components of these products (see Federal Register, September 9, 2008 [Volume 73, Number 175] [Final Rule – pages 52189‑52193]).

If the jurisdiction uses wet tare to determine net weight, follow the procedures described below that reference Used Dry Tare, except make no effort to dry the tare material. If Wet Tare is used to verify the net weight of the packages, the inspector must allow for moisture loss.

(Amended 2010)

#### Determination of Tare Sample and Average Tare Weight

Except in the instance of applying Unused Dry Tare, use this procedure for selecting and determining the tare sample and average tare weight. Depending upon the initial tare sample results, additional tare samples may need to be taken.

|  |
| --- |
| 1. Determine the initial tare sample size using Column 5 under initial tare sample size in Appendix A. Table 2‑1. “Sampling Plans for Category A” or Column 3 under initial tare sample size in Appendix A, Table 2‑2. “Sampling Plans for Category B.” Record the initial tare sample size in Box 7 on the appropriate form located in Appendix C. Model Inspection Report Forms. |
| **Note:** The initial tare sample size is considered the total tare sample size for the inspection lot when the sample size is less than 12. |
|  |
| 1. Except in the instance of applying Unused Dry Tare, select the packages for the initial tare sample from the sample packages. Mark the first two (three or five) packages in the order the random numbers were selected; these packages are the initial tare sample. | |
|  |
| 1. Determine the gross weight of each package and record it in Block a, “Gross Wt,” under the headings “Pkg. 1,” “Pkg. 2,” “Pkg. 3,” etc. on the report form. |
|  |
| 1. Except for aerosol or other pressurized packages, open the sample packages, empty, clean, and dry them as appropriate for the packaging material. |
|  |
| 1. Determine the tare weight for each package in the initial tare sample and record the value in Block b, “Tare Wt” under the appropriate package number column. |
|  | |
| 1. For sample sizes of 12 or more, subtract the individual tare weights from the respective package gross weights (Block a, minus Block b, on the report form) to obtain the net weight for each package and record each value in Block c, “Net Wt,” on the report form. | |
|  | |
| 1. Determine and record the “Range of Package Errors (Rc)” for the initial tare sample in Box 9 on the report form. The range is the difference between the package errors.   (Amended 2002) | |
|  | |
| 1. Determine and record the “Range of Tare Weights (Rt)” in Box 10. | |
|  | |
| 1. Compute the ratio Rc/Rt by dividing the value in Box 9 by the value in Box 10. Record the resulting value in Box 11. Rc and Rt must both be in the same unit of measure or both in dimensionless units. | |
|  | |
| 1. Determine and record in Box 12 the total number of tare samples to be opened for the tare determination from either Appendix A, Table 2‑3. “Category A” or Table 2‑4. “Category B.”  * In the first column (titled Ratio of Rc/Rt), locate the range in which the computed Rc/Rtfalls. Then, read across to the column headed with the appropriate sample size. * If the total number of packages to open equals the number already opened, go to Step 11. * If the total number of packages to open is greater than the number of packages already opened, compute the number of additional packages to open for the tare determination. * Open and weigh as per Steps 3, 4, and 5 and go to Step 11. Enter the total number of tare samples in Box 12. | |
|  | |
| 1. Determine the average tare weight using the tare weight values for all the packages opened and record the average tare weight in Box 13. | |

##### Unused Dry Tare

The average tare weight may be determined using samples of Unused Dry Tarewhen testing meat, poultry, or any other products that are not subject to regulation of the Food and Drug Administration (FDA). You may utilize Unused Dry Tare samples when conducting inspections at locations where the point-of-pack and sale are identical (e.g., store-packed products in a supermarket meat case). To determine Unused Dry Tare at the point-of-sale, randomly select two (2) samples of Unused Dry Tare, and weigh each separately. If there is no measurable variation in weight between the samples, proceed with the test using the weight of one of the samples. If the weight of the two (2) initial samples varies, randomly select three (3) additional tare samples and determine the average weight of all five (5) samples. Use this value as the average tare weight.

#### Special Procedures for Determining Tare

1. Aerosols and Other Pre-Pressurized Containers

Aerosol and other pre-pressurized containers (aerosols) are handled differently for two reasons: first, regulations in NIST Handbook 130 under the “Uniform Packaging and Labeling Regulation” (UPLR) require that packages designed “to deliver” the product under pressure, “must state the net quantity of the contents that will be expelled when the instructions for use as shown on the container are followed.” This means that any product retained in aerosol containers after full dispersion is included in the tare weight. Second, aerosol containers must not be opened because they are pressurized; for safety reasons they should not be punctured or opened. When emptying aerosol containers to determine a tare weight, exhaust them in a well-ventilated area (e.g., under an exhaust hood or outdoors) at least 15 m (50 ft) from any source of open flame or spark.

To ensure that the container properly dispenses the product, read and follow any dispensing instructions on the package. If shaking during use is specified in the instructions, periodically shake (at least two or three times during expulsion of the product). If directions are not given, shake the container five times with a brisk wrist twisting motion. If the container has a ball agitator, continue the shaking procedure for one minute after the ball has shaken loose.

1. Vacuum Packed Coffee

The gross weight of a container (typically a metal can) of vacuum-packed coffee will be more after the seal is broken and air enters the can. In the procedure to determine the tare weight of the packaging material, correct the gross weight determined for unopened cans as follows. Use the initial tare sample packages, weigh, and record the gross weight of the product-filled cans before and after breaking the vacuum seal. Compute the average gross weight difference (open weight minus sealed weight) and record this in Box 13a of the report form. The nominal gross weight equals the average tare weight minus the average difference in gross weights plus the labeled weight (Box 14): Box 13 − Box 13a + Box 1.

(Amended 2002)

### Determine Nominal Gross Weight and Package Error

#### Determine Nominal Gross Weight

A nominal gross weight is used to calculate package errors. To compute the nominal gross weight, add the average tare weight (recorded in Box 13) to the labeled weight (recorded in Box 1). Record in Box 14.

The nominal gross weight is represented by the formula:

*Nominal gross weight* = *average tare weight* + *labeled weight*

#### Determine Package Error

To obtain the package error, subtract the nominal gross weight from each package’s gross weight. The package error is represented by the formula:

*Package error* = *gross weight* − *nominal gross weight*

(Added 2010)

Determine the errors of the packages opened for tare by subtracting the nominal gross weight recorded in Box 14 from the individual package gross weights recorded for each package (Pkg. 1, Pkg. 2, etc.) in Block a, “Gross Wt.” The nominal gross weight must be used, rather than the actual net weight, for each package to determine the package error. This ensures that the same average tare weight is used to determine the error for every package in the sample, not just the unopened packages.

* **Standard Packages.** – Record the package error in the appropriate plus or minus column on the report form for each package opened for tare.
* **Random Packages.** – Determine the package error for the tare sample using a nominal gross weight for each package so that all of the package errors are determined with the same tare weight value. Record the package error on the Random Package Report Form in the appropriate plus or minus column under Package Errors.

**Note:** Converting the package error to dimensionless units allows the inspector to record the package errors as whole numbers disregarding decimal points and zeroes in front and unit of measure after the number. This section does not prohibit the use of software or units of weight instead of dimensionless units.

**Example:**

*If weighing in 0.001 lb increments, the unit of measure is 0.001 lb. If the package error for the first package opened for tare is* +*0.008 lb, instead of recording 0.008 lb in the plus column, record the error as “8” in the plus column. If the second package error is* +*0.060 lb, record the package error as “60” in the plus column, and so on.*

Determine the errors for the rest of the sample by subtracting the nominal gross weight (Box 14) from the gross weight of each of the unopened sample packages. Record the package errors in the “Package Errors” section of the report form using either units of weight (lb or g) or dimensionless units.

#### Compute Total Package Error

Add all the package errors for the packages in the sample. Be sure to subtract the minus package errors from the plus package errors and to record the total net error in Box 15, indicating the positive or negative value of the error.

(Amended 2010)

### Evaluate for Compliance

This inspection lot will pass or fail based on the sample test results. The following steps lead the inspector through the process to determine if a sample passes or fails. If the product is subject a moisture allowance, follow the procedures under Section 2.3.8. “Moisture Allowances” to correct the MAV.

#### Maximum Allowable Variation (MAV) Requirement

1. Compare each minus package error with the MAV recorded in Box 3 or Box 4 (if using dimensionless units). Circle the package errors that exceed the MAV. These are “Unreasonable Minus Errors.” Record the number of unreasonable minus errors found in the sample in Box 16.
2. Compare the number in Box 16 with the number of unreasonable errors allowed (recorded in Box 8). If the number found exceeds the allowed number, the lot fails. Record in Box 17 whether the number of unreasonable errors found is less or more than allowed.

#### Average Requirement

1. Determine the average error by dividing the total error recorded in Box 15 by the sample size recorded in Box 6. Record the average error in Box 18 if using dimensionless units or in Box 19 if using units of weight.
2. Compute the average error in terms of weight (if working in dimensionless units up to this time) by multiplying the average error in dimensionless units by the unit of measure and record the value in Box 19. If the average error is positive, the sample passes the average requirement. If the average error is negative, the sample fails under a “Category B” test. Record in Box 20.

**Note:** If the total error recorded in Box 15 is a plus value, and Box 17 is “No,” (the number of unreasonable errors is equal to or less than the number allowed, recorded in Box 8), the lot passes.

(Refer to Section 1.4.1. Net Quantity of Contents Requirements for Pesticides Labeled with Minimum Net Quantity of Contents Declarations.”)

1. If the average error is a negative value when testing under the Sampling Plans for “Category A,” compute the Sample Error Limit (SEL) as follows:

* Compute the Sample Standard Deviation and record it in Box 21.



* + Obtain the Sample Correction Factor from Column 3 of Appendix A. Table 2‑1. “Sampling Plans for Category A” test. Record this value in Box 22.
  + Compute the Sample Error Limit using the formula:

*Sample Error Limit (Box 23)* =

*Sample Standard Deviation (Box 21)* × *Sample Correction Factor (Box 22)*

1. Compliance Evaluation of the Average Error:

* If the value of the Average Error (Box 18) is smaller than the Sample Error Limit (Box 23), the sample passes.
* If the value of the Average Error (disregarding the sign) (Box 18) is larger than the Sample Error Limit (Box 23), the sample fails. However, if the product is subject to moisture loss, the sample does not necessarily fail. Follow the procedures under “Moisture Allowances” in this chapter.

(Amended 2018)

### Moisture Allowances

When no predetermined allowance is found in NIST Handbook 133, the potential for moisture loss must be considered. Inspectors should follow their jurisdiction’s guidance for making their determination on an acceptable moisture allowance.

(Added 2010)

If the product tested is subject to moisture loss, provide for the moisture allowance by following one of the two procedures listed below.

#### Applying Moisture Loss before Determining Package Errors

1. Determine the percent value of the moisture allowance if the product is listed below. (see Table 2-3. “Moisture Allowances.”)

| **Table 2-3.**  **Moisture Allowances** | | | |
| --- | --- | --- | --- |
| **Verifying the labeled net weight of packages of:** | | **Moisture Allowance is:** | **Notes** |
| Flour | | 3 % |  |
| Dry pet food | | 3 % | Dry pet food means all extruded dog and cat foods and baked treats packaged in Kraft paper bags and/or cardboard boxes with a moisture content of 13 % or less at time of pack. |
| Pasta products | | 3 % | Pasta products means all macaroni, noodle, and like products packaged in kraft paper bags, paperboard cartons, and/or flexible plastic bags with a moisture content of 13 % or less at the time of pack. |
| Borax | | see Section  2.4. Borax |  |
| **Wet Tare Only1** | | | |
| Fresh poultry | 3 % | | Fresh poultry is defined as poultry above a temperature of − 3 °C (26 °F) that yields or gives when pushed with the thumb. |
| Franks or hot dogs | 2.5 % | |  |
| Bacon, fresh sausage, and luncheon meats | 0 % | | For packages of bacon, fresh sausage, and luncheon meats, there is no moisture allowance if there is no free-flowing liquid or absorbent material in contact with the product and the package is cleaned of clinging material. Luncheon meats are any cooked sausage product, loaves, jellied products, cured products, and any sliced sandwich-style meat. This does not include whole hams, briskets, roasts, turkeys, or chickens requiring further preparation to be made into ready-to-eat sliced product. When there is no free-flowing liquid inside the package and there are no absorbent materials in contact with the product, Wet Tare and Used Dried Tare are equivalent. |
| **1**Wet tare procedures must not be used to verify the labeled net weight of packages of meat and poultry packed at an official United States Department of Agriculture (USDA) facility and bearing a USDA seal of inspection. The Food Safety and Inspection Service (FSIS) adopted specific sections of the 2005 4th edition of NIST Handbook 133 by reference in 2008 but not the “Wet Tare” method for determining net weight compliance. FSIS considers the free-flowing liquids in packages of meat and poultry products, including single-ingredient, raw poultry products, to be integral components of these products (see Federal Register, September 9, 2008 [Volume 73, Number 175] [Final Rule – pages 52189‑52193]). | | | |

(Amended 2010 and 2013)

**Notes:**

1. There is no moisture allowance when inspecting meat and poultry from a USDA inspected plant when Used Dry Tare and “Category A” sampling plans are used.
2. For the Wet Tare Only section of Table 2-3. “Moisture Allowances,” free-flowing liquid and liquid absorbed by packaging materials in contact with the product are part of the wet tare.

(Added 2010)

2. To compute moisture allowance, multiply the labeled quantity by the decimal percent value of the allowance. Record this value in Box 13a.

**Example:**

*Labeled net quantity of flour is 907 g (2 lb)*

*Moisture Allowance is 3 % (0.03)*

*Moisture Allowance* = *907 g (2 lb)*×*0.03*=*27 g (0.06 lb)*

* 1. If the Moisture Allowance is known in advance (e.g., flour, pasta products, and dry pet food), it can be applied by adjusting the Nominal Gross Weight used to determine the sample package errors. The Moisture Allowance in Box 13a is subtracted from the Nominal Gross Weight to obtain an Adjusted Nominal Gross Weight which is entered in Box 14. The Nominal Gross Weight is defined in Section 2.3.6.1. as the sum of the Labeled Weight and the Average Tare Weight from Box 13.

**Example:**

*Use a Labeled Weight of 907 g (2 lb) and an Average Tare Weight of 14 g (0.03 lb)*

*The calculation is:*

*Labeled Net Quantity 907 g (2 lb)* + *Average Tare Weight 14 g (0.03 lb)* = *921 g (2.03 lb)* – *Moisture Allowance 27 g (0.06 lb)* = *Adjusted Nominal Gross Weight of 894 g (1.97 lb)*

This result is entered in Box 14.

* 1. Determine package errors by subtracting the Adjusted Nominal Gross Weight from the Gross Weights of the Sample Packages.

**Example:**

*The calculation is:*

*Gross Weight of the Sample Packages* – *Adjusted Nominal Gross Weight* = *Package Error*

**Note:** When the Nominal Gross Weight is adjusted by subtracting the Moisture Allowance value(s) the Maximum Allowable Variation(s) is not changed. This is because the errors that will be found in the sample packages have been adjusted by subtracting the Moisture Allowance (e.g., 3 %) from the Nominal Gross Weight. That increases the individual package errors by the amount of the moisture allowance (e.g., 3 %). If the value(s) of the MAV(s) were also adjusted it would result in doubling the allowance. MAV is always based on the labeled net quantity.

(Added 2010)

#### Applying Moisture Allowance after Determining Package Errors

Adjustments can be made when the value of the Moisture Allowance is determined following the test (e.g., after the sample fails or if a packer provides reasonable moisture allowance based on data obtained using a scientific method) using the following approach:

If the sample fails the Average Requirement but has no unreasonable package errors, only Step 1 is used. If the sample passes the Average Requirement but fails because the sample included one or more Unreasonable Minus Errors, only Step 2 is used.

If the sample fails the Average and MAV Requirements, both of the following steps are applied.

|  |
| --- |
| 1. Use the following approach to apply a Moisture Allowance to the Average Requirement after the test is completed: |
|  |
| * the Moisture Allowance is computed; |
|  |
| **Example:**  *3 %*×*907 g (2 lb)* = *27 g (0.06 lb)* |
|  |
| * added to the Sample Error Limit; |
|  |
| **Example:**  *If the Sample Error Limit is 0.023, add 0.06 to obtain an Adjusted Sample Error Limit of 0.083)* |
|  |
| * the Adjusted Sample Error Limit is then compared to the Average Error of the Sample; and |
|  |
| * if the average error (disregarding sign) in Box 18 is smaller than the Adjusted Sample Error Limit, the sample passes.   HOWEVER,   * if the average error (disregarding sign) in Box 18 is larger than the Adjusted Sample Error Limit, the sample fails. |
|  |
| 1. To apply Moisture Allowance to the MAV(s) after the test, the following method is recommended: |
|  |
| * compute Moisture Allowance; |
|  |
| **Example:**  *3 %* × *907 g (2 lb)* = *27 g (0.06 lb)* |
|  |
| * add to MAV for labeled net quantity of the package to get Adjusted Maximum Allowable Variations; |
|  |
| **Example:**  *MAV for 907 g (2 lb) is 31.7 g (0.07 lb)*+*27 g (0.06 lb)*=  *Adjusted Maximum Allowable Variation(s) of 58.7 g (0.13 lb)* |
|  |
| * compare each minus package error to the Adjusted MAV; |
|  |
| * mark package errors that exceed the Adjusted MAV and record the number of unreasonable minus errors found in the sample; and |
|  |
| * if this number exceeds the number of unreasonable errors allowed, the sample fails. |

(Added 2010)

#### Moisture Allowance Gray Area

When the average error of a lot of fresh poultry, franks/hot dogs, or pasta products is minus but does not exceed the established “moisture allowance” or “gray area,” contact thepacker or plant management personnel to determine what information is available on the lot in question. Questions to the plant management representative may include:

* Is a quality control program in place?
* What information is available concerning the lot in question?
* If net weight checks were completed, what were the results of those checks?
* What adjustments, if any, were made to the target weight?

**Note:** Ifthe plant management has data on the lot, such data may help to substantiate that the “lot” had met the net content requirements at the point of manufacture.

This handbook provides “moisture allowances” for some meat and poultry products, flour, pasta products, and dry pet food. These allowances are based on the premise that when the average net weight of a sample is found to be less than the labeled weight, but not by an amount that exceeds the allowable limit, either the lot is declared to be within the moisture allowance or further investigation can be conducted.

Reasonable variations from net quantity of contents caused by the loss or gain of moisture from the package are permitted when caused by ordinary and customary exposure to conditions that occur under good distribution practices. If evidence is obtained and documented to prove that the lot was shipped from the packaging plant in a short-weight condition or was distributed under inappropriate or damaging distribution practices, appropriate enforcement action should be taken.

(Amended 2010 and 2013)

## Borax

This audit test is only used if the sample fails a net weight test. This procedure applies to packages of powdered or granular products consisting predominantly (more than 50 %) of borax. This method is used to identify possible short-filling by weight at point-of-pack for borax. Since the density of borax can vary at point-of-pack, further investigation is required to determine whether such short-filling has occurred. Use the following procedure to determine if packages of borax are labeled correctly. Borax shall be labeled by weight. Borax can lose more than 23 % of its weight due to moisture loss. However, it does not lose volume with moisture loss, and this property makes possible a method of volume testing based on a density determination in the event that the net weight of the borax does not meet the average or individual package requirements.

(Amended 2016)

### Test Equipment

* Dry measure with a capacity of 550.6 mL or (1 dry pt), 1101 mL (dry quart), 1000 mL (liter)
* Metal funnel with slide-gate and stand
* A scale that meets the requirements in Chapter 2, Section 2.2. “Measurement Standards and Test Equipment.”
* Straightedge or ruler
* Safety glasses
* Gloves
* Dust mask
* Level (at least 15 cm [6 in] in length)
* Pan or drop cloth/polyethylene sheeting for catching overflow of dry measure
* Borax Audit Worksheet

(Amended 2016)

### Test Procedure

Use this procedure only if the sample fails to meet the package requirements in Section 2.3.7. “Evaluate for Compliance.”

Select the package with the lightest gross weight. Fill out Boxes 1 through 3 of the Borax Audit Worksheet.

Record the volume declared on the package (Box 4). This volume declaration shall not appear on the principal display panel. Instead, it shall appear on the back, side, or bottom of the package and may read as:

Volume \_\_\_\_\_\_\_\_\_ mL per NIST Handbook 133

**Note:** 1 mL = 1 cm3

1. Determine the gross weight of the package (Box 5).
2. Look up the dry measure used in the following table and record the volume (Box 8).

|  |  |
| --- | --- |
| **Dry Measure** | **Volume in Milliliters** |
| Dry Pint | 550.6 ml |
| Dry Quart | 1101 ml |
| Liter | 1000 ml |

1. Determine the empty weight of dry measure and record the value (Box 9.)

Place the dry measure in the pan or on top of drop cloth/polyethylene sheeting and verify that it is level. Place the funnel on top of the dry measure and close the funnel side gate.

Pour an adequate amount of borax into the funnel so that the dry measure will be filled to overflowing.

Quickly remove the slide-gate from the funnel, allowing the borax to flow into the dry measure. To ensure that the borax is free-flowing, repeat Steps 5 (a), (b), and (c) at least three times. After the final filling, go to Step 5 (d).

1. Carefully, without agitating the dry measure, remove the funnel and level off the borax with the straightedge or ruler at a right angle to the rim of the cup, and carefully draw it across the top of the dry measure to leave an even surface. If the surface of the borax is not smooth, repeat Steps 5 (a), (b), (c), and (d). If the surface of the borax is smooth, proceed to Step 6.
2. Determine the gross weight of the filled dry measure and borax (Box 10).
3. Subtract the empty weight of the dry measure from the gross weight of the dry measure (Box 10 – Box 9) to obtain the net weight of the borax in the dry measure (Box 11).
4. Determine the tare weight of the package (Box 6).
5. Determine the net weight of package (Box 7).
6. Determine the net volume of the borax by dividing the net weight of the package (Box 7) by the net weight of the borax in the dry measure (Box 11) and multiply the result by the volume of the dry measure (Box 8). The result is the net volume of the borax in the package in milliliters (Box 12).

If the net volume of borax in the lightest package equals or exceeds the declared volume on the package, treat the lot as being in compliance based on volume and take no further action. If the net volume of borax in the lightest package is less than the declared volume on the package, further compliance testing will be necessary.

1. Take further steps to determine if the lot was in compliance with net weight requirements at point-of-pack or was short-filled by weight. To determine this, perform a laboratory moisture loss analysis to ascertain the weight of the original borax when it was fully hydrated; obtain additional data at the location of the packager; and/or investigate the problem with the packager of the borax.

(Amended 2016)

## Determination of Drained Weight

Since the weight per unit volume of a drained product is of the same order of magnitude as that of the packaging liquid that is drained off, an “average nominal gross weight” cannot be used in checking packages of this type. The entire sample must be opened. The procedure is based upon a test method accepted by the U.S. Food and Drug Administration (FDA).

A tare sample is not needed because all the packages in the sample will be opened and measured.

The weight of the container plus drained-away liquid is determined. This weight is then subtracted from the gross weight to determine the package error.

### Test Equipment

* Scales and weights recommended in Section 2.2. “Measurement Standards and Test Equipment” are suitable for the determination of drained weight.
* Sieves
  + For drained weight of 1.36 kg or (3 lb) or less, one 203 mm or (8 in) No. 8 mesh U.S. Standard Series sieve, receiving pan, and cover;
  + For drained weight greater than 1.36 kg or (3 lb), one 304 mm or (12 in) sieve, with same specifications as above;
  + For canned tomatoes, a U.S. Standard test sieve with 11.2 mm (7/16 in) openings must be used.

**Note:** The sieve is used, if it is necessary, to determine the percentage of solids in the container.

* Stopwatch

(Amended 2010)

### Test Procedure

|  |
| --- |
| 1. Follow Sections 2.3.1 through Section 2.3.4. to define an inspection lot, select “Category A” or a “Category B” sampling plan in the inspection (depending on the location of test); and select a random sample. |
|  |
| 1. Use Appendix C. “Standard Package Report.” Fill out Boxes 1 through 8. Determine and record on a worksheet the weight of the receiving pan. |
|  |
| 1. Determine and record on a worksheet the gross weight of each individual package comprising the sample. |
|  |
| 1. Pour the contents of the first package into the dry sieve with the receiving pan beneath it, incline sieve to an angle between 17° to 20°from horizontal to facilitate drainage, and allow the liquid from the product to drain into receiving pan for two minutes. (Do not shake or shift material on the sieve.) Remove sieve and product. |
|  |
| 1. Weigh the receiving pan, liquid, wet container, and any other tare material. (Do not include sieve and product.) Record this weight as tare and receiving pan on the worksheet. |
|  |
| 1. Subtract the weight of the receiving pan, determined in Step 2, from the weight obtained in Step 5 to obtain the package tare weight (which includes the weight of the liquid). Record package tare weight on the worksheet with the associated gross weight of the package. |
|  |
| 1. Subtract the tare weight, found in Step 6, from the corresponding package gross weight determined in Step 3 to obtain the drained weight of that package. Record package net weight on the worksheet. Determine the package error (drained weight – labeled drained weight) and record on worksheet. |
|  |
| 1. Repeat Steps 4 through 7 for the remaining packages in the sample after cleaning and drying the sieve and receiving pan between measurements of individual packages. |
|  |
| 1. Transfer the individual package errors to the Standard Pack Report form. |
|  |
| 1. To determine lot conformance, return toSection 2.3.7. “Evaluate for Compliance.” |

## Net Weight of Encased-in-Ice and Ice Glazed Products

### Net Weight of Encased-in-Ice and Frozen Block Product

**Note:** For determining the net weight of ice glazed seafood, meat, poultry, or similar products, follow the procedure in Section 2.6.2. “Net Weight of Ice Glazed Seafood, Meat, Poultry or Similar Products.”

#### Test Equipment

* Balance and weights (used to verify accuracy)
* Partial immersion thermometer or equivalent with 1 °C (2 °F) graduations and a − 35 °C to + 50 °C (− 30 °F to +120 °F) accurate to ± 1 °C (± 2 °F)
* Water source and hose with an approximate flow rate of 4 L to 15 L (1 gal to 4 gal) per minute for thawing blocks and other products
* Sink or other receptacle [i.e., bucket with a capacity of approximately 15 L (4 gal)] for thawing blocks and other products
* A wire mesh basket (e.g., used for testing large frozen blocks of shrimp) or a container that is large enough to hold the contents of one package (e.g., 2.27 kg or [5 lb] box of shrimp) and has openings small enough to retain all pieces of the product (e.g., an expanded metal test tube basket lined with standard 16‑mesh screen)
* Number 8 mesh, 203 mm (8 in) or 304 mm (12 in) sieve
* Means to determine a 30° angle
* Pan for weighing the thawed and drained product
* Stopwatch
* Ice Glazed Package Worksheet (see Appendix C. “Model Inspection Report Forms”)
* Ice Glazed Package Report (see Appendix C. “Model Inspection Report Forms”)

#### Test Procedure for Encased-in-Ice Product Only

|  |
| --- |
| 1. Follow Sections 2.3.1. through 2.3.4. to define the inspection lot, select a sampling plan and select a random sample. |
|  |
| 1. Place the unwrapped frozen seafood, meat, poultry, or similar products in the wire mesh basket or an open container to thaw (e.g., it is not placed in a plastic bag) and immerse in a 15 L (4 gal) or larger container of fresh water at a temperature between 23 °C to 29 °C (75 °F to 85 °F). Submerge the basket so that the top of the basket extends above the water level. |
|  |
| 1. Maintain a continuous flow of water into the bottom of the container to keep the temperature within the specified range. This is accomplished by maintaining a constant flow of warm water into the container holding the product (e.g., place a bucket in a sink to catch the overflow, and feed warm water into the bottom of the bucket through a hose). |
|  |
| **Note:** Direct immersion does not result in the product absorbing moisture because the freezing process causes the tissue to lose its ability to hold water. |
|  |
| 1. As soon as the product thaws, determined by loss of rigidity, transfer all material to a sieve (203 mm [8 in] for packages 453 g [1 lb] or less). A sieve 304 mm [12 in] for packages weighing more than 453 g [1 lb]) and distribute it evenly over the sieve. |
|  |
| 1. Without shifting the product, incline the sieve 30° from the horizontal position to facilitate drainage, and drain for two minutes. 2. While the product is draining, place pan on scale and tare the scale reading to zero. |
|  |
| 1. At the end of the drain time, immediately transfer the product to the tared pan for weighing to determine the net weight of the product. |

(Amended 2010)

### Net Weight of Ice Glazed Seafood, Meat, Poultry or Similar Products

For ice glazed seafood, meat, poultry or similar products, determine the net weight after removing the glaze using the following procedure.

#### Test Equipment

* Balance and weights (used to verify accuracy)
* Continuous cold water source
* Number 8 sieve and receiving pan, 203 mm (8 in) for packages 453 g (1 lb) or less. A 304 mm (12 in) for packages more than 453 g (1 lb).
* Means to determine a 17° to 20° angle
* Stopwatch

#### Test Procedures for Ice Glazed Product Only

|  |
| --- |
| 1. Follow Sections 2.3.1. through Section 2.3.4. to define an inspection lot, select “Category A” or a “Category B” sampling plan in the inspection (depending on the location of test), and select a random sample. |
|  |
| 1. Fill out the header information on boxes 1 through 8 on the Ice Glazed Package Report form. A tare sample is not needed. Record package price, price per pound, lot size, sample size, and unit of measure in Step 1 of the Ice Glazed Package Worksheet. (see Appendix C. “Model Inspection Report Forms.”) |
|  |
| **Note:** Use an official inspection report to record the inspection information. Attach additional worksheets, test notes, and other information as needed. This handbook provides an Ice Glazed Package Worksheet and Ice Glazed Package Report form in Appendix C. “Model Inspection Report Forms.” Modify the worksheet, package report and the box numbers to meet your agency’s needs. Other formats that contain more or less information may be acceptable. |
|  |
| 1. Number each package. Weigh each package for gross package weight and enter in Row 1 “Gross Pkg. Weight” on the Ice Glazed Worksheet. |
|  |
| 1. Enter the labeled net weight in Row 2 “Labeled Net Weight” for each package on the worksheet. If dual units, determine and enter the larger of the two units. |
|  |
| 1. Record the maximum allowable variation on Row 3 “MAV” on the worksheet. |
|  |
| 1. Weigh receiving pan and record the weight in Row 4, “Receiving Pan Weight” on the worksheet. |
|  |
| 1. Deglaze the product. Remove a package from low temperature storage; open it immediately and place the contents in the sieve or other draining device (e.g., colander) under a gentle spray of cold water.Carefully agitate the product. Handle with care to avoid breaking the product. Continue the spraying process until all ice glaze, that is seen or felt is removed. In general, the product should remain rigid; however, the ice glaze on certain products, usually smaller sized commodities, sometimes cannot be removed without partial thawing of the product. Nonetheless, remove all iceglaze because it may be a substantial part of the package weight. |
|  |
| 1. Transfer the product to the sieve (if the product is not already in the sieve).Without shifting the product, incline the sieve to an angle of 17° to 20° to facilitate drainage and drain (into waste receptacle or sink) for two minutes using a stopwatch. |
|  |
| 1. At the end of the drain time, immediately transfer the entire product to the receiving pan for weighing to determine the net weight. |
|  |
| 1. Place the product and receivingpan on the scale and weigh. Record the net weight in Row 5 on the ice glazed package worksheet. The net weight of product is equal to the weight of the receiving pan and the product minus the receiving pan weight. |
|  |
| 1. The package error is equal to the net weight of the product minus the labeled weight. Record the package error in Row 6. |
|  |
| 1. Repeat Steps 2 through 10 for each package in the sample, cleaning the sieve, cleaning and drying the receiving pan between package measurements. |
|  |
| 1. Transfer data from the Ice Glazed Package Worksheet to the Ice Glazed Package Report. |
|  |

### Evaluation of Results

Follow the procedures inSection 2.3.7. “Evaluate for Compliance.”

(Amended 2010)

## Determining the Net Weight and Percentage of Purge in Packages of Fresh and Frozen Chitterlings

### Test Equipment

• Scale or balance and mass standards (The standards are used to verify the accuracy and repeatability of the weighing device.)

• Partial immersion thermometer or equivalent with 1 °C (2 °F) graduations and a − 35 °C to + 50 °C (− 30 °F to + 120 °F) accurate to ± 1 °C (± 2 °F)

• Sink (e.g., water bath, ice chest) or other receptacle of suitable size to hold the packages for thawing, water source, and hose with fresh water that can be maintained at a temperature between 23 °C to 29 °C (75 °F to 85 °F) (used for thawing plastic bags or buckets of chitterlings)

An alternative thawing procedure for packages requires access to a refrigerator that must be available for storing sample packages for several days to thaw.

• Stainless Steel Sieve(s) and Drain Pan(s) with number 8 mesh, 203 mm (8 in) or 304 mm (12 in) (The use is based on the labeled net weight of the package under inspection.)

• Chitterlings Worksheet for Category A and Category B (see Appendix C**.** “Model Inspection Report Forms.”)

• Stopwatch (to measure drain periods)

• Knife or box cutter (to open packages)

• Waterproof marking pen (for numbering the packages)

• Disposable (non-latex) gloves

• Paper towels (drying sieve drain pan, packages and work area)

• Large plastic bags (to hold product emptied from packages)

• Plastic rod (to insert into buckets of chitterlings to determine if the product is thawed and to ensure there are no chunks of ice remaining).

(Added 2015)

### Test Procedure for Net Weight and Purge Determination for Fresh and Frozen Chitterlings.

This procedure is used to determine (1) the net weight and (2) the purge in packages of fresh and frozen chitterlings. The purge determination procedure requires the destructive testing of all the sample packages.

* + - 1. Follow Sections 2.3.1. “Define the Inspection Lot,” 2.3.2. “Select Sampling Plans” (use the “Category A” Sampling Plans in Appendix A. “Tables,” Table 2-1. “Sampling Plans for Category A” if the testing is outside of a USDA inspected packing facility, or the “Category B” Sampling Plan in Table 2-2. “Sampling Plans for Category B” if the testing is inside a USDA inspected packing facility), 2.3.3. “Record Inspection Data,” and 2.3.4. “Random Sample Selection.”

1. Select the random sample of packages.
2. Dry the sample packages and number each (e.g., 1 to 12) using a waterproof marker.
3. Record the Product Brand, Inspector Name, Labeled Net Weight (top of Column A), Packer Identity, Lot Code, Number of Unreasonable Errors, MAV from Appendix A. “Tables,” Table 2-9. “U.S. Department of Agriculture, Meat, Poultry, and Siluriformes Groups and Lower Limits for Individual Packages (Maximum Allowable Variations [MAVs]”), and the Unit of Measure of the scale used for weight determinations on the Chitterlings Worksheet (Appendix C. “Model Inspection Report Forms”). The appropriate information can be transferred to an official inspection report at the conclusion of the inspection. The worksheet should be added to the official record of the inspection.

(Added 2015)

#### Net Weight and Purge Determinations

Follow these procedures to determine the net weight and amount of purge from chitterlings.

##### Test Procedure for Determining the Net Weight and Purge from Fresh and Frozen Chitterlings

* + - 1. Determine the Gross Weight of each sample package (record in Column B).
      2. Determine the tare weight of the sieve drain pan (record in Drain Pan Tare above Column F).

**Frozen Chitterlings**

1. Fully immerse the unopened package of frozen chitterlings in a water bath maintained

at a temperature between 23 °C to 29 °C (75 °F to 85 °F).

**Notes:**

1. An alternative approach to thawing large frozen packages (e.g., 5 kg [10 lb] plastic pails) is to randomly select (mark them to be held for inspection) the sample packages and place them in a refrigerator for partial thawing over several days, and then carrying out the final thawing using the water bath technique.
2. If the products are to be placed in refrigerated storage for several days for partial thawing, segregate them from other product inventory and mark each container with an identifier to allow the inspector to ensure that they were the samples selected for testing (mark both lid and container on buckets) when the inspection is resumed after the thawing process. Also, mark the packages with a conspicuous notice that they are being held for inspection.
3. Maintain a continuous flow of water into the bath to keep the temperature within the specified range until the chitterlings are thawed. The chitterlings are thawed when it is determined by touch that they are not rigid and no ice crystals are observed or felt within or on their outside surface.

**Note:** For buckets, insert a plastic rod into the chitterlings to determine if the product is thawed and to ensure there are no chunks of ice remaining.

**Fresh and Frozen Chitterlings**

5. Draining the Chitterlings – Depending on the availability of a sink, work space, and the inspector’s preference, use the procedures in either Method A or Method B to drain the chitterlings. Refer to the Table 2-4. “Sieve Size Based on Labeled Net Weight” for the appropriate size sieve to use based on the labeled net weight on the package.

|  |  |  |  |
| --- | --- | --- | --- |
| **Table 2-4.**  **Sieve Size Based on Labeled Net Weight** | | | |
| **Labeled Net Weight** | **Sieve**  **Diameter** | **30 Degree Tilt from Horizontal** | **Incline Height** |
| If more than 453 g (1 lb) use a: | 304 mm  (12 in) | Incline Height | 175 mm (6.9 in) |
| If less than 453 g (1 lb) use a: | 203 mm  (8 in) | 116.8 mm (4.6 in) |
| * This procedure requires that the sieve and drain pan be cleaned and dried after each use. It is a good measurement practice to obtain the dry weights of both the sieve and pan and recheck those weights periodically during the test to make sure the cleaning and drying procedures are efficient. * If the amount of chitterlings in the package exceeds the capacity of the sieve, divide the solids evenly among two or more sieves of the same dimensions or make multiple determinations using a single sieve. Exercise care when transferring the chitterlings into the sieves to avoid spilling liquid which can void the test. | | | |

**Method A:**  Place a sieve over a sink or waste collection container. Pour the chitterlings into the sieve and distribute them over the surface of the sieve with a minimum of handling. Hold the sieve firmly and incline it 30 degrees (see Figure 2-3. “Sieve with Tilt Block Set at 30 Degrees” for an example of a tilt block for use with a sink drain set at 30 degrees) to facilitate drainage, then start the stop watch and drain for exactly two minutes. At the end of the drain time, immediately transfer the chitterlings to a drain pan for weighing. Determine the purged net weight of the chitterlings using the following formula and record in Column F of the worksheet.

*Drained Chitterlings and Drain Pan – Drain Pan Tare = Purged Net Weight*

**Method B:** Place a sieve on its drain pan. Pour the chitterlings into the sieve and distribute them over the surface of the sieve with a minimum of handling. Hold the sieve firmly and incline it 30 degrees to facilitate drainage, then start the stop watch and drain for exactly two minutes. At the end of the drain time, immediately transfer the drain pan with the purged liquid to the scale for weighing. Dry the empty package to determine its tare weight and enter it in Column C. Determine the purged net weight of the chitterlings using the following formula and record in Column F of the worksheet.

**Figure 2-3. Sieve with Tilt Block Set at 30 Degrees.**

*(Gross Weight of Package* − *Package Tare Weight)* – *(Weight of Purged Liquid & Drain Pan*− *Drain Pan Tare)* = *Purged Net Weight*

*(Column B – Column C)* − *(Weight of Purged Liquid & Drain Pan* – *Drain Pan Tare)* = *Purged Net Weight*

6. Calculate Purge using the formula shown below (use the labeled net weight in Column A and NOT the gross weight of the package in Column B) and record the result in Column G of the Worksheet.

*Purge in %*=*(Labeled Weight* − *Purged Net Weight)* ÷ *Labeled Weight × 100*

*Purge in %*=*Column A* – *Column F* ÷ *Column A* × *100*

**Example:**

*The labeled net weight is 5 lb and the Purged Net Weight is 4.19 lb*

*5 lb* – *4.19 lb* = *0.81 lb*÷ *5 lb* = *0.162 × 100 %* = *16.2 % purge*

7. Dry the empty package and determine its tare weight (record in Column C of the worksheet.)

8. Subtract the individual Package Tare Weight from the individual Package Gross Weight to obtain the Actual Package Net Weight (record in Column D of worksheet). Do not use an Average Tare Weight. Use the formula:

*Actual Package Net Weight* =*Gross Weight*−*Tare Weight*

*Actual Package Net Weight* = *Column B* – *Column C*

9. Subtract the Actual Package Net Weight from the Labeled Net Weight (record in Column E of worksheet). Use the formula:

*Package Error* = *Labeled Net Weight* – *Actual Package Net Weight*

*Package Error* = *Column A* – *Column D*

10. Repeat for all packages in the sample.

**Note:** The determination of compliance with the net weight and purge requirements are carried out concurrently. The calculation of the average net weight and average purge is completed after all of the packages are opened and all purge amounts are obtained. The sample must pass both the net weight and purge tests to comply with this section.

(Added 2015)

### Evaluations of Results – Compliance Determinations

**1. Net Weight**

1. Individual Package Requirement

If there are negative package errors, determine if any of the values exceed the Maximum Allowable Variation (MAV) for the packaged quantity in NIST Handbook 133, Appendix A. “Tables,” Table 2-9. “U.S. Department of Agriculture, Meat, Poultry, and Siluriformes Groups and Lower Limits for Individual Packages” (i.e., if the labeled net weight is more than 3 lb up to 10 lb then the MAV = 42.5 g [0.094 lb] 1.5 oz).

* If a package error exceeds the MAV, mark it as “Failed” in the MAV Fail column.
* Count the number of packages that exceed the MAV. If the number of packages that exceed the MAV is greater than the number allowed in NIST Handbook 133, Appendix A. “Tables,” Table 2-1. “Sampling Plans for Category A” or Table 2‑2. “Sampling Plans for Category B," the sample fails. Mark the sample as “Failed” in the Net Weight Compliance section of the worksheet.
* If the sample passes the Individual Package Requirement, apply the Average Error Requirement.

1. Average Error Requirement

Sum the package errors in Column E and enter the value in E1 – Total Error. Divide the value in E1 by the Sample Size (n) to obtain an Average Error and enter the value in E2. If the Average Error (E2) is a positive number, the sample passes. Go to the Net Weight Compliance Section and mark the sample as “Passed.”

* If the Average Error (E2) is a negative number, calculate the sample standard deviation of the package errors (Column E) and enter it in the block provided in the Net Weight Compliance section.
* Use the Sample Correction Factor (SCF) to calculate the Sample Error Limit (SEL).

*Sample Error Limit (SEL)* = *Sample Standard Deviation* × *Sample Correction Factor*

* Disregarding the signs,
* if the Average Error (E2) is larger than the SEL, the sample fails. Mark it “Failed” in the Net Weight Compliance Section of the worksheet,

or

* if the Average Error is less than the SEL, the sample passes. Go to the Net Weight Compliance Section and mark the sample as “Passed.”

**2. Purge**

Follow these procedures to determine the amount of purge from the chitterlings. Apply the Average Requirement in Section 2.3.7.2. “Average Requirement” to the purge to determine if the sample passes or fails the requirement. The Average Adjusted Purge (AAP) for the sample shall not exceed 20 % of the labeled weight. The Maximum Allowable Variations (Lower Limits for Individual Packages) in NIST Handbook 133, Appendix A. “Tables,” Table 2-9. “U.S. Department of Agriculture, Meat, Poultry, and Siluriformes Groups and Lower Limits for Individual Packages (Maximum Allowable Variations [MAVs]) are not applied in the purge test.

* Sum the purge values in Column G and enter the value in G1 – Total Purge. Divide the value in G1 by the Sample Size (n) to obtain an Average Purge and enter the value in G2. If the Average Purge (G2) is less than or equal to 20 %, the sample passes. Go to the Purge Compliance Section and mark the sample as “Passed.”
* If the Average Purge is greater than 20 %, calculate the Sample Standard Deviation of the values in Column G and enter it in the block provided in the Purge Compliance section.
* Use the Sample Correction Factor (SCF) to calculate the Purge Sample Error Limit (PSEL) in percent.
* Subtract the PSEL from the Average Purge (G2) to obtain an Adjusted Average Purge (AAP) and enter that value in G3.
* Pass or Fail
* If the AAP (G3) is greater than 20 %, the sample fails. Enter the Purge Value (G3) in the Purge Compliance section and mark the sample as “Failed.”

or

* if the AAP (G3) is 20 % or less, the sample passes. Enter the Purge Value (G3) in the Purge Compliance section and mark the sample as “Passed.”

(Added 2015)

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# Test Procedures – For Packages Labeled by Volume



## Scope

Use these procedures to determine thenet contentsof packaged goods labeled in fluid volume such as milk, water, beer, oil, paint, distilled spirits, soft drinks, juices, liquid cleaning supplies, or chemicals. This chapter also includes procedures for testing the capacities of containers such as paper cups, bowls, glass tumblers, and stemware.

These procedures do not cover berry baskets and rigid-dry measures that are covered by specific code requirements in NIST Handbook 44 “Specifications, Tolerances, and Other Technical Requirements for Weighing and Measuring Devices.”

### Test Methods

The gravimetric procedure may be used to verify the net quantity of contents of packages labeled in volume when the density (density means the weight of a specific volume of liquid determined at a reference temperature) of the product being tested does not vary excessively from one package to another.

If the density varies from one package to another, test each package using the volumetric test procedures described in this chapter. Special test methods are required for a number of unique products so care should be taken to select the correct test procedure.

**Reference Temperature:**

In addition to possible package-to-package variations in product density, the temperature of the liquid will affect the volume. The product will expand or contract based on a rise or fall in product temperature.

**Example:**

*The volume of a liquid cleaning product might be 5 L (1.32 gal) at 20 °C (68 °F) and 5.12 L (1.35 gal) at 25 °C (77 °F), which represents a 2.2 % change in volume.*

**Notes:**

* 1. This extreme example is for illustrative purposes. A 2.2 % volume change will not occur in normal testing.

Use the reference temperature specified in Table 3‑1. “Reference Temperatures for Liquids” to determine volume. When checking liquid products labeled by volume using the gravimetric procedure, maintain the packages used to determine product densities at reference temperatures. If testing the packages in a sample volumetrically, each package in the sample must be maintained at or corrected to the reference temperature when its volume is determined.

* 1. When checking liquid products using a volumetric or gravimetric procedure, the temperature of the samples must be maintained at the reference temperature ± 2 °C (± 5 °F).

|  |  |  |
| --- | --- | --- |
| **Table 3-1.**  **Reference Temperatures for Liquids** | | |
| **If the liquid commodity is:** | **Volume is determined at the reference temperature of:** | **Code of Federal Regulation (CFR) Reference\*** |
| Malt (Beer) | 4 °C (39.1 °F) | 27 CFR 7.10 |
| Distilled Spirits | 15.56 °C (60 °F) | 27 CFR 5.11 |
| Frozen food - sold and consumed in the frozen state | At the frozen temperature | 21 CFR 101.7(b)(2)(i) |
| Petroleum | 15.6 °C (60 °F) | 16 CFR 500.8(b) |
| Refrigerated food (e.g., milk and other dairy products labeled “KEEP REFRIGERATED”) | 4 °C (40 °F) | 21 CFR 101.7(b)(2)(ii) |
| Other liquids and wine (e.g., includes liquids sold in a refrigerated state for immediate customer consumption such as soft-drinks, bottled water and others that do not require refrigeration) | 20 °C (68 °F) | Food: 21 CFR 101.7(b)(2)(iii)  Non-Food: 16 CFR 500.8(b)  Wine: 27 CFR 4.10 (b) |
| \*The Code of Federal Regulations can be accessed online at: [**www.ecfr.gov**](http://www.ecfr.gov/) | | |

(Amended 2010)

## Gravimetric Test Procedure for Non-Viscous Liquids

### Test Equipment

* A scale that meets the requirements in Chapter 2, Section 2.2. “Measurement Standards and Test Equipment.”

**Note:** To verify that the scale has adequate resolution for use, it is first necessary to determine the density of the liquid; next verify that the scale division is no larger than MAV/6 for the package size under test. The smallest graduation on the scale must not exceed the weight value for MAV/6.

**Example:**

*Assume the inspector is using a scale with 1 g (0.002 lb) increments to test packages labeled 1 L (33.8 fl oz) that have an MAV of 29 mL (1 fl oz). Also, assume the inspector finds that the weight of 1 L of the liquid is 943 g (2.078 lb). This will result in an MAV/6 value in weight of 4.715 g (0.010 lb):*

*29 mL* ÷ *6* = *4.8 mL (1 fl oz* ÷ *6* = *0.166 6 fl oz)*

*943 g* ÷ *1000 mL = 0.943 g/mL (2.07 8 lb* ÷ *33.6 fl oz* = *0.061 8 lb/fl oz)*

*4.8 mL* × *0.943 g/mL* = *4.5264 g (0.166 6 fl oz* × *0.061 8 lb/fl oz* = *0.010 lb)*

*In this example, the 1 g (0.002 lb) scale division is smaller than the MAV/6 value of 4.5264 g (0.010 lb) so the scale is suitable for making a density determination.*

* A partial immersion thermometer (or equivalent) with a range of − 35 °C to + 50 °C (30 °F to 120 °F), at least 1 °C (1 °F) graduations, and with a tolerance of ± 1 °C (± 2 °F).
* Volumetric measures

**Note:** When checking packages labeled in SI units, flask sizes of 100 mL, 200 mL, 500 mL, 1 L, 2 L, 4 L, and 5 L and a 50 mL cylindrical graduate with 1 mL divisions may be used. When checking packages labeled in U.S. customary units the use of measuring flasks and graduates with capacities of gill, half-pint, pint, quart, half-gallon, gallon, and a 2 fl oz cylindrical graduate, graduated to 1/2 fl dr is recommended.

* Defoaming agents may be necessary for testing liquids such as beer and soft drinks that effervesce or are carbonated. Two such products are Hexanol or Octanol (Capryl Alcohol\*).

**\*Note:** The mention of trade or brand names does not imply that these products are endorsed or recommended by the U.S. Department of Commerce over similar products commercially available from other manufacturers.

* Bubble level at least 152 mm (6 in) in length
* Stopwatch

### Test Procedure

|  |  |
| --- | --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection. Select a random sample. | |
|  | |
| 1. Bring the sample packages and their contents to the reference temperature as specified in Table 3‑1. “Reference Temperatures for Liquids.” To determine if the liquid is at its reference temperature, immerse the thermometer in the liquid before starting the test. Verify the temperature again immediately after the flask and liquid is weighed. If the product requires mixing for uniformity, mix it before opening in accordance with any instructions specified on the package label. Shaking liquids, such as flavored milk, often entraps air that will affect volume measurements, so use caution when testing these products. Often, less air is entrapped if the package is gently rolled to mix the contents. | |
|  | |
| 1. For milk, select a volumetric measure equal to or one size smaller than the label declaration. For all other products, select a volumetric measure that is one size smaller than the label declaration.   (Amended 2004)  **Example:**  *If testing a 1 L bottle of juice or a soft drink, select a 500 mL volumetric measure.* | |
|  | |
| **Note:** When determining the density of milk, if the product from the first container does not fill the volumetric measure to the nominal capacity graduation, product may be added from another container as long as product integrity is maintained (i.e., brand, identity, lot code, and temperature). | |
|  | |
| 1. Prepare a clean volumetric measure to use according to the following procedure: | |
|  | |
| * Because flasks are ordinarily calibrated on a “to deliver” basis, they must be “wet down” before using. Immediately before use, fill the volumetric flask(s) or graduate with water. The water should be at the reference temperature of the product being tested. Fill the flask(s) with water to a point slightly below the top graduation on the neck. The flask should be emptied in 30 seconds (± 5 seconds). Tilt the flask gradually so the flask walls are splashed as little as possible as the flask is emptied. When the main flow stops, the flask should be nearly inverted. Hold the flask in this position for 10 seconds more and touch off the drop of water that adheres to the tip. If necessary, dry the outside of the flask. This is called the “wet down” condition. The flask or graduate is then ready to fill with liquid from a package. | |
|  | |
| **Note:** When using a volumetric measure that is calibrated “to contain,” the measure must be dry before each measurement. | |
|  | |
| * If the liquid effervesces or foams when opened or poured (such as carbonated beverages), add two drops of a defoaming agent to the bottom of the flask before filling with the liquid. If working with a carbonated beverage, make all density determinations immediately upon placing the product into the standard. This reduces the chance of volume changes occurring from the loss of carbonization. | |
|  |
| 1. If the flask capacity is equal to the labeled volume, pour the liquid into the volumetric measure tilting the package to a nearly vertical position. If the flask capacity is smaller than the package’s labeled volume, fill the flask to its nominal capacity graduation. | |
|  | |
| 1. Position the flask on a level surface at eye level. For clear liquids, place a material of some dark color outside the flask immediately below the level of the meniscus. Read the volume from the lowest point of the meniscus. For opaque liquids, read volume from the center top rim of the liquid surface. | |
|  | |
| 1. Evaluate the density variation. | |
|  | |
| * Select a volumetric measure equal to or one size smaller than the labeled volume (depending on the product) and prepare it as described in Step 4 of this section. Then determine and record its empty weight. | |
|  | |
| * Determine acceptability of the liquid density variation, using two packages as follows: | |
|  | |
| * Determine the gross weight of the first package. * Pour the liquid from the first package into a flask. Measure exactly to the nominal capacity marked on the neck of the measure. | |
|  | |
| * Weigh the filled flask and subtract its empty weight to obtain the weight of the liquid. Determine density by dividing the weight of the liquid by the capacity of the flask. | |
|  | |
| * Determine the weight of the liquid from a second package using the same procedure. | |
| * If the difference between the densities of the two packages exceeds one division, use the volumetric procedure in Section 3.3. “Volumetric Test Procedure for Non-Viscous Liquids.” | |
|  | |
| 1. Determine the Average Used Dry Tare Weight of the sample according to provisions of Section 2.3.5. “Procedures for Determining Tare.” | |
|  | |
| 1. Calculate the Average Product Density by adding the densities of the liquid from the two packages and dividing the sum by two. | |
|  | |
| 1. Calculate the “nominal gross weight” using the following formula if the flask capacity is equal to the labeled volume: | |
|  | |
| *Nominal Gross Weight* = *(Average Product Density [in weight units])* +  *(Average Used Dry Tare Weight)* | |
|  | |
| **Note:** If the flask size is smaller than the labeled volume, the following formula is used: | |
|  | |
| *Nominal Gross Weight* = *(Average Product Density* ×  *[Labeled Volume/Flask Capacity])* + *(Average Used Dry Tare Weight)* | |
|  | |
| 1. Weigh the remaining packages in the sample. |
|  |
| 1. Subtract the nominal gross weight from the gross weight of each package to obtain package errors in terms of weight. All sample packages are compared to the nominal gross weight. |
|  |
| 1. To convert the average error or package error from weight to volume, use the following formula:   *Package Error in Volume* = *Package Error in Weight*÷*Average Product Density* *Per Volume Unit of Measure.* |
|  |

### Evaluation of Results

Follow the procedures in Chapter 2, Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.



## Volumetric Test Procedure for Non-Viscous Liquids

If it is determined that the densities of the liquids vary beyond the specified limit, use the volumetric test procedure below to test the product.

### Test Equipment

* A partial immersion thermometer (or equivalent) with a range of − 35 °C to + 50 °C (30 °F to 120 °F), at least 1 °C (1 °F) graduations, and with a tolerance of ± 1 °C (± 2 °F).
* Volumetric measures

**Note:** When checking packages labeled in SI units, flask sizes of 100 mL, 200 mL, 500 mL, 1 L, 2 L, 4 L, and 5 L and a 50 mL cylindrical graduate with 1 mL divisions may be used. When checking packages labeled in U.S. customary units the use of measuring flasks and graduates with capacities of gill, half-pint, pint, quart, half-gallon, gallon, and a 2 fl oz cylindrical graduate, graduated to 1/2 fl dr is recommended.

* Defoaming agents may be necessary for testing liquids such as beer and soft drinks that effervesce or are carbonated. Two such products are Hexanol or Octanol (Capryl Alcohol\*).

**\*Note:** The mention of trade or brand names does not imply that these products are endorsed or recommended by the U.S. Department of Commerce over similar products commercially available from other manufacturers.

* Bubble level at least 152 mm (6 in) in length
* Stopwatch

### Test Procedure

1. Follow Steps 1 through 6 in Section 3.2. “Gravimetric Test Procedure for Non-Viscous Liquids” for each package in the sample.
2. In Step 5, drain the container into the flask for one minute after the stream of liquid breaks into drops.
3. Read the package errors directly from the graduations on the measure. The reference temperature must be maintained within ± 2 °C (± 5 °F) for the entire sample.

### Evaluation of Results

Follow the procedures in Chapter 2, Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

## Volumetric Test Procedures for Viscous Fluids – Headspace

Depending on how level the surface of the commodity is, use one of the two headspace test procedures. Use Section 3.4.2.a. “Test Procedure for Testing Oils, Syrups, and other Viscous Liquids with a Smooth and Level Surface” to determine volume where the liquid has a level surface (e.g., oils, syrups, and other viscous liquids). Use Section 3.4.2.b. “Test Procedure for Testing Mayonnaise, Salad Dressing, and Water Immiscible Products with no Smooth and Level Surface” to determine volume where the commodity does not have a level surface (e.g., mayonnaise and salad dressing).

Before conducting either of the following volumetric test procedures, follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample.

(Amended 2019)

### Test Equipment

* Micrometer depth gage (ends of rods may be flat or fully rounded) 0 mm to 225 mm (0 in to 9 in) or longer.
* Level (at least 152 mm (6 in) in length)
* Laboratory pipets and/or buret
  + Class A 100 mL buret as defined by the latest version of ASTM E287, “Standard Specification for Laboratory Glass Graduated Burets.”
  + Class A pipets, calibrated “to deliver “as defined by the latest version of ASTM E969, “Standard Specification for Glass Volumetric (Transfer) Pipets.”
    - Volumetric measures
    - Distilled Water or Reverse Osmosis Water (for use with laboratory pipets and/or burets)
    - Water
    - Rubber bulb syringe
    - Plastic disks that are 3 mm (1/8 in) thick with diameters equal to the seat diameter or larger than the brim diameter of each container to be tested. The diameter tolerance for the disks is 50 μm (± 0.05 mm [± 0.002 in]). The outer edge should be smooth and beveled at a 30° angle with the horizontal to 800 μm (0.8 mm [1/32 in]) thick at the edge. Each disk must have a 20 mm (3/4 in) diameter hole through its center and a series of 1.5 mm (1/16 in) diameter holes 25 mm (1 in) apart around the periphery of the disk and 3 mm (1/8 in) from the outer edge. All edges must be smooth.
    - Stopwatch
* Partial immersion thermometer (or equivalent) with 1 °C (2 °F) graduations and a range of − 35 °C to + 50 °C (− 30 °F to + 120 °F) accurate to ± 1 °C (± 2 °F)

(Amended 2019)

### Test Procedures

1. Test Procedure for Testing Oils, Syrups, and other Viscous Liquids with a Smooth and Level Surface

Use the volumetric headspace procedure described in this section to determine volume when the commodity has a level surface. Open every package in the sample.

|  |
| --- |
| 1. Bring the temperature of both the liquid and the water to be used to measure the volume of the liquid to the reference temperature specified in Table 3‑1. “Reference Temperatures for Liquids.” Verify with a thermometer that the product has maintained the reference temperature. |
|  |
| 1. Place the package on a level surface and open it. Measure the headspace of the package at the point of contact with the liquid using a depth gage. If necessary, support the package to prevent deflection in the bottom of the container that may affect the volume. |
|  |
| 1. Empty, clean, and dry the package. |
|  |
| 1. Refill the container with water measured from a volumetric standard to the original liquid headspace level measured in Step 2 of this procedure until the water touches the depth gage. |
|  |
| 1. Determine the amount of water used in Step 4 of this procedure to obtain the volume of the liquid and calculate the “package error” based on that volume. |
|  |
| *“Package Error”* = *Labeled Value* – *Measured Volume* |
|  |

1. Test Procedure for Testing Mayonnaise, Salad Dressing, and Water Immiscible Products with no Smooth and Level Surface

Use the following volumetric headspace procedure to determine volume when the commodity does not have a level surface (e.g., mayonnaise, salad dressing, and other water immiscible products without a level liquid surface). The procedure guides the inspector to determine the amount of headspace above the product in the package and the volume of the container. Determine the product volume by subtracting the headspace volume from the container volume. Open and test every package in the sample.

(Amended 2010)

**Note:** Make all measurements on a level surface.

|  |
| --- |
| * 1. Bring the temperature of both the commodity and the water used to measure the volume to the appropriate temperature designated in Table 3‑1. “Reference Temperatures for Liquids.” |
|  |
| * 1. Open the first package and place a disk larger than the package container opening over the opening. |
|  |
| * 1. Measurement Procedure: |
|  |
| * Deliver water from a flask (or flasks), graduate, or buret, through the central hole in the disk onto the top of the product until the container is filled. If it appears that the contents of the flask may overfill the container, do not empty the flask. Add water until all of the air in the container has been displaced and the water begins to rise in the center hole of the disk. Stop the filling procedure when the water fills the center disk hole and domes up slightly due to the surface tension. Do not add additional water after the level of the water dome has dropped. |
|  |
| * If the water dome breaks on the surface of the disk, the container has been overfilled and the test is void; dry the container and start over. |
|  |
| * 1. To obtain the headspace capacity, record the volume of water used to fill the container and subtract 1 mL (0.03 fl oz), which is the amount of water held in the hole in the disk specified. |
|  |
| * 1. Empty, clean, and dry the package container. |
|  |
| * 1. Using Steps 3 and 4 of this procedure, refill the package container with water measured from a volumetric measure to the maximum capacity of the package, subtract 1 mL (0.03 fl oz), and record the amount of water used as the container volume; and |
|  |
| 1. From the container volume determined in Step 6 of this procedure, subtract the headspace capacity in Step 4 of this procedure to obtain the measured volume of the product. |
|  |
| 1. Calculate the “package error” for that volume where “package error” equals labeled volume minus the measured volume of the product. |
|  |

### Evaluation of Results

For either of the above procedures, follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

## Goods Labeled by Capacity – Volumetric Test Procedure

### Test Equipment

Use the test equipment in Section 3.4. “Volumetric Test Procedures for Viscous Fluids – Headspace” (except for the micrometer depth gage) to perform this test procedure.

### Test Procedure

**Note:**Make all measurements on a level surface.

|  |
| --- |
| 1. Before conducting any of the following volumetric test procedures, refer to Section 2.3.1.  “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample. |
|  |
| 1. When testing goods labeled by capacity, use water at a reference temperature of 20 °C ± 2 °C (68 °F ± 5 °F). |
|  |
| 1. Select a sample container and place a disk larger than the container opening over the opening. |
|  |
| 1. Measurement Procedure: |
|  |
| * Add water to the container using flask (or flasks), graduate, or buret corresponding to labeled capacity of the container. If it appears that the contents of the flask may overfill the container, do not empty the flask. Add water until all of the air in the container has been displaced and the water begins to rise in the center hole of the disk. Stop filling the container when the water fills the center disk hole and domes up slightly due to the surface tension. |
|  |
| * If the water dome breaks on the surface of the disk, the container has been overfilled and the test is void; dry the container and start over. |
|  |
| * Record the amount of water used to fill the container and subtract 1 mL (0.03 fl oz) this is the amount of water held in the hole in the disk specified) to obtain the total container volume. |
|  |
| 1. Test the other containers in the sample according to Steps 3 and 4 of this procedure. |
|  |
| 1. To determine package errors, subtract the total container volume obtained in Step 4 of this procedure from the labeled capacity of the container. |
|  |

### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot compliance.

## Pressed and Blown Glass Tumblers and Stemware

This handbook provides a tolerance to the labeled capacity of glass tumblers and stemware. The average requirement does not apply to these products. (see Table 3‑2. “Allowable Differences for Pressed and Blown Glass Tumblers and Stemware.”)

### Test Equipment

Use the test equipment in Section 3.4. “Volumetric Test Procedures for Viscous Fluids – Headspace” (except for the micrometer depth gage) to perform this test procedure.

### Test Procedure

* 1. Follow Section 2.3.1.“Define the Inspection Lot” and determine which sampling plan to use in the inspection, select a random sample, and then use the volumetric test procedure in Section 3.5. “Goods Labeled by Capacity – Volumetric Test Procedure” to determine container capacity and volume errors.
  2. Compare the individual container error with the allowable difference that applies in Table 3‑2. “Allowable Differences for Pressed and Blown Glass Tumblers and Stemware.” If a package contains more than one container, all of the containers in the package must meet the allowable difference requirements in order for the package to pass.

|  |  |
| --- | --- |
| **Table 3‑2.**  **Allowable Differences for Pressed and Blown Glass Tumblers and Stemware** | |
| **Unit of Measure** |  |
| **If the capacity in metric units is:** | **The allowable difference is:** |
| 200 mL or less | ± 10 mL |
| More than 200 mL | ± 5 % of the labeled capacity |
| **If the capacity in U.S. customary units is:** | **Then the allowable difference is:** |
| 5 fl oz or less | ± 1/4 fl oz |
| More than 5 fl oz | ± 5 % of the labeled capacity |

### Evaluation of Results

Count the packages in the sample with volume errors greater than the allowable difference and compare the resulting number with the number given in Column 3. (Appendix A, Table 2-11. “Sampling Plans and Accuracy Requirements for Packages Labeled by Low Count [50 or Fewer] and Packages Given Tolerances [Glass and Stemware])

* + - If the number of containers in the sample with errors exceeding the allowable difference exceeds the number allowed in Column 3, the lot fails.
    - If the number of packages with errors exceeding the allowable difference is less than or equal to the number in Column 3, the lot passes.

**Note:**The average capacity error is not calculated because the lot passes or fails based on the individual volume errors. Take action on the individual units containing errors exceeding the allowable difference.

## Volumetric Test Procedure for Paint, Varnish, and Lacquers – Non-Aerosol

The following procedure is used to verify the net quantity of contents of containers of paint, varnish, wood stains, sealants, lacquers or like products labeled by volume. For the purposes of this test procedure the term “paint” includes any liquid or product (i.e., varnish lacquers, and other coatings).

(Amended 2019)

### Test Equipment

* A scale that meets the requirements inSection 2.2. “Measurement Standards and Test Equipment”
* Volumetric measures
* Partial immersion thermometer (or equivalent with 1 °C (2 °F) graduations and a range of – 35 °C to + 50 °C (–30 °F to + 120 °F) accurate to ± 1 °C (± 2 °F)
* Micrometer depth gage (ends of rods may be flat or fully rounded), 0 mm to 225 mm (0 in to 9 in)
* Spanning bar, 25.4 mm × 25.4 mm × 304 mm or (1 in × 1 in × 12 in)
* Ruler, 304 mm (12 in)
* Paint solvent or other solvent suitable for the product being tested
* Cloth, 304 mm (12 in) square
* Wood, 50 mm (2 in) thick × 150 mm (6 in) wide × 300 mm (12 in) long
* Rubber mallet
* Metal disk or other appropriate shape, 6.4 mm (¼ in) thick and slightly smaller than the diameter of package container bottom
* Rubber spatula
* Level at least 152 mm (6 in) in length
* Distilled water or reverse osmosis water
* Micrometer (optional)
* Stopwatch

(Amended 2019)

### Test Procedures

1. Plant Audit Test Procedure

Use the following procedure to conduct an audit inspection in a production facility. This method applies to containers in a sample that are the lightest in weight and likely to contain the smallest volume of product. Duplicate the level of fill with water in an empty unused container of the same dimensions and capacity as the one under test. Use this method to check any size rigid container, if the liquid level is within the measuring range of the depth gage. If any paint is clinging to the sidewall or lid, carefully scrape the paint into the container using a rubber spatula to ensure the full content volume is measured.

**Note:** Do not shake or invert the containers selected as the sample**.**

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot” to determine which “Category A” sampling plan to use; select a random sample.   **Note:** The sample containers shall be identically labeled as to volume, brand, commodity, color, and lot. |
|  |
| 1. Determine the gross weight of the sample container. Record the gross weight of the lightest and heaviest container. |
|  |
| 1. Select the lightest container and place it on a level work surface and open it. Place a spanning bar and depth gage across the top center of the container. Lower the depth gage rod until its point touches the surface of the paint and lock the rod adjustment. |
|  |
| 4. Obtain an empty, unused – undamaged container of the same type and capacity as the container under test from the packer. Place the container on a rigid level work surface and place a disk or other appropriate support under the bottom to prevent deflection. |
|  |
| 1. Use a volumetric flask or cylinder to fill the container with water [water reference temperature 20 °C ± 2 °C (68 °F ± 5 °F)] to the largest labeled quantity declared on the container. |
|  |
| 1. Place the spanning bar and depth gage (locked at the surface depth of the paint in the container measured in Step 3.) across the top center of the container. If the point of the depth gage is at or below the surface of the water added in Step 4. assume the container is not short measure. When the audit test indicates that a short measure may exist in the sample container, then use Section 3.7.2.b. “Compliance Test Procedure”. |
| (Added 2019) |

1. Compliance Test Procedure

Use the following procedure when testing rigid containers of paint when they have failed the plant audit test. This procedure is used to test paint or other liquid whether testing is performed inside the plant or at retail.

**Note:** Do not shake or invert the containers selected as the sample.

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot” to determine which “Category A” sampling plan to use; select a random sample.   **Note:** The sample containers shall be identically labeled as to the volume, brand, commodity, color, and lot. The steps noted with an (\*) are required if there is paint adhering to the lid and it cannot be removed by scraping into the container. |
|  |
| 1. Determine the gross weight of these containers and record in Column 2 of the “Example Worksheet for Determing Possible Violation in Checking Paint” (in this section). Select and test the containers in order of the lightest to the heaviest. |
|  |
| 1. Record the labeled volume of the first tare sample package in Column 1 of the worksheet. Place the container on a level surface and use a circular (or appropriately shaped) metal or other solid disk to eliminate deflection in the bottom of the container and remove the lid. If paint clings to the lid of the container, scrape it off with a spatula and place back into the container. |
|  |
| 1. \*If paint that adheres to the lid cannot be completely removed then by scraping the paint into the container, determine the weight of the lid plus any adhering paint. Clean (dry) the paint lid with solvent and weigh again. Subtract the clean (dry) lid weight from the lid weight with paint (wet) to determine the weight of the paint adhering to the lid. Record this weight in Column 3. |
|  |
| 1. Place the spanning bar and depth gage across the top center of the container. Mark the location of the spanning bar on the rim of the container. Lower the depth gage rod until the point touches the paint surface and lock the rod adjustment. |
|  |
| 1. Empty and clean the sample container and lid with solvent; dry and weigh the container and lid. Record the tare weight in Column 5. |
|  |
| 1. Set up the container in the same manner as in Step 3. |
|  |
| 1. Place the spanning bar at the same location on the rim of the paint container as marked in Step 5. With the depth gage set as described in Step 5, deliver water into the container in known amounts until the water reaches the same level occupied by the paint as indicated by the depth gage. Record this volume of water (in mL or fl oz) in Column 6 of the worksheet. This is the volume occupied by the paint in the container. Follow Steps 9a, 10a, and 11a if scraping does not remove the paint from the lid. To determine if gravimetric testing can be used to test the other containers in the sample, follow only Steps 9, 10, and 11 when no paint adheres to the lid. |
|  |
| 1. Subtract the weight of the container (Column 5) from the gross weight (Column 2) to arrive at the net weight of paint in the selected container. Record the net weight in Column 7 of the worksheet. |
|  |
| 9a.\* Subtract the weight of the container (Column 5) and the weight of product on the lid (Column 3) from the gross weight (Column 2) to arrive at the net weight of paint in the container. Record in Column 7 (excluding the weight of the paint on the lid). |
|  |
| 1. Calculate the weight of the labeled volume of paint (for the first container opened for tare).   *net weight (Column 7) × labeled volume (Column 1) ÷ volume of paint in can (Column 6)*  Record this value in Column 8. |
|  |
| 10a.\* Calculate the package volume =  *volume in container (Column 6) + (lid weight [Column 3] ×*  *volume in container [Column 6] ÷ net weight [Column 7])*  Record it in Column 9 of the worksheet. |
|  |
| 1. Calculate the package error. Use the following formula if paint does not adhere to the lid.   *Package error = (Column 6 value) − (labeled volume)* |
|  |
| 11a.\* Use the following formula if paint does adhere to the lid and will not come off by scraping.  *Package error = (Column 9 value)* − *(labeled volume)* |
|  |
| 12. Repeat Steps 2 through 11 for the second package chosen or tare |

(Amended 2010 and 2019)

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Example Worksheet for Determining Possible Violation in Checking Paint**  (add additional rows as needed) | | | | | | | | |
| **1.**  **Labeled Volume** | **2.**  **Gross Weight** | **3.**  **Lid Weight (Wet − Dry)** | **4. Liquid Level** | **5.**  **Tare** | **6.**  **Water Volume** | **7.**  **Net Wt. = 2 − 5** | **8.**  **Weight of Labeled Volume = 7 × 1 ÷ 6** | **9.**  **Package Volume =**  **6 + [(3 ÷ 7) × 6)]** |
|  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |

**Note:** A gravimetric procedure can be used if the weights of the labeled volume for the first two containers do not differ from each other by more than one division on the scale (if they meet this criterion, check the rest of the sample gravimetrically and record in Column 8). The weight of a given volume of paint often varies considerably from container to container; therefore, volumetric measurement may prove necessary for the entire sample using the headspace procedure in Step 8. To determine the volume and enter the Package Volume in Column 9. Proceed to procedures in Section 2.3.7. “Evaluate for Compliance”.

**Note:** To conserve inspection time and reduce destructive testing the inspector may stop testing and consider this test as an audit if the first few containers contain the correct. However, the inspector may continue to test the complete sample to determine the average fill level of the entire sample.

1. Use Section 2.3.6. “Determine Nominal Gross Weight and Package Error” to determine the “Nominal Gross Weight” as follows:

The nominal gross weight equals the sum of the average weight of the labeled volume (average of values recorded in Column 8) plus the average tare (average of values recorded in Column 3) for the containers selected for tare.

### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

(Amended 2019)

## Testing Viscous Materials – Such As Caulking Compounds and Pastes

Use the following procedure for any package of viscous material labeled by volume. It is suitable for very viscous materials such as cartridge-packed caulking compounds, glues, pastes, and other similar products. It is best to conduct this procedure in a laboratory using a hood to ventilate solvent fumes. If used in the field, perform the test in a well-ventilated area. Except for the special measurement procedures to determine the weight of the labeled volume, this procedure follows the basic test procedure.

### Test Equipment

* A scale that meets the requirements in Section 2.2. “Measurement Standards and Test Equipment.”
* Pycnometer (pik·nämˊ ət ər), a vessel of known volume used for weighing semifluids. The pycnometer can be bought or made. If it is made, refer to it as a “density cup.” To make a 150 mL or 5 fl oz density cup, cut off the lip of a 150 mL beaker with an abrasive saw and grind the lip flat on a lap wheel. The slicker plate is available commercially. The metrology laboratory should calibrate the density cup gravimetrically with respect to the contained volume using the procedure as defined by the latest version of ASTM E542, “Standard Practice for Calibration of Laboratory Volumetric Apparatus.”

**Note:** If applicable, comply with any special instructions furnished by the manufacturer to calibrate a pycnometer that has not been calibrated. It is not necessary to reweigh or recalibrate for each test; however, mark the pieces of each unit to prevent interchange of cups and slicker plates.

* Appropriate solvents (water, Stoddard solvent, kerosene, alcohol, etc.)
* Caulking gun (for cartridge packed products)

### Test Procedure

|  |
| --- |
| 1. Follow the procedures in Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; and select a random sample. |
|  |
| 1. Weigh a calibrated pycnometer and slicker plate and record as “pycnometer weight” and record the volume of the pycnometer. |
|  |
| 1. Determine the gross weight of the first package and record the weight value. Open the package and transfer the product to the pycnometer by filling it to excess. Use a caulking gun to transfer product from the caulking cartridges. If using a pycnometer, cover it with a lid and screw the cap down tightly. Excess material will be forced out through the hole in the lid, so the lid must be clean. If using a density cup, place the slicker plate over ¾ of the cup mouth, press down and slowly move the plate across the remainder of the opening. With the slicker plate in place, clean all the exterior surfaces with solvent and dry. |
|  |
| 1. Completely remove the product from the package container; clean the package container with solvent; dry and weigh it to determine the tare weight. |
|  |
| 1. Weigh the filled pycnometer or filled density cup with slicker plate and record this weight. Subtract the weight of the empty pycnometer from the filled weight to determine the net weight of the product contained in the pycnometer and record this weight. |
|  |
| 1. Clean the pycnometer and repeat Steps 3, 4, and 5 for the second package in the tare sample. |
|  |
| 1. Determine acceptability of the density variation on the two packages selected for tare. If the difference between the densities of the two packages exceeds one division of the scale, do not use the gravimetric procedure to determine the net quantity of contents. Instead, use the procedure in steps 9, 10, and 11.   *Weight of Product in Pycnometer* ÷ *Pycnometer Volume* = *Product Density* |
|  |
| **Note:** If the gravimetric procedure can be used, perform Steps 8, 10, and 11 for each package in the sample. |
|  |
| 1. Calculate the weight of product corresponding to the labeled volume of product according to the following formula:   *Product Density* × *Labeled Volume* = *Labeled Weight* |
|  |
| 1. Test each package individually by determining the product density in each package using the pycnometer and record the gross, tare, and net weight of each package. Subtract the weight of the labeled volume (determined for each package) from the net weight of product to arrive at each individual package error in units of weight. |
|  |
| 1. Convert the package errors to units of volume using the following formula: |
|  |
| *Package Error (volume)* =  *(Package Error [weight]* × *Pycnometer Volume)* ÷ *(Weight of Product in Pycnometer)* |
|  |
| 1. Record the package errors on the report form, using an appropriate unit of measure. |

### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

## Peat Moss

### Dim**ensional** Test Procedure for Compressed Quantity

(Added 2015)

#### Test Equipment

* Calculator or spreadsheet Software (programmed to make volume calculations
* Worksheet for Peat Moss Labeled by Volume – Dimensional Procedure (see Appendix C. “Model Inspection Report Forms.”)
* Non-permanent marking pen.
* Knife or razor cutter (for use in opening packages and unwrapping shrink-wrapped pallets in warehouses)
* Cellophane or duct tape (for use in securing packaging tails)
* Dimensional Measuring Frame (see Figure 3-1. “Dimensional Measuring Frame”).



**Figure 3-1. Dimensional Measuring Frame**

* Rigid Rulers ­Starrett[[1]](#footnote-2) or equal with 1.0 mm graduations. The edges of a ruler used with a measuring frame must be straight and the edges must be the zero point (see Figure 3‑1. “Dimensional Measuring Frame”).
  + 304 mm (12 in)
  + 500 mm (19.5 in)
  + 1 m (39 in)
* Carpenter square
  + 304 mm (12 in)
  + 600 mm (24 in)

(Amended 2015)

#### Test Procedure

**Test Notes:**

**Rounding:** When a package measurement falls between graduations on a ruler, round the value up. This practice eliminates the issue of rounding from the volume determination and provides the packager the benefit of the doubt. If a ruler with a graduation of 1.0 mm is used, the rounding error will be limited to 0.5 mm or less. It is good practice to circle a measurement that has been rounded up or make a statement to such effect so that it becomes a part of the record.

**Dimension Identification:** The following package nomenclature is used to identify the dimensions measured in this test procedure (see Figure 3-2. “Dimensional Identification”).



**PDP**

**Figure 3-2. Dimensional Identification**

**Note: Packages of compressed peat moss do not have declaration of expanded volume.**

**Safety Precautions:**

This procedure does not address all of the safety issues that users need to be aware of in order to carry out the following tasks. Users are sometimes required to conduct tests in warehouse spaces or retail stores where forklift trucks are in motion – care must be taken to warn others to avoid or exercise care around the test site. The procedure requires users to lift heavy objects including large bulky packages and test measures and includes the use of sharp instruments to obtain packages from shrink-wrapped pallets. Users may be required to climb ladders or work platforms to obtain sample packages. When opening and emptying packages, dust, or other particles may be present or escape from the packages, which may cause eye injuries and respiratory or other health problems. Users must utilize appropriate safety equipment and exercise good safety practices. If safe working conditions cannot be ensured, suspend testing until the situation is corrected.

1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” Sampling Plan for the inspection. Collect the sample packages from the Inspection Lot using random sampling. If the packages are not randomly selected, the sample will not be representative of the lot and the test results will not be valid for use in enforcement action. Place the sample packages in a location where there is adequate lighting and ample space for the packages and test equipment.

2. Examine the package for excess packaging material (i.e., packaging tails). Fold the packaging material consistent with design of the packaging and tape the material securely to the package so that its effect on the dimensional measurement is minimized. If the thickness of packaging tail appears excessive, it is appropriate to determine its average thickness by making at least three measurements along its length using a dead weight dial micrometer specified in Section 4.5. “Polyethylene Sheeting” and subtract the thickness from the measurement of length, width or height. Any deduction from a measurement should be noted on the inspection report.

3. If a Dimensional Measuring Frame is used, place it on a solid support. If a table is used, select one of sufficient load capacity to hold the weight of the frame and the heaviest package to be tested.

4. Position the frame so that the zero end of the ruler can be placed squarely and firmly against a surface of the frame and so that the ruler graduations can be read. Position yourself so that you can read both the ruler and the edge of the carpenter square in Figure 3-3. “Rigid Frame.”

The rigid frame allows the observer to hold the zero reference point firmly in place.


**Figure 3-3. Rigid Frame. The rigid frame allows the observer to hold the zero reference point firmly in place.**

5. Place the package against two sides of the frame without compressing the package. Place a carpenter square against the package at the point of measurement and align the ruler perpendicular to the edge of the carpenter square as shown in Figure 3-4. “Length Measurement” where the package length and Figure 3-5. “Height Measurement” where the package height are being determined.



**Using a Measuring Frame for Dimensional Testing Ruler and Carpenter Square Define Zero Reference and Measurement Point.**

**Figure 3-4. Length Measurement.**

1. Measurements – take at least five measurements\* of each of the dimensions as follows:

\*On small packages (height or length dimensions of 152 mm [6 in] or less), at least three measurements are taken using the following instructions.

| **Inspect the package for shape and place the flattest surfaces against the measuring frame.** | | |
| --- | --- | --- |
|  | **Length** (see Figure 3-4. “Length Measurement”)   1. Take the first measurement across the center line of the length axis of package. 2. Take the second measurement at half the distance between the center line and either of the package edges. 3. Take the third measurement half the distance between the second measurement and the package edge. 4. Take the fourth measurement on the opposite end of the package at half of the distance between the center line and the package edge. 5. Take the fifth measurement at half of the distance between the fourth measurement and the package edge. | **Fifth**  **Fourth**  **Center** ine  **Second**  **Third**  **Length** |
|  | **Height** (see Figure 3-5. “Height Measurement”):   1. Take the first measurement across the center line of the height axis of the package. 2. Take the second measurement at half the distance between the center line and the package edge. 3. Take the third measurement half the distance between the second measurement and the package edge. 4. Take the fourth measurement on the opposite end of the package at half of the distance between the center line and the package edge. 5. Take the fifth measurement at half of the distance between the fourth measurement and the package edge. | **Center Line**  **Height** |
|  | **Width** (see Figure 3-6. “Width Measurement”): If using one, turn the measuring frame on end and place the package on its bottom and against the frame as shown in the picture and on the right where the package width is being measured.   1. Take the first measurement across the center line of width axis of the package. 2. Take the second measurement at half the distance between the center line and the package edge. 3. Take the third measurement half the distance between the second measurement and the package edge. 4. Take the fourth measurement on the opposite end of the package at half the distance between the center line and the package edge. 5. Take the fifth measurement half of the distance between the forth measurement and the package edge. | **Width**  **Center Line** |



**Figure 3-5. Height Measurement. The packaging tail on the end of the package can affect this measurement so it has been folded over and taped against the end of the package.**

**Figure 3-6. Width Measurement. The frame is rotated on its end to vertical so that the carpenter square does not compress the product.**

7. Record the dimensions of each package in millimeters in a software program or inspection form that includes the information shown in the sample worksheet “Calculate the Compressed Volume of the Package in Liters” (below). Enter the measurements in the appropriate spaces and calculate the volume in liters. Calculate the package error by following the steps listed in the table and then calculate the average error for the sample.

**Note:** The following table is an example of the information from an actual test that is included in a worksheet for verifying the compressed volume on packages of peat moss. The Peat Moss Labeled by Volume Package Worksheet – Dimensional Procedure (see Appendix C. Model Inspection Forms) has space for a sample of 12 packages and includes the steps for calculating the Average Package Error. Here, the package error in the dimensional volume was + 6.8 L (+ 0.24 ft3). To determine the value of the MAV, look up the labeled quantity in Appendix A., Table 2-6. “Maximum Allowable Variations for Packages Labeled by Liquid and Dry Volume.”

| **Sample Worksheet**  **Calculate the Compressed Volume of the Package in Liters** | | | | |
| --- | --- | --- | --- | --- |
| **Unit of Measure = 1.0 mm** | | **Length (L)** | **Width (W)** | **Height (H)** |
|  | **1.** | *482* | *282* | *690* |
|  | **2.** | *490* | *278* | *690* |
|  | **3.** (Center Line) | *493* | *276* | *681* |
|  | **4.** | *499* | *272* | *677* |
|  | **5.** | *493* | *269* | *657* |
| **a.** | **Average:** | *491* | *275.4* | *679* |
| **b.** | **L × W × H = Volume/1 000 000** | *91.8 L* | | |
| **c.** | **Labeled Compressed Quantities:** | *85.0 L* | *NA cu in* | *3.0 cu ft* |
| **d.** | **Conversion Factors** | *NA* | *(b)* × *61.02374* | *(b)* × *0.03531467* |
| **e.** | **Converted Volume** | *85.0 L* | *NA cu in* | *3.24 cu ft* |
| **f.** | **Package Error = (b – c)** | *6.8 L* | *NA cu in* | *0.24 cu ft* |

(Amended 2010 and 2015)

### Uncompressed Volume Packages

Use the following method to test peat moss sold using an uncompressed volume as the declaration of content. The procedure as defined by the latest version of ASTM D2978, “Standard Test Method for Volume of Processed Peat Materials.”

#### Test Equipment

* 12.7 mm (or 1/2 in) sieve
  + Use a measure appropriate for the package size. (Refer to Table 3‑4. “Specifications for Test Measures for Mulch and Soils” for additional information on test measure size and construction.)
* Straight edge, 508 mm (20 in) in length
* Sheet for catching overflow of material
* Level (at least 152 mm [6 in] in length)

(Amended 2015)

#### Test Procedure

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample. |
|  |
| 1. Open each package and pour the contents from a height of 2 ft through the sieve directly into the measuring container (overfilling it). Use this method for particulate solids (such as soils or other garden materials) labeled in cubic dimensions or dry volume. Some materials may not pass through the sieve for peat moss; in these instances, separate the materials by hand (to compensate for packing and settling of the product after packaging) before filling the measure. |
|  |
| **Note:** Separated material (product not passing through the sieve) must be included in the product volume. |
|  |
| 1. Shake the measuring container with a rotary motion at one rotation per second for five seconds. Do not lift the measuring container when rotating it. If the package contents are greater than the measuring container capacity, level the measuring container contents with a straightedge using a zigzag motion across the top of the container. |
|  |
| 1. Empty the container. Repeat the filling operations as many times as necessary, noting the partial fill of the container for the last quantity delivered using the interior horizontal markings as a guide. |
|  |
| 1. Record the total volume. |
|  |
| 1. To compute each package error, subtract the labeled quantity from the total volume and record it. |

(Amended 2015)

### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance for either procedure.

(Amended 2015)

## Mulch and Soils Labeled by Volume

Mulch is defined as “any product or material except peat or peat moss that is advertised, offered for sale, or sold for primary use as a horticultural, above-ground dressing, for decoration, moisture control, weed control, erosion control, temperature control, or other similar purposes.”

Soil is defined as “any product or material, except peat or peat moss that is advertised or offered for sale, or sold for primary use as a horticultural growing media, soil amendment, and/or soil replacement.”

### Test Equipment

* A test measure appropriate for the package size that meets the specifications for test measures in Table 3‑4. “Specifications for Test Measures for Mulch and Soils”
* Drop cloth/polyethylene sheeting for catching overflow of material
* Level (at least 152 mm [6 in] in length)

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **Table 3-4.**  **Specifications for Test Measures for Mulch and Soils** | | | | | | |
| **Nominal  Capacity of Test Measure4** | **Actual Volume of  the  Measure4** | **Interior Length1** | **Interior  Width1** | **Interior**  **Height2** | **Marked  Intervals  on Interior  Wall3** | **Volume  Equivalentof Marked  Intervals** |
| 30.2 L  (1.07 cu ft)  for testing packages that contain less than 28.3 L  (1 cu ft or  25.7 dry qt) | 31.9 L  (1.13 cu ft) | 213.4 mm  (8.4 in) | 203.2 mm  (8 in) | 736.6 mm  (29 in) | 12.7 mm  (1/2 in) | 550.6 mL  (33.6 in3) |
| 28.3 L  (1 cu ft) | 33.04 L  (1.16 cu ft) | 304.8 mm  (12 in) | 304.8 mm  (12 in) | 355.6 mm  (14 in) | 1179.8 mL  (72 cu in) |
| 406.4 mm  (16 in) | 228.6 mm  (9 in) |
| 56.6 L  (2 cu ft) | 63.7 L  (2.25 cu ft) | 304.8 mm  (12 in) | 304.8 mm  (12 in) | 685.8 mm  (27 in) |
| 406.4 mm  (16 in) | 228.6 mm  (9 in) | 685.8 mm  (27 in) |
| 84.9 L  (3 cu ft) | 92 L  (3.25 cu ft) | 304.8 mm  (12 in) | 304.8 mm  (12 in) | 990.6 mm  (39 in) |
| 406.4 mm  (16 in) | 228.6 mm  (9 in) | 990.6 mm  (39 in) |
| Measures are typically constructed of 1.27 cm (1/2 in) marine plywood.  The measure must accommodate the entire contents of the package being tested, and a transparent sidewall is useful for determining the level of fill, but must be reinforced if it is not thick enough to resist distortion. If the measure has a clear front, place the level gage at the back (inside) of the measure so that the markings are read over the top of the mulch.  **Notes**  1Other interior dimensions are acceptable if the test measure approximates the configuration of the package under test, can accommodate the entire contents of the package at one time and does not exceed a base configuration of the package cross-section.  2The height of the test measure shall be 355.6 mm (14 in) for a 1 cu ft package, 685.8 mm (27 in) for a 1.5 cu ft to 2 cu ft package or 990.6 mm (39 in) for a 3 cu ft package.  3When lines are marked in boxes, they should extend to all four sides of the measure, if possible to improve readability. It is recommended that a line indicating the MAV level also be marked to reduce the possibility of reading errors when the level of the mulch is at or near the MAV.  4The Nominal Capacity is given to identify the size of packages that can be tested in a single measurement using the dry measure with the listed dimensions. It is based on the most common package sizes of mulch in the marketplace. If the measures are built to the dimensions shown above the actual volume will be larger than the nominal volume so that plus errors (overfill) can be measured accurately. | | | | | | |

(Amended 2010 and 2017)

### Test Procedure

1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection, and select a random sample.

2. Some types of mulch are susceptible to clumping and compacting. To ensure that the material is loose and free flowing when placed into the test measure, gently massage the package while rolling the bag on the ground (or flat surface) at least four full rotations (but not more than eight full rotations), without lifting or dropping the package, before opening to reduce the clumping and compaction of the material.

**Note:** Mulch products stored exposed to the elements may become saturated with moisture. Excessive moisture adds weight to mulch particles and distorts the volume test results. Test samples with flowing or excessive collected moisture in the package shall be excluded from the test procedure.

1. Placing contents into the test measure.

* Open the bag, gather the bag opening to ensure that no product is lost. Place the gathered bag opening as far into the top of the measure as possible without disturbing or leaning against the measure.
* Release the bag opening and quickly dump the contents of the package into a test measure in a continuous flow.

**Note:** Do not touch the product or disturb the test measure by rocking, shaking, dropping or tamping it during the test procedure.

* Massage the outside of the bag to maintain a continuous flow of the product but not for the purpose of de-clumping the product.
* Using your hand, gently level the contents, being careful not to affect the compaction of the product.

1. Read the horizontal marks at a position level with the product and round the readings between two marked intervals up to the nearest 38.1 mm (1/2 in) increment to determine the package net volume.
2. Determine package errors by subtracting the labeled volume from the package net volume in the measure. Record each package error.

*Package Error* = *Package Net Volume* − *Labeled Volume*

(Amended 2017)

### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

**Note:** In accordance with Appendix A, Table 2‑10. “Exceptions to the Maximum Allowable Variations for Textiles, Polyethylene Sheeting and Film, Mulch and Soil Labeled by Volume, Packaged Firewood and Stove Wood Labeled by Volume, and Packages Labeled by Count with 50 Items or Fewer, and Specific Agricultural Seeds Labeled by Count”, apply an MAV of 5 % of the declared quantity to mulch and soil sold by volume. When testing mulch and soil with a net quantity in terms of volume, one package out of every 12 in the sample may exceed the 5 % MAV (e.g., one in a sample of 12 packages; two in a sample of 24 packages; four in a sample of 48 packages). However, the sample must meet the average requirement of the “Category A” Sampling Plan.

## Ice Cream Novelties

Note: The following procedure can be used to test packaged products that are solid or semisolid and that will not dissolve in, mix with, absorb, or be absorbed by the fluid into which the product will be immersed. For example, ice cream labeled by volume can be tested using ice water or kerosene as the immersion fluid.

Exception: Pelletized ice cream is beads of ice cream which are quick frozen with liquid nitrogen. The beads are relatively small, but can vary in shape and size. On April 17, 2009, the FDA issued a letter stating that this product is considered semisolid food, in accordance with 21 CFR 101.105(a). The FDA also addresses that the appropriate net quantity of content declaration for pelletized ice cream products be in terms of net weight.

(Added 2010)

The following volume displacement procedure uses a displacement vessel specifically designed for ice cream novelties such as ice cream bars, ice cream sandwiches, or cones. The procedure determines the volume of the novelty by measuring the amount of water displaced when the novelty is submerged in the vessel. Two displacements per sample are required to subtract the volume of sticks or cups.

The procedure first determines if the densities of the novelties are the same from package to package (in the same lot) so that a gravimetric test can be used to verify the labeled volume. If a gravimetric procedure is used, compute an average weight for the declared volume from the first two packages and weigh the remainder of the sample. If the gravimetric procedure cannot be used, use the volume displacement procedure for all of the packages in the sample.

### Test Equipment

* A scale that meets the requirements in Section 2.2. “Measurement Standards and Test Equipment”
* Volumetric measures
* Displacement vessel with dimensions appropriate for the size of novelties being tested (see Figure 3-7, “Example of a Displacement Vessel”). It should include an interior baffle that reduces wave action when the novelty is inserted and a downward angled overflow spout to reduce dripping. Other designs may be used.



**Figure 3-7. Example of a Displacement Vessel.**

**Note:** This displacement vessel can be constructed or similar devices may be obtained from any laboratory equipment or science education supplier. The U.S. Department of Commerce does not endorse or recommend any particular device over similar commercially available products from other manufacturers.

* Thin wire, clamp, or tongs
* Freezer or ice chest and dry ice
* Single-edged razor or sharp knife (for sandwiches only)
* Ice water/kerosene maintained at 1 °C (33 °F) or below
* Indelible marker (for ice pops only)
* Level, at least 152 mm (6 in) in length
* A partial immersion thermometer (or equivalent) with a range of − 1 °C to + 50 °C (30 °F to 120 °F), at least 1 °C (1 °F) graduations, and with a tolerance of ± 1 °C (± 2 °F)
* A table top, laboratory-type jack of sufficient size to hold the displacement vessel
* Stopwatch

### Test Procedure

|  |  |
| --- | --- |
| 1. Follow the procedures in Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; and select a random sample. | |
|  | |
| 1. Maintain the samples at the reference temperature for frozen products that is specified in Table 3‑1. “Reference Temperatures for Liquids.” Place the samples in the freezer or ice chest until they are ready to be tested, and then remove packages from the freezer one at a time. | |
|  | |
| 1. According to the type of novelty, prepare the sample products as follows: | |
|  | |
| * \***Ice-pop**. Mark on the stick(s) with the indelible marker the point to which the ice-pop will be submerged in the ice water. (After the ice-pop contents have been submerged, remove the novelty to determine the volume of the stick.) | |
|  | |
| * \***Cone**. Make a small hole in the cone below the ice cream portion to allow air to escape. | |
|  | |
| * **Sandwich**. Determine whether the declared volume is (a) the total volume of the novelty (that is, including the cookie portion) or (b) the volume of the ice-cream-like portion only. If the declared volume is the volume of only the ice-cream-like portion, shave off the cookie with a razor or knife, leaving some remnants of cookie to ensure that no ice cream is accidentally shaved off. Work quickly, and return the novelty to the freezer before the sandwich softens. | |
|  | |
| * **Cup**. Remove the cap from the cup. | |
|  |
| 1. Fill the displacement vessel with ice water until it overflows the spout. Allow it to sit until dripping stops. Raise the displacement vessel as necessary and place the graduate beneath the spout. |
|  |
| 1. Remove a package from the freezer, determine its gross weight, and record it. |
|  |
| 1. Submerge the novelty as suggested until it is below the surface level of the water. |
| * + **Ice-pop**. Use a clamp, tongs, or your fingers to hold the stick(s) and submerge the ice-pop to the level marked in Step 3 of the Test Procedure. |
| * + **Cone**. Shape the wire into a loop, and use it to push the cone, headfirst (ice cream portion first) into the ice water. Do not completely submerge the cone immediately: let water fill the cone through the hole made in Step 3 of the Test Procedure before completely submerging the novelty. |
| * + **Sandwich or cup**. Skewer the novelty with the thin wire or form a loop on the end of the wire to push the sandwich or ice cream portion or cup completely below the liquid level. |
|  |
| 1. Record the total water volume in the graduate.  * For a cone or sandwich, record the water volume as the net volume and go to Step 9. * For ice-pops or cups, record the water volume in the graduate as the gross volume and go to Step 8. |
| 1. Refill the displacement vessel with water to overflowing and reposition the empty graduate under the spout. After the cup and novelty contents have been submerged, remove the novelty from the cup to determine the volume of the cup. |
|  |
| * **Ice-pop**. Melt the ice-pop off the stick or sticks. Submerge the stick or sticks to the line marked in Step 3. Record the volume of tare material (i.e., stick) by measuring the water displaced into the graduate. The net volume for the ice-pop is the gross volume recorded in Step 7 minus the volume of the tare materials in this step. Record this volume as the “volume of novelty.” To determine the error in the package, subtract the labeled quantity from the volume of novelty. |
|  |
| * **Cup**. Remove the novelty from the cup. Rinse the cup, and then submerge it in the displacement vessel. Small pinholes in the base of the cup can be made to make submersion easier. Record the volume of water displaced into the graduate by the cup as the volume of tare material. The net volume for the novelty is the gross volume determined in Step 7 minus the volume of the tare materials determined in this step. Record this as the net volume of the novelty. To determine the error in the package, subtract the labeled quantity from the volume of novelty. |
|  |
| 1. Clean and air-dry the tare materials (sticks, wrappers, cup, lid, etc.). Weigh and record the weight of these materials for the package. |
|  |
| 1. Subtract the tare weight from the gross weight to obtain the net weight and record this value. |
|  |
| 1. Compute the weight of the labeled volume for the package using the following formula and then record the weight:   *Product Density* = *(product net weight in Step 10)* ÷ *(the total water volume in Step 7* – *volume of tare material in Step 8)*  *Weight of labeled volume* = *(labeled volume)* × *(Product Density)* |
|  |
| 1. Repeat Steps 3 through 11 for a second package. |
|  |
| 1. If the weight of the labeled volumes in Step 11 for the two packages differs from each other by more than one division on the scale, the gravimetric test procedure cannot be used to test the sample for compliance. If this is the case, use Steps 3 through 8 for each of the remaining packages in the sample to determine their net volumes and package errors. Then go to evaluation of results. If the weights of the labeled volumes agree within one division, continue to Step 14 to test the rest of the sample using the gravimetric test procedure.\* |
|  |
| 1. Use Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight” to determine the Average Used Dry tare Weight of the sample. |
|  |
| 1. Find the Average Product Density by adding the densities of the product from the two packages and dividing the sum by two. |
|  |
| 1. Using the weight of labeled volume determined in Step 11, calculate the Average Product Weight by multiplying the weight of the labeled volume by the average product density.   *\*Average Product Weight* = *Labeled Volume* × *Average Product Density* |
|  |
| 1. Calculate the “nominal gross weight” using the formula:   *Nominal Gross Weight* = *Average Product Weight* + *Average Used Dry Tare Weight* |
|  | |
| 1. Weigh the remaining packages in the sample. | |
|  | |
| 1. Subtract the nominal gross weight from the gross weight of each package to obtain package errors in terms of weight. | |
|  | |
| **Note:** Compare the sample packages to the nominal gross weight. | |
|  | |
| 1. Determine the average package error by totaling all package errors and dividing by the number of packages in the sample. | |
|  | |
| To convert the average error or package error from weight to volume, use the following formula: | |
|  | |
| *Package Error in Volume* = *(Package Error in Weight)* ÷ *(Average Product Density)* | |
|  | |

### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

## Fresh Oysters Labeled by Volume

Packaged fresh oysters removed from the shell must be labeled by volume. The maximum amount of permitted free liquid is limited to 15 % by weight. (see NIST Handbook 130, Method of Sale of Commodities, Section 1.5.2.3. “Fresh Oysters Removed From Shell.”) Testing the quantity of contents of fresh oysters requires the inspector to determine total volume, total weight of solids and liquid, and the weight of the free liquid.

### Test Equipment

* A scale that meets the requirements in Section 2.2. “Measurement Standards and Test Equipment”
* Volumetric measures
* Micrometer depth gage (ends of rods fully rounded), 0 mm to 228 mm (0 in to 9 in)
* Strainer for determining the amount of drained liquid from shucked oysters. Use a strainer and a slightly smaller bottom receiving pan or tray constructed to the following specifications:
  + Sides: 50 mm (2 in)
  + Area: 1935 cm2 (300 in2) or more for each 3.78 L (1 gal) of oysters

**Note:** Strainers of smaller area dimensions are permitted to facilitate testing smaller containers.

* + Perforations:

Diameter: 6.35 mm (1/4 in)

Location: 3.17 cm (11/4 in) apart in a square pattern, or perforations of equivalent area and distribution.

* Spanning bar, 25.4 mm × 25.4 mm × 304 mm (1 in × 1 in × 12 in)
* Rubber spatula
* Partial immersion thermometer, 1 °C (2 °F) graduations and a range of – 35 °C to + 50 °C (− 30 °F to + 120 °F) accurate to ±1 °C (±2 °F)
* Level, at least 152 mm (6 in) in length
* Stopwatch

(Amended 2014)

### Test Procedure

**Note:** Test the oysters at a temperature of 7 °C (± 1 °C) (45 °F [± 2 °F])

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; and select a random sample. |
|  |
| 1. Determine and record the gross weight of a sample package. |
|  |
| 1. Set the container on a level surface and open it. Use a depth gage to determine the level of fill. Lock the depth gage. Mark the location of the gage on the package. |
|  |
| 1. Weigh a dry receiving pan and record the weight. Set strainer over the receiving pan. |
|  |
| 1. Pour the contents from the container onto the strainer without shaking it.  Drain for two minutes. Remove strainer with oysters. It is normal for oysters to include mucous (which is part of the product) that will not pass through the strainer, so do not force it. |
|  |
| 1. Weigh the receiving pan and liquid and record the weight. Subtract the weight of the dry receiving pan from the weight of pan and liquid to obtain the weight of free liquid and record the value. |
|  |
| 1. Clean, dry, and weigh the container and record the tare weight. Subtract the tare weight from the gross weight to obtain the total weight of the oysters and liquid and record this value. |
|  |
| 1. Determine and record the percent of free liquid by weight as follows:   **Note:** This handbook provides a worksheet for Determining the Free Liquid and Net Volume of Oysters in Appendix C. “Model Inspection Report Forms.”  *Percent of free liquid by weight* = *[(weight of free liquid)* ÷*(weight of oysters* + *liquid)]* ×*100*  *or*  *(f* ÷ *c)* × *100* = *Percentage of Free Liquid by Weights*  *Where:*  *f* = *Weight of Free Liquid*  *c* = *(Net Weight of Oysters* + *Liquid)* |
|  |
| 1. Set up the depth gage on the dry package container as in Step 3. Pour water from the flasks and graduate as needed to re-establish the level of fill obtained in Step 3. Add the volumes delivered as the actual net volume for the container and record the value. |
|  |

**Note:** Some containers will hold the declared volume only when filled to the brim; they may have been designed for other products, rather than for oysters. If the net volume is short measure (per Step 9), determine if the container will reach the declared volume only if filled to the brim. Under such circumstance, the package net volumes will all be short measure because the container cannot be filled to the brim with a solid and liquid mixture. A small headspace is required in order to get the lid into the container without losing any liquid.

(Amended 2014)

### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

## Determining the Net Contents of Compressed Gas in Cylinders

These procedures are for industrial compressed gas. Compressed gas may be labeled by weight (for example, Liquefied Petroleum [LP] gas, or carbon dioxide) or by volume. Acetylene, liquid oxygen, nitrogen, nitrous oxide, and argon are all filled by weight. Acetylene is sold by liters or by cubic feet. Helium, gaseous oxygen, nitrogen, air, and argon are filled according to pressure and temperature tables.

Checking the net contents of compressed gas cylinders depends on the method of labeling; those labeled by weight are generally checked by weight. Cylinders filled by using pressure and temperature charts must be tested using a pressure gage that is connected to the cylinder. The volume is determined using the pressure and temperature of the cylinder.

**Safety Precautions:**

Be aware of the hazards of the high pressure found in cylinders of compressed gas. An inspector should handle compressed gas only if the inspector has been trained and is knowledgeable regarding the product, cylinder, fittings, and proper procedures (see *Compressed Gas Association [CGA] pamphlet P‑1, “Safe Handling of Compressed Gases in Containers*,” for additional information). Additional precautions that are necessary for personal safety are described in the CGA Handbook of Compressed Gases. All personnel testing compressed gases should have this manual for reference and be familiar with its contents. It is essential that the inspector be certain of the contents before connecting to the cylinder. Discharging a gas or cryogenic liquid through a system for which the material is not intended could result in a fire and/or explosion or property damage due to the incompatibility of the system and the product. Before connecting a cylinder to anything, be certain of the following:

|  |
| --- |
| 1. Always wear safety glasses. |
|  |
| 1. The cylinder is clearly marked or labeled with the correct name of the contents and that no conflicting marks or labels are present. Do not rely on the color of the cylinder to identify the contents of a cylinder. Be extremely careful with all gases because some react violently when mixed or when coming in contact with other substances. For example, oxygen reacts violently when it comes in contact with hydrocarbons. |
|  |
| 1. The cylinder is provided with the correct Compressed Gas Association (CGA) connection(s) for the product. A proper connection will go together smoothly; so excessive force should not be used. Do not use an adapter to connect oxygen to non-oxygen cleaned equipment. When a cylinder valve is opened to measure the internal pressure, position the body away from the pressure gage blowout plug or in front of the gage if the gage has a solid cast front case. If the bourdon tube should rupture, do not be in a position to suffer serious injuries from gas pressure or fragments of metal. |
|  |
| **Note:** The acetone in acetylene cylinders is included in the tare weight of the cylinder. Therefore, as acetylene is withdrawn from the cylinder, some acetone will also be withdrawn, changing the tare weight. |
|  |
| 1. Thoroughly know the procedure and place emphasis on safety precautions before attempting any tests. Do not use charts referred to in the procedure until the necessary training has been completed. When moving a cylinder, always place the protective cap on the cylinder. Do not leave spaces between cylinders when moving them. This can lead to a “domino” effect if one cylinder is pushed over. |
|  |
| 1. Open all valves slowly. A failure of the gage or other ancillary equipment can result in injuries to nearby persons. Remember that high gas pressure can propel objects with great force. Gas ejected under pressure can also cause serious bodily injuries if someone is too close during release of pressure. |
|  |
| 1. One of the gages will be reserved for testing oxygen only and will be prominently labeled “For Oxygen Use Only.” This gage must be cleaned for oxygen service and maintained in that “clean” condition. The other gage(s) may be used for testing a variety of gases if they are compatible with one another. |
|  |
| 1. Observe special precautions with flammable gas in cylinders in addition to the several precautions necessary for the safe handling of any compressed gas in cylinders. Do not “crack” cylinder valves of flammable gas before connecting them to a regulator or test gage. This is extremely important for hydrogen or acetylene. |

### Test Equipment

* Scale that meets the requirements in Section 2.2. “Measurement Standards and Test Equipment.” Use a wooden or non-sparking metal ramp to roll the cylinders on the scale to reduce shock loading.
* Two calibrated precision bourdon tube gages or any other approved laboratory-type pressure-measuring device that can be accurately read within plus or minus 40 kPa (5 psi). A gage having scale increments of 200 kPa (25 psi) or smaller shall be considered as satisfactory for reading within plus or minus 40 kPa (5 psi). The range of both gages shall be a minimum of 0 kPa to 23 MPa (0 psi to 5000 psi) when testing cylinders using standard industrial cylinder valve connections. These standardized connections are listed in “*CGA Standard V‑1, Standard for Compressed Gas Cylinder Valve Outlet and Inlet Connections for use with Gas Pressures up to 21 MPa (3000 psi)*.” For testing cylinders with cylinder valve connections rated for over 21 MPa (3000 psi), the test gage and its inlet connection must be rated at 14 MPa (2000 psi) over the maximum pressure that the connection is rated for in CGA V‑1.

**Notes:**

1. There are standard high-pressure industrial connections on the market that are being used up to their maximum pressure of 52 MPa (7500 psi).
2. Any gage or connectors used with oxygen cylinders must be cleaned for oxygen service, transported in a manner which will keep them clean and never used for any other gas including air or oxygen mixtures. Oxygen will react with hydrocarbons and many foreign materials that may cause a fire or explosion.
3. Use a separate gage and fitting for each gas to be tested. If adapters must be used, do not use on oxygen systems.

* An approved and calibrated electronic temperature measuring device or three calibrated liquid-in-glass thermometers having either a digital readout or scale division of no more than 1 °F (0.5 °C). The electronic device equipped with a surface temperature sensor is preferred over a liquid-in-glass thermometer because of its shorter response time.
* Two box-end wrenches of 29 mm (11/8 in) for oxygen, nitrogen, carbon dioxide, argon, helium, and hydrogen and 22 mm (7/8 in) for some sizes of propane. All industrial CGA connections are limited to these two hex sizes. Avoid using an adjustable wrench because of the tendency to round the edges of the fittings, which can lead to connections not being tightened properly.

### Test Procedures

1. Test Procedure for Cylinders Labeled by Weight

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample. |
|  |
| 1. The cylinder should be marked or stenciled with a tare weight. The marked value may or may not be used by the filling plant when determining the net weight of those cylinders sold or filled by weight. If there is a tare weight marked on the net contents tag or directly on the cylinder, then an actual tare weight was determined at the time of fill. If there is no tare weight marked on a tag or on the cylinder, then the stamped or stenciled tare weight is presumed to have been used to determine the net contents. |
|  |
| **Note:** Check the accuracy of the stamped tare weights on empty cylinders whenever possible. The actual tare weight must be within (a) 1/2 % of the stamped tare weight for 9.07 kg (20 lb) tare weights or less or (b) 1/4 % of the stamped tare weight for greater than 9.07 kg (20 lb) tare weights. (see NIST Handbook 130, Method of Sale Regulation, Section 2.16. “Compressed or Liquefied Gases in Refillable Cylinders.”) The cap is not included in the tare weight. |
|  |
| 1. Place cylinder on scale and remove protective cap. Weigh the cylinder and determine net weight, using either the stamped or stenciled tare weight, or the tare weight marked on the tag. Compare actual net weight with labeled net weight, or use the actual net weight to look up the correct volume declaration (for Acetylene Gas), and compare that with the labeled volume. |
|  |
| **Note:** Most producers will replace acetone in the cylinder before the cylinder is refilled, filling the cylinder with acetone to the stamped tare weight. Other producers, although not following recommended procedures, do not replace the acetone until it drops to a predetermined weight. In the latter situation, the refilling plant must note the actual tare weight of the cylinder and show it on the tag containing the net content statement or on the cylinder itself. Refer to tables for acetylene if necessary (if the acetylene is labeled by volume). |
|  |

1. Test Procedure for Cylinders Labeled by Volume
   * + 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample.
       2. Determine the temperature of the cylinders in the sample. Place the thermometer approximately halfway up a cylinder in contact with the outside surface. Take the temperature of three cylinders selected at random and use the average temperature of the three values.
       3. Using the appropriate pressure gage, measure the pressure of each cylinder in the sample.
       4. Determine the cylinder nominal capacity from cylinder data tables or from the manufacturer. (These tables must be obtained in advance of testing.)
       5. The SCF/CF volume of compressed gases (e.g., oxygen, argon, nitrogen, helium, or hydrogen) shall be determined using NIST Standard Reference Database 23 “Reference Fluid Thermodynamic and Transport Properties Database” (REFPROP). (see [www.nist.gov/srd/refprop](https://www.nist.gov/srd/refprop)) (**Note:** Weights and measures officials should contact the NIST Office of Weights and Measures at (301) 975-4004 or [**owm@nist.gov**](mailto:owm@nist.gov) for access to the database.)
       6. Multiply the cylinder nominal capacity by the value (SCF/CF) obtained from the content tables. This is the actual net quantity of gas.
       7. Subtract the labeled net quantity from the actual net quantity to determine the error.

### Evaluation of Results

Follow Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

## Firewood – Volumetric Test Procedure for Packaged Firewood with a Labeled Volume of 113 L [4 ft3] or Less and Stacked Firewood Sold by the Cord or Fractions of a Cord.

Unless otherwise indicated, take all measurements without rearranging the wood or removing it from the package. However, if the layers of wood are crosshatched or not ranked in discrete sections in the package, remove the wood from the package, re-stack, and measure according to the procedures described in this section. For boxed firewood, it is the volume of the wood in the box that is determined not the volume of the box.

(Amended 2016)

### Test Equipment

|  |  |  |
| --- | --- | --- |
| **Linear Measurement**  The maximum value of graduations on a ruler or tape shall be equal to or less than: | | |
| **For Testing** | **SI Units** | **U.S. Customary Units** |
| Packaged Firewood | 1 mm | 1/16 in (0.0625 in) |
| Stacked Firewood | 0.5 cm | 1/8 in (0.125 in) |

**Other Equipment:**

Except where a long tape measure is needed for measuring stacks of wood and unless otherwise noted below, a precision tempered steel ruler should be used for linear measurements. Current calibration certificates issued by a NIST recognized or accredited laboratory should be available for all measuring devices.

* To test boxes of firewood, use a straightedge and a 150 mm (6 in) tempered steel pocket ruler to measure the box headspace. A rigid 610 mm (24 in) tempered steel ruler is required to measure piece length and the dimensions of the box.
* To test bundles of firewood, use a rigid 610 mm (24 in) tempered steel ruler to measure typical piece length. If the circumference based auditing method is to be conducted, a precision 610 mm (24 in) diameter (pi) tape or flexible steel tape with 1 mm (1/16 in) graduations may be used to approximate the package volume for screening and audit purposes.

For testing stacks of firewood, a precision tape or long tape measure is used. For testing bundles and bags of firewood, the following equipment and materials are used in addition to the linear measures listed above:

* Binding Straps: Straps with ratchet type closures are easily tightened to secure the wood tightly.The binding straps are used to hold wood bundles together if the bundles need to be removed from the package/wrapping material.
* Graph Paper: 279.4 mm × 431.8 mm (11 in × 17 in) with 0.5 centimeter or 1/4 inch squares. This paper is used for tracing and calculating the areas of the ends of a bundle of firewood. Prior to using any graph paper use a calibrated ruler to verify the dimensions of squares at several random points across the page.
  + Ruler: 300 mm (12 in) with 0.5 cm (1/4 in) graduations. This ruler is used with the graph paper to calculate the area of the bundle ends.

(Amended 2016)

### Test Procedure

**General Instructions**

* When testing packaged firewood Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; and select a random sample.
* Measurements shall be read to the smallest graduation on the ruler or tape. Round any value that falls between two graduations up to the higher value except when making headspace depth measurements in the test procedure for boxes where a value falling between two graduations is rounded down.
* Samples for Length. Use Table 3-5. “Minimum Number of Pieces to be Measured for Length” to determine the minimum number of pieces to measure to determine the average length of the firewood pieces in a package or stack.

|  |  |  |
| --- | --- | --- |
| **Table 3-5.**  **Minimum Number of Pieces to be Measured for Length** | | |
|  | **Volume** | **Minimum Number of Pieces to be Measured for Length\*** |
| 1. | Packaged firewood 453 L (16 cu ft) (1/8 cord) or less |
| a. | For packages with 12 pieces or less | All |
| b. | For packages with 13 to 50 pieces | At least 12 pieces |
| c. | For packages with more than 50 pieces | At least 24 pieces |
| 2. | Stacked wood | At least 12 pieces for each 1/2 cord or fraction thereof |
| \***Note:** While the packages of firewood to be included in the sample must be selected using the random sampling techniques described in NIST Handbook 133, Section 2.3.4. “Random Sample Selection,” those techniques are not used in selecting the individual pieces for measurement of length. Since the packages were selected at random, the assumption is made that the length of any piece selected for measuring is generally representative of the other pieces that the packer cut or selected for inclusion in the package under inspection. When selecting pieces of wood for measurement, take them from different locations in the package or stack so they are representative of the total amount of wood under test. | | |

* Measuring Procedures for Length. Use the instructions and graphics in Table 3-6. “Determining Piece Length” when measuring the length of the pieces to determine the average length of a piece of firewood based on its shape in a package or stack. If a piece of wood does not appear to fall within the examples shows, measure it as if it were an irregular shape and take three or more measurements and average them.

| **Table 3-6.  Determining Piece Length** |
| --- |
| 1. **Uniform Shapes**   Errors in the length measurement can result in a significant volume errors especially with the small quantities typical of packaged wood. When the pieces are generally cut in a uniform manner, a single measurement along the center line of the longitudinal axis is used to determine piece length. Take the measurement along a straight line between two points over solid wood. |
| * + - 1. Most wood pieces are cut perpendicular to their longitudinal axis so one measurement taken from the face of one end to the face of the other end will provide an accurate length determination. |
| (ii) On pieces of wood with “reverse bias” and “bias” end cuts estimate where the center line of the piece is and then measure to these points as shown below. The intent of this measurement is to determine an “average” length that is assumed to fall along the center line of the piece. The top piece is an example of a “reverse” bias cut.  The bottom piece is an example of a bias cut |
| 1. **Irregular Shapes**   When the pieces have irregular shapes, cuts, or shattered ends, it is necessary to take at least three measurements and average the results to obtain the length of the piece. Take the measurements along a straight line between two points which cover solid wood that appear to be the shortest and longest dimensions and a third measurement at or near the center line of the piece. |
| (iii) This piece has a bias cut end on the left and an irregular end on the right. The measurements are taken at the longest and shortest points where the line crosses over solid wood. The lowest measurement (dotted line over the air space) is not used because it does not cross wood. Only the three upper measurements are used to calculate the average length for this piece unless additional measurements across solid wood are taken. |
| (iv) This is a piece with a bias cut on the left end and irregular end on the right. Note how the measurements are taken at the longest and shortest points where the line crosses over solid wood. The lowest measurement (the dotted line) would not be used because it does not crossover wood. |
| (v) This piece of wood has a “shattered end.” Shattering occurs when wood is stressed beyond its breaking point and the end is not trimmed. The inspector will take additonal measurements to account at the shortest point of the voids and longest points at the extensions. In this example, five measurements were taken and averaged to account for the voids and extensions. |

1. Boxed Firewood

**Note:** A packer may place wrapped bundles of firewood in boxes for ease of handling as well as for display on retail store shelves. When a box contains a bundle of wrapped firewood, the volume of the bundle is verified using the test procedure in c. “Bundled and Bagged Firewood.”

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; and select a random sample. |
|  |
| 1. Open the box to determine the average height of wood. |
|  |
| 1. Measure the internal height of the box. (see Figure 3-8. “Measuring the Internal Height of the Box.”) |

|  |
| --- |
| Photo showing the box (packaging) for the firewood being measured for height with a rigid rule.  **Figure 3-8. Measuring the Internal Height of the Box.** |

|  |
| --- |
| 1. Determining the Height of the Wood. Take at least five measurements spaced at intervals along each end and center of the wood stack (record as “d1, d2. . .etc.; taking at least 15 measurements). (see Figure 3-9. “Top View of the Box” – Measure at cross bars and Figure 3‑9a. “Examples of the Headspace Measurement.”) Measure from the bottom of a straightedge placed across the top of the box to the highest point on the wood (round the measurements down to the nearest 0.5 cm [1/8 in] or less). Calculate the average height of the stack by averaging these measurements and subtracting the result from the internal height of the box using the following formula:   *Average Height of Wood Stack* =  *(Internal Height of Box)* − *(Sum of Depth Measurements* ÷ *Number of Measurements)* |

**Figure 3-9. Top View of the Box. Measure at the cross bars.**

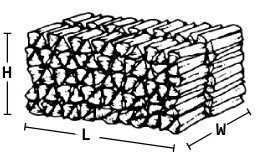
|  |  |
| --- | --- |
|  | Two photos exhibiting how to measure headspace in a package/box of wood. |
| **Figure 3-9a. Examples of the Headspace Measurement.** | |
| 5. Width of Wood Stack. Open the box and measure the width of the wood stack. Take at least five measurements at intervals spaced along the length of the stack. Average these values to obtain an Average Width of Wood Stack. (see Figure 3-10. “Top View of the Box,” and Figure 3-10a. “Measuring the Width of the Firewood in a Box.”) You are measuring the width of the wood, not the width of the box.  Average Width of Wood Stack = (W1 + W2 + W3 + W4 + W5) ÷ 5 | |
| **Figure 3-10. Top View of the Box. Measure at crosslines.** | |

|  |  |
| --- | --- |
| **Figure 3-10a. Measuring the Width of the Firewood in a Box.** | **Photo of a measurement beinging taken of the box containing firewood.** |
| 6. Individual Piece Length. Remove the wood from the package and measure the length of each piece of wood (see Table 3-5. “Minimum Number of Pieces to be Measured for Length”). If the piece of wood is uniform in shape, take at least one point-to-point measurement along the center line of the longitudinal axis (see Table 3-6. “Determining Piece Length, (a) Uniform Shapes” for examples) and record the value.  If the wood is irregularly shaped (see Table 3-6. “Determining Piece Length, (b) Irregular Shapes” for examples), take at least three measurements along a straight line between two points crossing solid wood that appear to be the shortest and longest dimensions, and a third at or near the center line of the piece. Calculate the average of the measurements to obtain the Average Individual Piece Length and record the length of the piece.  *To determine Average Individual Piece Length (AIPL) of irregularly shaped pieces:*  *AIPL* = *(L 1* + *L2* + *L3)* ÷ *3*  After all pieces are measured, total the lengths and divide that total by the number of samples to obtain the Average Piece Length for the package.  *To determine Average Piece Length (APL) for the package:*  *APL* = *(L1* + *L2* + *L3* + *Ln) ÷ (Number of Pieces in Sample)* | |
|  | |
| 7. Use the average values for height, width, and length to calculate the volume of wood in the box.  *Volume in liters* = *(height in mm* × *width in mm* × *length in mm)* ÷ *1,000,000*  *Volume in cubic feet* = *(height in inches* × *width in inches* × *length in inches)* ÷ *(1728)*  **Note:** 1 cubic foot = 1728 in3, 1 cubic liter = 1,000,000 L3 | |
| 8. For boxes of wood that are packed with the wood ranked in two discrete sections perpendicular to each other, calculate the volume of wood in the box as follows: (1) determine the average height, width, and length as in 1, 2, and 3 above for each discrete section, compute total volume, and (2) total the calculated volumes of the two sections. Compute total volume by adding Volume 1 (V1) and Volume 2 (V2) according to the following formula.  *Total Volume* = *V1* + *V2* | |

|  |
| --- |
| This illustration shows how the width of the firewood is measured when two perpendicular stacks of firewood are in a box. The height, width, and length of the pieces are used to determine the volume of the separate stacks which are then added together to obtain the volume of wood in the package. |
| **Volume 2**  **Volume 1** | |

1. Stacked Firewood

Bulk deliveries of firewood are typically required by law or regulation to be on the basis of cord measurements. The “cord” is defined as the amount of wood contained in a space of 128 ft3 when the wood is ranked and well stowed. The standard dimensions for a cord of wood are 4 ft (height)  × 4 ft (width) × 8 ft (length) but wood may be stacked and measured in any configuration. See Figure 3-11. “A Cord of Wood” for an illustration of how a cord may be stacked.

****

**Figure 3-11. A Cord of Wood.**

**A cord of wood measures Length (8 ft) × Width (4 ft) × Height (4 ft).**

Wood Delivered to a Consumer. If a delivery ticket or sales receipt is available (these are often required by state regulation), review the delivery ticket or sales receipt and determine the quantity delivered. Identify the wood to be measured and verify the wood delivered was not mixed with wood that was already present at the location. Also, determine if the delivery was partial or complete (i.e., no additional deliveries are expected) and if any of the delivered wood has been used.

If necessary, stack the firewood in a ranked and well-stowed geometrical shape that facilitates volume calculations (i.e., rectangular). Any voids that will accommodate a piece of wood in the stack shall be deducted from the measured volume.

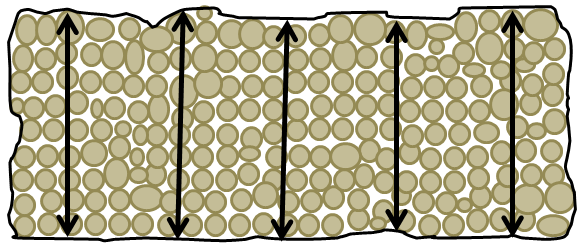
**Note:** The length measurements of the individual pieces may be made during the stacking process.

* 1. Determine the Average Measurements of the Stack. The number of measurements for each dimension given below is the minimum that should be taken.
* Height of Stack. A height measurement is the vertical distance between the top edge of a piece of wood in the top row and the bottom edge of a piece of wood on the bottom row. Start at one end of the front of the stack; measure the height of the stack at five equally spaced intervals (e.g., approximately 18 in to 24 in) along the length of stack. If the length of the stack is over 10 ft, take additional height measurements at equally spaced intervals along its length. If the height of the stack varies significantly (e.g., the pieces are stacked in peaks along the length of the stack), take additional height measurements. Calculate and record the average height for the front of the stack. Repeat the same height measurement procedure along the back of the stack and then calculate and record the average height for the back of the stack. Calculate the average height of the stack by averaging the two results. If the wood to be measured is stacked on a slope, take the height measurements at right-angles to the slope.

*Average HeightFront = (h1* + *h2* + *h3 + h4* + *h5)* ÷ *5*

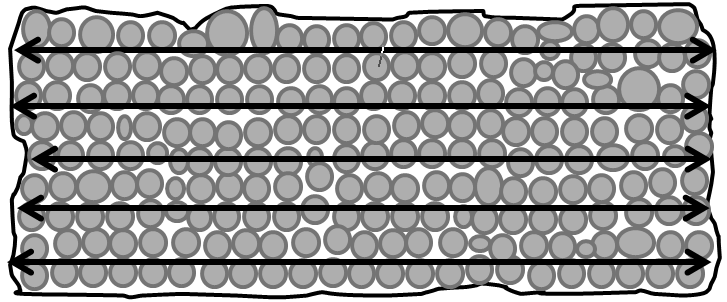
*Average HeightBack = (h1* + *h2* + *h3* +*h4* + *h5)* ÷ *5*

*Average Height of Stack = Average HeightFront + Average HeightBack ÷ 2*



**Average Height Measurement (front and back)**

* Length of Stack. A length measurement is the horizontal distance between the left edge of a piece of wood on the left side of the stack and the right edge of a piece of wood on the opposite side of the stack. Start at either side of the stack; measure the length of the stack in five equal intervals. Calculate and record the average length. If the length of the stack varies significantly (e.g., the ends of the stack bulge out along the height of the stack), take additional measurements.

**

**Average Length Measurement (front and back)**

* Calculate and record the Average Length or the Front of the Stack. Repeat the length measurement procedure along the back of the stack and then calculate and record the average length for the stack.

*Average Stack LengthFront* = *(l1* + *l2* + *l3* + *l4* + *l5) ÷ 5*

*Average Stack LengthBack = (l1* + *l2* + *l3* + *l4* + *l5) ÷ 5*

*Average Stack Length = (Average LengthFront + Average LengthBack )* ÷ *2*

* Width of Stack. This is equal to the Average Length of Pieces that make up the Width of the Stack. Refer to Table 3-5. “Minimum Number of Pieces to be Measured for Length” to determine how many pieces are to be measured. This dimension is calculated by averaging the length of individual pieces of wood in the stack. The wood can be stacked in a single or multiple rows. If the wood is stacked in several rows deep, select a representative random sample from each row. If the wood needs to be stacked, measure the pieces prior to stacking. If the wood is already stacked, select the pieces at random by moving up and down and across the stack. If it is necessary to remove the wood from a stack to measure the individual piece lengths, always complete the height and length measurements before disturbing the stacked wood.
  1. Individual Piece Length. Table 3-5. “Minimum Number of Pieces to be Measured for Length” requires that at least 12 pieces of wood be measured for every half cord estimated to be in the stack.
* If the wood is uniform in shape, take at least one point-to-point measurement along the center line of the longitudinal axis (see Table 3-6. “Determining Piece Length, (a) “Uniform Shape” for examples) and record the value.
* If the wood is irregularly shaped (see Table 3-6. “Determining Piece Length, (b) Irregular Shape” for examples), take at least three measurements along a straight line between two points crossing solid wood that appear to be the shortest and longest dimensions, and a third at or near the center line of the piece. Calculate the average of the measurements to determine Average Individual Piece Length (AIPL) of irregularly shaped pieces:

*AIPL = (L1* + *L2* + *L3)* ÷ *3*

* After all the pieces are measured, total the lengths and divide the total by the number of samples to obtain the Average Piece Length for the stack. To determine Average Piece Length (APL) for the package:

*APL* = *(L1* + *L2* + *L3* + *… Ln)* ÷ *(Number of Pieces in Sample)*

* 1. Calculate Volume.

*Volume in liters* = *(Avg. Height [cm]* × *Avg. Width [cm]* × *Average Piece Length [cm])* ÷ *1000*

*Volume in cubic feet* = *(Avg. Height [in]* × *Avg. Width [in]* × *Average Piece Length [in])* ÷ *1728*

* 1. Supplemental Measurement of Stacked Wood:
* Volume of a Triangle Stack of Wood (see Figure 3-12. “Triangular Stack of Wood”). To calculate the volume of a triangular stack, take at least two measurements (one each side) of the height and length, and five measurements of the width of the stack and average each result. Use this formula to calculate the volume.

*Volume of Triangular Stack = (Avg. Height* × *Avg. Length of Base* × *Avg. Width)* ÷ *2*

* The volume of the triangular stack may be added to the volume of other stacks.

**Figure 3-12. Triangular Stack of Wood.**

1. Bundled and Bagged Firewood

### Two photo showing firewood packaged the left one is in a bundle and the right one is packaged in a bag.

**Figure 3-13. Firewood Bundle and Bag**



### Field Audit Procedure – Bundled and Bagged Firewood

A circumference estimating method can be used for quickly identifying potentially short measure bundles. The procedure is based on measuring the circumference of the package ends and calculating the areas without using graph paper. It shall be used for audit purposes only and must not be used for official inspection.

After the bundle or bag is secured, use a flexible measuring tape to measure the circumference near each end of the bundle or bag of firewood. Using one movement, extend the measuring tape around the end of the bundle or bag to obtain its circumference. The tape must be pulled tight. If the wood at the ends of a bag or bundle is not accessible due to plastic wrapping, the wrapping should be moved away from the ends so the measuring tape can be placed tightly around the bundle so circumference measurements can be taken.

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**Figure 3-13a. Strapping the Ends of a Bundle.**

**Figure 3-13b. Measuring the Circumference of the Bundle.**

**At the point of the arrow, the circumference of the bundle is 2 ft 10 in (34 in).**



**Note:** The tape used has a blank end so the “0” line is visible immediately under the 10 in mark.

Calculate the Average Circumference:

*Average Circumference* = *(circumference1* + *circumference2)* ÷ *2*

**Example:**

*If circumference1 is 34 in and circumference2 is 33.75 in then:*

*Average Circumference: 34* + *33.75* ÷ *2* = *33.875 in*

Calculate the Radius:

*Radius* = *Average Circumference* ÷ *2π*

*Where: π* = *3.1415*

**Example:**

*radius* = *33.875* ÷ *(2* × *π or 6.283)* = *5.39 in*

Calculate the Average Area

*Average Area* = *πr²*

**Example:**

*Average Area* = *3.1415* × *5.392 (or 29.06)* = *91.3 in2*

Calculate the Average Length of the Pieces:

Average length of the pieces of wood – measure the length of several pieces of wood in the bundle or bag. Measurements are to be taken from center to center at the end of each piece.

Then calculate the average:

*Average length* = *sum of the length of all pieces* ÷ *number of pieces*

Calculate Volume:

*Volume in liters* = *(Average area [cm²]* × *Average Length [cm])* ÷ *1000*

*Volume in cubic feet* = *(Average Area [in²]* × *Average Length [in])* ÷ *1728*

**Example:**

*Assume the Average Length of the Pieces is 16 in and Average Area is 91.3 in2*

*Bundle Volume* = *91.3* *in2* × *16* *in* = *1460 in3 or 0.84 ft3*

If results indicate that the sample fails, conduct further testing using the reference test procedure for bundles and bags. Do not take any legal action based solely on this audit procedure.

(Amended 2016)

### Test Procedure - Bundled and Bagged Firewood

* 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; and select a random sample.
  2. Average Area of Bundle Ends:
* Place a binding strap around each end of the bundle (or bag of firewood) to prevent movement of the pieces during test. Place the straps approximately 10 cm (4 in) from the ends (see Figure 3-14. “A Tightly Wrapped Bundle with Straps Placed at 10 cm (4 in)” and tighten them securely.

**Test Note:** To test a bag of firewood remove the firewood from the bag and form a compact bundle and strap it as shown in Figure 3-14. “A Tightly Wrapped Bundle with Straps Placed at 10 cm (4 in),” and follow the procedures for measuring a bundle of firewood.

**Figure 3-14.** **A Tightly Wrapped Bundle with Straps Placed at 10 cm (4 in).**

**Notice:** Do not use shrink wrap or packaging to define the perimeter because it can result in inaccurate measurements.

If necessary, trim the shrink wrap back from the ends to allow for the bundle to sit flat on the graph paper.

* Set one end of the bundle or bag of firewood on graph paper large enough to cover the end completely. Draw a line around the outside of the wood perimeter on the graph paper using a sharp point marking pen (see Figure 3-15. “Tracing Perimeter of the Wood”).
* Count the number of square centimeters or square inches that are enclosed within the perimeter line. Determine portions of square centimeters or square inches not completely within the perimeter line to the nearest one-quarter square inch. Repeat this process on the opposite end of the bundle or bag.

****

**Figure 3-15. Tracing the Perimeter of the Wood.**

**Examples:**

* 1. *Using 1/4 sq in graph paper and a ruler with 1/4 in graduations, large blocks of the area within the perimeter are quickly measured. This is done by using the ruler to determine the length and then width of the area which are each divided by 0.25 (1/4 in) {or multiply 4*×*7.25} to obtain the number of blocks in that dimension. These two values are multiplied to obtain the total number of blocks enclosed in the area. The areas in the partially covered blocks are rounded up or down to the nearest 1/4 in by enclosing the whole square and placing an “x” in the partial spaces which are included in the blocks where the area has been rounded up. One reason for squaring the graph squares is to simplify the counting.*
  2. *Use a ruler to count graph squares, the rulers as shown in Figure 3-16. “Perimeter of a Bundle as Defined by the Wood” indicate the dimensions of the square are 71/4*×*73/4 in. To obtain the number of blocks divide 7.25 by 0.25 {or multiply 4*×*7.25}. To obtain the number of blocks along the left hand line (7.25*÷*0.25*=*29). The bottom line measures 73/4 in so 7.75*÷*0.25*=*31 {or 4*×*7.75* = *31}. Multiple the two values to obtain the total number of squares within the area which is:  29*×*31*=*899. To obtain square inches divide 899 by 16 (the number of 1/4 in graph squares in a square inch) or 899 ÷ 16 = for area of 56.19 in2 for this area of the bundle.*
  3. *Continue to divide the area into blocks to make counting easier and then count the blocks in the remaining areas and sum these values to obtain the total. (see the example in Figure 3-17. “Perimeter of a Bundle of as Defined by the Wood.”) The total number of blocks was calculated by adding:*

*46*+*45* + *899* + *25* + *8*+ *54* = *1177 squares* ÷ *16* = *73.56 sq in*

*for this end of the bundle.*

*Calculate the Average Area: Average Area = (Area1* + *Area2)* ÷ *2*

|  |
| --- |
| **Drawing of the perimeter of a bundle defined by the wood on a piece of graph paper.** |
| **Figure 3-16. Perimeter of a Bundle as Defined by the Wood.** |

1. Average Length of the Pieces of Wood. Individual piece length, remove the wood from the package and measure the length of each piece of wood (see Table 3-5. “Minimum Number of Pieces to be Measured for Length” for the number of pieces to be measured.) If the piece of wood is uniform in shape, take at least one point-to-point measurement along the center line of the longitudinal axis (see Table 3-6. “Determining Piece Length,” (a) Uniform Shapes for examples) and record the value.

* If the wood is irregularly shaped (see Table 3-6. “Determining Piece Length,” (b) Irregular Shapes for examples), take at least three measurements along a straight line between two points crossing solid wood that appear to be the shortest and longest dimensions, and a third at or near the center-line of the piece. Calculate the average of the measurements to obtain the Average Individual Piece Length and record the length of the piece.

*To determine Average Individual Piece Length (AIPL) of irregularly shaped pieces:*

*AIPL* = *(L1* + *L2* + *L3)* ÷ *3*

**Note:** If length measurements are made in millimeters divide the total by 10 to obtain centimeters.

* After all pieces are measured, total the lengths and divide that total by the number of samples to obtain the Average Piece Length for the package.

*To determine Average Piece Length (APL) for the package:*

*APL = (L1* + *L2* + *L3* + *… Ln)* ÷ *(Number of Pieces in Sample)*

1. Use the average values for height, width, and length to calculate the volume of wood in the bundle or bag

* Calculate Volume:

*Volume in liters* = *(Average Area [cm2]* × *Average Length [cm])* ÷ *1000*

*Volume in cubic feet* = *(Average Area [in2]* × *Average Length [in])* ÷ *1728*

**Note:** 1 Cubic Foot = 1728 in3, 1 L3 = 1000 cm

(Amended 2016)

### Evaluation of Results

Follow Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

**Note:**  Specified in Appendix A, Table 2‑10. “Exceptions to the Maximum Allowable Variations for Textiles, Polyethylene Sheeting and Film, Mulch and Soil Labeled by Volume, Packaged Firewood and Stove Wood Labeled by Volume, and Packages Labeled by Count with 50 Items or Fewer, and Specific Agricultural Seeds Labeled by Count.”

## Test Procedure for Verifying the Useable Volume Declaration on Packages of Animal Bedding

### Test Equipment

* + Calculator or spreadsheet software
  + Standard Package Report Form – Animal Bedding
  + Measurement Grid and Package Error Worksheet for Cylindrical and Square or Rectangular Test Measures
  + Permanent ink marking pen
  + Knife or razor cutter (for use in opening packages and unwrapping shrink-wrapped pallets in warehouses)
  + Cellophane tape, Duct tape (for repairing chutes and sealing packages)
  + Polyethylene bags (49 L to 113.5 L [13 gal to 30 gal]) (to hold product once it is uncompressed)
  + Rigid Rulers – Starrett[[2]](#footnote-3) or equal with 1.0 mm graduations. The edges of a ruler used with a measuring frame must be straight and the edges must be the zero point.
    - 300 mm (12 in)
    - 500 mm (19.5 in)
    - 1 m (39 in)
  + Tarp – canvas 3 m × 3 m (10 ft × 10 ft)
  + Broom and dust pan
  + Levels – for verifying the level of the test measure and taking headspace readings.
* 152 mm (6 in) Bubble Level
  + - 1 m (40 in) Carpenter Level
  + Scale 15 kg (30 lb) (only used if the audit procedure is utilized.)
  + Chutes for uncompressing and pouring the bedding into a test measure
  + Test Measures (see Table 3-8. “Test Measures for Animal Bedding”)

|  |  |  |  |
| --- | --- | --- | --- |
| **Table 3-7.**  **Recommended Chute Dimensions** | | | |
| **Nominal Capacity** | **Height** | **Width** | **Length** |
| 70 L (2.5 ft3) | 254 mm (10 in) | 228 mm (9 in) | 1219 mm (48 in) |
| 100 L (3.5 ft3) | 254 mm (10 in) | 279 mm (11 in) | 1397 mm (55 in) |
| 170 L (6 ft3) | 279 mm (11 in) | 355 mm (14 in) | 1727 mm (68 in) |
| 240 L (8.5 ft3) | 304 mm (12 in) | 406 mm (16 in) | 2006 mm (79 in) |
| 283 L (10 ft3) | 304 mm (12 in) | 406 mm (16 in) | 2286 mm (90 in) |
| **NOTE:** Chutes (see Illustration 1. Testing Chutes) may be constructed using hinges and pins so that they lie flat for transporting. They can be constructed of sheet metal or with other slick surface material which enable the bedding to flow easily. The construction of the chutes used in this study allows the sides to move in or out slightly so that the bedding does not become clogged at the outlet. The heights and lengths may be adjusted slightly to fit into vehicles for transport but the widths should not be reduced because narrowing the opening can restrict material flow and result in “bridging” where the bedding collects and creates a block. Also, the width should be kept smaller than the opening of the test measure so that spillage does not occur during pouring. | | | |
| Photo showing the various testing shoots in varying sizes.  Illustration 1. Testing Chutes | | | |

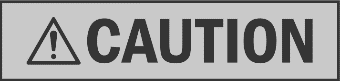
| **Table 3-8. Test Measures for Animal Bedding NOTES: a, b, c, and d**  Only Interior Dimensions are Used for Volume Calculations. Must Be Calibrated with Traceable Measurement Standards Prior to Use. | | | | | | | | | | |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Rectangular Test Measures** | | | | | | | | | | |
| **Actual Volume of the**  **Measure b & d** | **Interior Wall Dimensions** | | | | | | **Surface Area** | | **Marked Increments on Ruler** | **Increment Volume** |
| **Length** | | **Width** | | **Heightd** | |
| 31.9 L  1.13 ft3 | 213.4 mm  (8.4 in) | | 203.2 mm  (8 in) | | 736.6 mm  (29 in) | | 43 362 mm2  (67.2 in2) | | 12.7 mm  (0.5 in) | 550.6 mL\*  0.55 L  (33.6 in3) |
| 28.3 L  1 ft3 | 304.8 mm (12 in) | | 304.8 mm (12 in) | | 304.8 mm (12 in) | | 92 903 mm2  (144 in2) | | 1.18 L\*\*  (72 in3) |
| 63.7 L  2.25 ft3 | 304.8 mm (12 in) | | 304.8 mm (12 in) | | 685.8 mm  (27 in) | |
| 406.4 mm  (16 in) | | 228.6 mm  (9 in) | | 685.8 mm  (27 in) | |
| 92 L  3.25 ft3 | 304.8 mm (12 in) | | 304.8 mm (12 in) | | 990.6 mm  (39 in) | |
| 406.4 mm  (16 in) | | 228.6 mm  (9 in) | | 990.6 mm  (39 in) | |
| \*1.0 mm = 43 mL (2.6 cu in) \*\* 1.0 mm = 92 mL or 0.09 L (5.6 cu in) | | | | | | | | | | |
| **Square Test Measures** | | | | | | | | | | |
| **Actual Volume of the**  **Measure b & d** | **Interior Wall Dimensions** | | | | | | | **Surface Area** | **Marked Increments**  **on Ruler** | **Increment Volume** |
| **Length** | | **Width** | | **Heightd** | | |
| 77.4 L  (2.73 ft3) | 381 mm  (15 in) | | 381 mm  (15 in) | | 533.4 mm  (21 in) | | | 145 161 mm2  (225 in2) | 1.0 mm  (0.03937 in) | 0.14 L  (8.5 in3) |
| 144 L  (5.09 ft3) | 508 mm  (20 in) | | 508 mm  (20 in) | | 558.8 mm  (22 in) | | | 258 064 mm2  (400 in2) | 0.25 L  (15.2 in3) |
| 283 L  (10 ft3) | 609.6 mm  (24 in) | | 609.6 mm  (24 in) | | 762 mm  (30 in) | | | 371 612 mm2  (576 in2) | 0.37 L  (22.5 in3) |
| **Cylindrical Test Measures**  These dimensions are based on the tube having a 1/4 inch wall thickness. Other tube thicknesses may be used. | | | | | | | | | | |
| **Actual Volume**  ***Volume = πr2h*** | | **Interior Diameter**  **(Outside Diameter)** | | **Height** | | **Surface Area**  ***Area = πr2*** | | | **Increment** | **Increment**  **Volume** |
| 52 L  (1.8 ft3) | | 292.1 mm (304.8 mm)  11.5 in (12 in) | | 780 mm  (30.70 in) | | 67 012 mm2  (103.8 in2) | | | 1.0 mm  (0.03937 in) | 0.06 L  (4 in3) |
| 124 L  (4.3 ft3) | | 444.5 mm (457.2 mm)  17.5 in (18 in) | | 800 mm  (31.49 in) | | 155 179 mm2  (240.52 in2) | | | 0.15 L  (9.4 in3) |
| 279 L  (9.8 ft3) | | 596.9 mm (609.6 mm)  23.5 in (24 in) | | 1000 mm  (39.37 in) | | 279 829 mm2  (433.76 in2) | | | 0.27 L  (16.4 in3) |
| **Notes**  a. Rectangular and Square Based Dry Measures are typically constructed of 12.7 mm to 19.05 mm (0.5 in to 0.75 in) marine plywood. A 4.76 mm (3/16 in) transparent sidewall is useful for determining the level of fill, but must be reinforced or be made of thicker material if it distorts when the measure is filled. If the measure has a clear front, place the level gage at the back (inside) of the measure so that the markings are read over the top of the animal bedding. Any of these measures may be made without an attached bottom for ease of emptying if they are placed on a solid level base during filling and measurement.  b. Other size measures may be used if calibrated and the volume equivalence of the increment of 1.0 mm is no greater than 1/6 the MAV. Widening the base of a measure reduces the column height of the product and will reduce compression but the trade-off is that the larger surface area increases the volume so the potential for measurement errors increase. One of the benefits of the cylindrical design is that, in addition to eliminating the 90 degree angles of the corners where gaps in fill frequently occur, the surface area of a cylinder is less than an equal volume square measure and that results in better resolution in the volume measurements (i.e., compare the readability of a 24 in sq box which has a surface area of 576 in2, to the 24 in cylinder which has a surface area of 433 in2). The height of the test measure may be reduced, but this will limit the volume of the package that can be tested.  c. If lines are marked in any test measures, they should extend around all sides of the measure if possible to improve readability. It is recommended that a line indicating the MAV level also be marked to reduce the possibility of reading errors when the level of the product is at or near the MAV.  d. If the measures are built to the dimensions shown above, the actual volume of most of the measures will be larger than the nominal volume so that plus errors (overfill) can be measured accurately.  **Test Note:** Nothing in this section should be construed or interpreted as prohibiting the use of test measures meeting these specifications, or constructed in other geometric shapes or dimensions, or those made of other materials to test any other products. | | | | | | | | | | |

### Test Procedure

**Test Notes**:

**Rounding:** When a volume measurement falls between graduations on a ruler, round the value in the direction that favors the packer. This practice eliminates the issue of rounding from the volume determination and provides packagers the benefit of the doubt. The ruler graduation is 1.0 mm so the rounding error will be limited to 0.5 mm or less. It is good practice to circle a measurement that has been rounded up or make a statement to such effect so that it becomes a part of the inspection record.

**Safety Precautions:**

****

This procedure does not address all of the safety issues that users need to be aware of in order to carry out the following tasks. Users are sometimes required to conduct test in warehouse spaces or retail stores where fork-trucks are in motion – care must be taken to warn others to avoid or exercise care around the test site. The procedure requires users to lift heavy objects including large bulky packages and test measures and includes the use of sharp instruments to obtain packages from shrink-wrapped pallets. Users may be required to climb ladders or work platforms to obtain packages. When opening and emptying packages, dust, and other particles may be present or escape from the packages which may cause eye injuries and respiratory or other health problems. Users must utilize appropriate safety equipment and exercise good safety practice. If safe working conditions cannot be ensured, suspend testing until the situation is corrected.

1. Follow Section 2.3.1. “Define the Inspection Lot” select “Category A, Sampling Plan” in this inspection. Determine the Sample Size based on the size of the Inspection Lot using Category A. Collect the sample packages from the Inspection Lot using Section 2.3.4. “Random Sampling Selection.”

**Test Notes:**

1. Place the test equipment and sample packages in a location where there is adequate lighting and ample space around the packages and equipment so the packages can be opened and the chutes and test measures used safely.
2. If the package is not labeled with a usable volume, it is opened and the contents are poured directly into the test measure.

**Optional – Audit Screening by Weight**

The full test procedure requires that all of the packages be opened for testing. Regardless of the type of bedding, the product cannot be returned to the original package. An alternative gravimetric auditing procedure may be used to reduce the amount of destructive testing and conserve inspection resources.

**Audit Procedure:** After randomly selecting the sample packages from the Inspection Lot, obtain the gross weight for each package. Select the lightest and heaviest packages and conduct a usable volumetric test these two packages. If the lightest and heaviest packages pass (i.e., each contains at least the useable volume declared on the label), it is highly likely that the remaining packages in the sample will also pass. Accept these two package samples as an AUDIT TEST and move on to inspect other types of bedding or Inspection Lots of other types or brands of bedding. If either of the two packages is found to have a minus error that exceeds the Maximum Allowable Variation, the sample fails. No further testing is required (i.e., assuming no MAV is allowed for the sample size (see Appendix A, Table 2‑1. “Sampling Plans for Category A”.) If either of the packages is found to have a minus error that does not exceed the MAV, continue to test all of the packages and take action based on the final results from the complete sample.

**Test Note:** If the gravimetric audit procedure is used, ensure the scale is placed on a solid level support, and its accuracy has been verified to a test load that is at least 10 % more than the gross weight of the packages (e.g., to estimate the load, place one of the packages on the scale and then test the scale with a load above the package’s gross weight). See Section 2.2. “Measurement Standards and Test Equipment” for additional information.

1. Select the appropriate test measure for the package size.

* Spread a tarp large enough to hold a chute and test measure.
* Place the chute and test measure on the tarp. Verify that the test measure is level.

1. Select a chute of appropriate capacity (see Table 3-7. “Recommended Chute Dimensions”) for the package size and position it on the tarp.
2. Open the packaging, uncompressing and pouring the bedding into the test measure twice.

* **Open Package:** Place the package in the chute and use a knife or box cutter to open and remove the wrapper. Spread the bedding uniformly along the length of the chute. The bedding is uncompressed in two steps. The first step is to loosen the clumps of bedding by gently pulling them apart (do not tear the fibers of cellulose bedding or “grind” any bedding between your hands because these practices break the material down). Spread your fingers and pick the material up using your hands from beneath to loosen it up. There should be no clumps of bedding in the chute. If any bedding has fallen out of the chute onto the tarp, collect it and return it to the chute. The following pictures illustrate this step of the procedure. The second step of the expanded volume recovery process is to pour the bedding into a test measure as described in Step 2.

**Figure 3-19. Loosening the Clumps of Bedding Material.**

**Figure 3-18. Spreading Bedding Material**

|  |
| --- |
| Photo showing the distribution of material after the first pour.  **Figure 3-20. First Pour into the Test Measure.** |

* + - **First Pour:** The first pour into the test measure is only used to further un-compress the bedding so no measurements are taken. Hold the chute above the test measure and tilt it so that you pour the bedding into the center of the test measure. The bedding should be poured slowly into the test measure in one continuous stream and not “dumped” (if it is “dumped” or poured too quickly some of the bedding will blow out of the measure or the bedding will be packed down and its volume reduced). The flow rate should be controlled by the tilt angle of the chute. The chute itself can be shaken but DO NOT HIT OR SHAKE THE TEST MEASURE. Also, do not touch the product to facilitate flow. (Do not adjust the flow by closing the opening of the chute as that may cause the bedding to heap up and then fall into the measure in clumps, which may result in impact compression). Empty the bedding back into the chute and spread it out evenly along its length.

|  |  |
| --- | --- |
| Figure 3-21. How to Hold a Chute for the Pour. | Cradle the chute on one arm while holding it with one hand and tilting the cradle with the other hand. |
| **Figure 3-21. How to Hold a Chute for the Pour.** | **Figure 3-22. How to Cradle the Chute. Cradle the chute on one arm while holding it with one hand and tilting the cradle with the other hand.** |

* + - **Second Pour:** The second pour into the test measure is used to make the volume determination. Hold the chute above the test measure and tilt it so that you pour the bedding into the center of the test measure. The bedding should be poured slowly into the test measure in one continuous stream and not “dumped.” The flow rate should be controlled by the tilt angle of the chute. The chute can be shaken but DO NOT HIT OR SHAKE THE TEST MEASURE.

**Test Note:** Stop filling the measure if it appears that the test measure will overflow. The overflow product should be measured separately (use a smaller test measure of adequate size and capacity if one is available) and the multiple measurement volumes are added. If pouring into a square test measure, pour at an angle to two corners for the widest opening (see Figure 3-24. “Filling a Test Measure”).

|  |  |
| --- | --- |
| **Photo illustrating the pouring of bedding material into a 44 L test measure.** | **Filling a test measure at an angle to use the larger opening.** |
| **Figure 3-23. Filling a 44 L Test Measure.** | **Figure 3-24. Filling a Test Measure at an Angle to use the Larger Opening.** |

1. Volume Determination.

Do not Hand level the surface of the bedding as manual leveling “packs” the Bedding and reduces its volume. DO NOT JAR OR SHAKE THE TEST MEASURE

**Test Note:** Before using a test measure for volume determinations, place a level of adequate length on top of the test measure at approximately three equal measuring points across the top. A permanent marking pen can be used to evenly space the marks across the top edge of the test measure so that it can be positioned to take the measurements. (see Figure 3-25. “Marking Evenly Spaced Measuring Points.”)

|  |  |
| --- | --- |
| Photo illustraing evenly spaced measuring points across the top of the test measure. | **Figure 3-25.  Marking Evenly Spaced Measuring Points across the top of the test measure.** |

* Place a rigid level or straight edge of adequate size on top the test measure and select a ruler of adequate length to reach to the lowest level of the top surface of the bedding. Start at the measuring points to your left or right, place the ruler against the side of the level, and hold it with either hand. The zero graduation is pointed down so the ruler can be lowered into the test measure for measurement. Lower the ruler into the test measure slowly until its end is at the surface level of the bedding (see Figure 3-26. “Placing the Ruler into the Test Measure with Zero End Down” and Figure 3-27. “Ruler Shown with Zero End at the Bedding Surface).

|  |  |
| --- | --- |
| **Photo showing a clear container that contains bedding matieral.  A ruler is inserted into the bedding and intersects with a level resting at the top of the container.** | **Photo to illustrate using the headspace measurement on a 279 L test measure.  The ruler is read from the bottom edge of a straight edge or level from a position that reduces parallax.** |
| **Figure 3-26. Placing the Ruler into the Test Measure with Zero End Down.** | **Figure 3-27. Ruler Shown with the Zero End at the Bedding Surface.** |

* Determine the depth of each measurement point from the surface of the bedding to the bottom edge of the straight edge and record the value in the appropriate space on the worksheet. Take a minimum of nine measurements (at least 9 for cylindrical measures) across the top of the test measure in a grid pattern. Read the graduations on the ruler from a position that minimizes errors caused by parallax.

| **Table 3-9. Illustrations of Depth Determinations**  **with Cylindrical Test Measures** | | | |
| --- | --- | --- | --- |
| Photo exhibiting how to read the depth from the bottom of the straighedge dow to the bedding in a 44 L test measure froma position that reduces parallax.  **Illustration 1. Reading the Depth of the Container. This photo illustrates how to read the depth of container.** | The picture on the left (Illustration 1) shows how to read the depth from the bottom of the straightedge (top edge of measure) down to the to bedding in a 44 L test measure from a position that reduces parallax. The graphic below (Illustration 2) illustrates the actual worksheet with the headspace procedure on the 44 L cylinder test measure (its internal radius is 151.77515 mm and its height is 610 mm). The bedding was poured into the test measure but not leveled. Then nine measurements were made at the locations shown on the grid to determine the depth of the product from the top edge of the measure. The average of the nine values was 479.88 mm which was subtracted from the height of the test measure to obtain 130.12 mm for the average height of the column of bedding in the measure.  The volume was calculated using:  *Volume in liters* = *(πr2h) 3.14159265 (Pi)* × *23035.69 mm* × *130.12 mm* = *9.41 L\**  \*After the calculation was completed the result was divided by 1 000 000 to obtain the volume in liters. | | |
|  |  | | |
| 430  439  528  **Illustration 2. Illustration of Worksheet.**  492  475  462  419  542  532 | | | |
| **Photo to illustrate using the headspace measurement on a 279 L test measure.  The ruler is read from the bottom edge of a straight edge or level from a position that reduces parallax.** | | | **Illustration 3. Using the head­space measure­ment on a 279 L test measure. The ruler is read from the bottom edge of a straight edge or level from a position that reduces parallax.** |
| **Photo illustrating how the ruler is placed on the bedding with the headspace method.** | | **Illustration 4. Illustrating how the ruler is placed on the bedding with the headspace method. The ruler is read from the bottom edge of a straight edge or level from a position that reduces parallax.** | |

| **Table 3-10. Illustrations of Depth Determinations with Square Test Measures** | | |
| --- | --- | --- |
| **Photo showing a square test measure with bedding matterial in the bottom.  Inserted into the test measure at the corner of the test measure is a vertical ruler intersecting with a horizontal rule at the top of the test measure.**  **Illustration 1. Depth Determination.** | **Drawing of a square with vertical and horizontal lines forming a nine-section square grid.  This illustrates the actual worksheet with the headspace procedure on a square test measure.**  115  95  51  98  46  138  77  46  43  **Illustration 2. Measurement Grid for Headspace Measurement Procedure.** | |
| The picture on the left (Illustration 1. Depth Determination) shows how to read the depth from the bottom of the straightedge (top edge of measure) down to the bedding in a 283 L square test measure from a position that reduces parallax. The graphic on the right (Illustration 2. Measurement Grid for Headspace Measurement Procedure) illustrates the actual worksheet with the headspace procedure on the square test measure (its internal dimensions are 609.6 mm × 609.6 mm × 762 mm (24 in × 24 in × 30 in). The bedding was poured into the test measure but not leveled. Then nine measurements were made at the locations shown on the grid to determine the depth of the product from the top edge of the measure. The average of the nine values was 78.77 mm that was subtracted from the height of the test measure to obtain 683.23 mm for the average height of the column of bedding in the measure.  The volume was calculated using:  *Volume in liters* = *lwh 609.6 mm* × *609.6 mm* × *683.23 mm* = *253.89 L\**  \*After the calculation was completed, the result was divided by 1 000 000 to obtain the volume in liters. | | |
|  | | **Illustration 3.  Using the headspace measurement on 56.6 L (2 cu ft) test measure. The ruler is read from the bottom edge of a straight edge or level from a position that reduces parallax.** |
|  | | **Illustration 4. Showing how the ruler is placed on the bedding with the headspace method. The ruler is read from the bottom edge of a straight edge or level from a position that reduces parallax.** |

1. Using the Worksheet for Volume Calculation

* Enter the sample number of the package on the worksheet along with its labeled usable volume.
* Test Measure Information
* For a cylindrical test measure, enter its interior height and radius in the spaces labeled A and B.
* For a square or rectangular test measure enter its interior height and the area of its base (i.e., length × width) in spaces labeled A and B.
* Sum the measurements in the grid, divide the value by the number of measurements (i.e., 9), and enter this value in the space labeled C, Average Depth.
* Calculate the Average Height of the Bedding (subtract C [Average Depth] from A [Interior Height of Test Measure]) and enter this value in the space labeled D.
* Calculate the Volume of Bedding in the Package:
* For a cylindrical test measure, the formula (*Volume in Liters* = *πr2h)* is shown on line E on the worksheet. It is:

*Volume (Liters)* = *3.14159265* × *r2 (B2)* × *Average Height (D)* ÷ *1 000 000.*

Enter the package volume in the space provided for this value in line E.

* For a square or rectangular test measure the formula (*Volume in Liters* = *LWH)* is shown in line E on the worksheet. It is:

*Volume (Liters)* = *B (Area of Test Measure Base)*×*D (Average Height)* ÷ *1 000 000.*

Enter the package volume in the space provided for this value in line E.

* Calculate the Package Error using the following formula:
* Package Error = Labeled Usable Volume (Liters) − E Package Volume (Liters)

*Package Error (Liters)* = *Labeled Expanded Volume* – *Package Volume*

* Transfer the individual package errors (verify whether they are positive or negative) to the “Standard Package Report – Animal Bedding” in Appendix D. Fill in the required header information. For Box 7, “Number of Unreasonable Package Errors Allowed for Sample Size”, use Appendix A Table 2-1. “Sampling Plans for Category A”, “Column 4.”, Based on the sample size, determine how many packages may have minus package errors that exceed the MAV (i.e., unreasonable package error).

THEN:

* Calculate the Total Error (Enter in Box 8. “Total Error”).

(Amended 2016)

### Evaluation of the Test Results and Determination of Pass or Fail

1. Determine if any of the minus package errors exceeds the MAV. Apply a MAV value of 5 % (0.05 × labeled expanded volume) to single measurement volume determinations. If none of the minus package errors exceeds the MAV, go to Step 3. If any of the minus package errors exceed the MAV, enter the number of packages in Box 9 “Number of Unreasonable Minus Errors”. Go to Box 10 “Is Box 9 Greater than Box 7?” and determine if the value exceeds the number in Box 7 “Number of Unreasonable Package Errors Allowed for Sample Size”. If the number of packages with unreasonable errors exceeds the number permitted in Box 7 “Number of Unreasonable Package Errors Allowed for Sample Size,” the sample fails. Go to Box 17 “Disposition of the Inspection Lot” and reject the Inspection Lot.
2. Calculate the Average Error for the sample by dividing Box 8 “Total Error,” by Box 6 “Sample Size” and enter the value in Box 11 “Calculate Average Error,” then go Box 12 “Does Box 11 equal Zero or Plus?” If the Average Error is zero or a positive number the sample passes, go to Box 17 “Disposition of the Inspection Lot” and approve the inspection lot. If the Average Error is a negative value go to Step 3.
3. Calculate the Sample Standard Deviation and enter in Box 13. “Compute Sample Standard Deviation.” To obtain the Sample Correction Factor for the sample size use Appendix A, Table 2-1. “Sampling Plans for Category A,” Column 3 “Sample Correction Factor’ and enter that in Box 14 “Sample Correction Factor.” Then calculate the Sample Error Limit by multiplying Box 13 “Compute Sample Standard Deviation” and Box 14 “Sample Correction Factor.” Enter the value in Box 15 “Compute Sample Error Limit.”

* Disregarding the signs, determine if the minus in Box 11 “Calculate Average Error” is larger than the value in Box 15 “Compute Sample Error Limit.”
* If yes, the sample fails, go to Box 17 “Disposition of Inspection” and reject the Inspection Lot.
* If no, the sample passes, go to Box 17 “Disposition of Inspection” and approve the Inspection Lot

1. Prepare a comprehensive report of the test results and enforcement action taken and present the information to the party responsible for the product.

(Amended 2016)

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# Test Procedures – Packages Labeled by Count, Linear Measure, Area, Thickness, and Combinations of Quantities

## Scope

The following procedures should be used to determine the net contents of products sold by count, area, thickness, and linear measure. If a package includes more than one declaration of quantity, each declaration must meet the package requirements.

A gravimetric procedure may be used to test products sold by measure or count if the density of the product does not vary excessively from one package to another. If the gravimetric procedure cannot be used, each package in the sample must be opened to measure or count the contents.

## Packages Labeled by Count

If the labeled count is 50 items or fewer, use Section 4.2.1. “Packages Labeled with 50 Items or Fewer.” If the labeled count is more than 50 items, see Section 4.2.2. “Packages Labeled by Count of More than 50 Items.” If the labeled count is more than 50 items for corn, soybeans, field beans, and wheat seeds, see Section 4.9. “Procedure for Checking the Contents of Specific Agricultural Seed Packages Labeled by Count.”



### Packages Labeled with 50 Items or Fewer

#### Test Equipment

None.

#### Test Procedure

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use “the sampling plans in Appendix A. Tables, Table 2-11. “Sampling Plans and Accuracy Requirements for Packages Labeled by Low Count (50 or Fewer) and Packages Given Tolerances (Glass and Stemware)” for the inspection and select a random sample. |
|  |
| 1. Open the packages and count the number of items in each. Record the number of packages that contain fewer than the labeled count. |

#### Evaluation of Results

|  |
| --- |
| 1. Refer to Column 2 to determine the number of packages that are allowed to contain fewer than the labeled count. |
|  |
| 1. If the number of packages in the sample that contain fewer than the labeled count exceeds the number permitted in Column 2, the sample and the lot fail to meet the package requirement. |
|  |
| **Note:** For statistical reasons, the average requirement does not apply to packages labeled by count of 50 or fewer items, **and the MAV does not apply to the lot**. It only applies to the packages in the sample. |
|  |
| 1. Maximum Allowable Variations: The MAVs listed in Appendix A, Table 2‑7. “Maximum Allowable Variations (MAVs) for Packages Labeled by Count” define the limits of reasonable variation for an individual package even though the MAV is not directly used in the sampling plan. Individual packages that are undercount by more than the MAV are considered defective. Even if the sample passes, these should be repacked, relabeled, or otherwise handled. |
|  |
| **Example:**  *If testing a lot of 160 packages of pencils labeled “50 pencils,” choose a random sample of 12 packages from the lot. If the scale cannot discriminate between differences in count, open every package and count the pencils. For example, assume the 12 package counts are: 50, 52, 50, 50, 51, 53, 52, 50, 50, 50, 47, and 50.*  *Because only one package contains fewer than 50 pencils, the sample passes the test (refer to Appendix A. Table 2‑11. “Accuracy Requirements for Packages Labeled by Low Count [50 or Fewer] and Packages Given Tolerances [Glass and Stemware]”). However, the package containing 47 pencils should not be introduced into commerce even though the lot complies with the package requirements because it is undercount by more than the MAV (1 item) permitted in Appendix A, Table 2‑7. “Maximum Allowable Variations (MAVs) for Packages Labeled by Count.”* |

(Amended 2010)

### Packages Labeled by Count of More than 50 Items

There are two procedures to determine count without opening all packages in the sample. The first is an audit procedure and the second is recommended for determining compliance and taking legal action. Both use the weight of a counted number of items in the package. If the weight of discrete items or numbers of items in a package varies excessively, the packaged items must be counted rather than weighed.

To determine if a gravimetric procedure can be used to inspect packages labeled by count, follow the steps below.



#### Test Equipment

Scale that meets the requirements in Section 2.2. “Measurement Standards and Test Equipment.”

**Scale Sensitivity:**

First, determine if the scale being used is sensitive enough to determine the weight of individual items by doing the following:

|  |
| --- |
| 1. For packages labeled with a count of 84 or higher, calculate the weight equivalent for the MAV/6 for the labeled count of the package. MAV/6 must be at least equal to one-half scale division on a mechanical scale or one division on a digital scale. |
|  |
| 1. For packages with a labeled count of 83 or fewer, when each unit weighs at least two‑scale divisions, consider the scale acceptable. |
|  |
| **Example:**  *According to Appendix A, Table 2‑7. “Maximum Allowable Variations (MAVs) for Packages Labeled by Count,” the MAV is 7 for a package labeled with a count of 250 items. The scale should be capable of measuring differences corresponding to MAV/6 or, in this example, the weight of one item.* |
|  |
| * If the scale meets the appropriate requirement, gravimetric testing can be used to determine package count or, |
|  |
| * If the scale does not meet the criteria, count the content in each package in the sample. |

#### Test Procedures

1. Audit Procedure

Use this procedure to audit lots of packages labeled by count of more than 50 items but not for determining lot compliance. Determine the lot compliance based on actual count or by using the “Violation Procedure” (b).

**Note:** The precision of this procedure is only ± 1 %.

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; and select a random sample. |
|  |
| 1. Select an initial tare sample according to Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight.” |
|  |
| 1. Gross weigh the first package in the tare sample and record this weight. |
|  |
| 1. Select the number of items from the first tare package that weighs the greater: |
|  |
| * 10 % of the labeled count; or |
|  |
| * a quantity equal to at least 50 minimum divisions on the scale. |
|  |
| **Example:**  *Using a scale with 1 g divisions, the selected count must weigh at least 50 grams. If a scale with 0.001 lb divisions is used, the selected count must weigh at least 0.05 lb. Record the count and weight.* |
|  |
| 1. Calculate the weight of the labeled count using the following formula:   *Weight of the Labeled Count =*  *(labeled count* × *weight of items in Step 4)* ÷*(Count of items in Step 4)* |
|  |
| Record the result as “labeled count weight.” |
|  |
| 1. Gross weigh the remaining packages of the tare sample and keep contents of opened packages separated in case all of the items must be counted. |
|  |
| 1. Determine the Average Used Dry Tare Weight of the sample according to Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight.” |
|  |
| 1. Record the nominal gross weight by adding the weight of the labeled count and the average tare weight. |
|  |
| 1. Subtract the nominal gross weight from the gross weight of the individual packages and record the errors.   *(Package error [weight])* =  *(actual package gross weight)* − *(nominal gross weight)* |
|  |
| 1. Convert the package errors in units of weight to count using the following formula:   *Package error (count)* = *(Package error [weight]* × *labeled count)* ÷ *(labeled count weight)* |
|  |
| Round any fractional counts up to whole items in favor of the packager. Record the package error in units of count.   1. Compute the average error. |
|  |
| * If the average error is minus, go to the “Violation Procedure” below. |
|  |
| * If the average error is zero or positive, the sample is presumed to conform to the package requirements. |

1. Violation Procedure

If possible, use the gravimetric procedure to determine compliance, to minimize the number of packages to be opened. This procedure combines the measurement of the weight of the number of units in the package with the determination of tare. Therefore, it will not be necessary to open more packages than the tare sample. If the audit procedure in this section has been used, the procedure below can be followed with the same sample if package contents have been kept separate and can still be counted. Use the following procedure to determine if the sample passes or fails.

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample. |
|  |
| 1. Select an initial tare sample according to Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight.” |
|  |
| 1. Gross weigh the packages selected for the tare sample and record these weights. Open these packages and determine the tare and net weights of the contents, and count the exact number of items in the packages. Record this information. |
|  |
| 1. Calculate and record the weights of the labeled counts for the first two packages using the formula:   *Weight of labeled count* = *(labeled count)* × *(contents weight* ÷ *contents count)* |
|  |
| To avoid round off errors, carry at least two extra decimal places in the calculation until the weight of the labeled count is obtained. To use the gravimetric procedure, the difference in weights of the labeled counts of the two packages must not exceed one scale division. |
|  |
| * If the difference in weights exceeds this criterion, determine the actual count per package for every package in the sample recording plus and minus errors. Then, follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance. |
|  |
| * If the difference is within the criterion, average the weights of the labeled count and go on to Step 5. |
|  |
| 1. Determine the Average Used Dry Tare Weight of the sample according to provisions in Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight.” |
|  |
| 1. Determine and record the nominal gross weight by adding the average weight of the labeled count of items in the package Step 4 to the average tare weight Step 5. |
|  |
| 1. Weigh the remaining packages in the sample, subtract the nominal gross weight from the gross weight of the individual packages, and record the errors.   *Package Error (weight)* = *(Actual Package Gross Weight)* − *(Nominal Gross Weight)* |
|  |
| 1. Look up the MAV for the package size from Appendix A, Table 2‑7. “Maximum Allowable Variations (MAVs) for Packages Labeled by Count”and convert it to weight using the formula:   *MAV (weight)* =  *(MAV (count)* × *Average Weight of Labeled Count [from Step 4])* ÷ *(Labeled Count)* |
| 1. Convert the MAV to dimensionless units by dividing the MAV (weight) by the unit of measure and record. |

#### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

Convert back to count when completing the report form, using the following formula:

*Average Package Error (count)* = *(Avg. Pkg. Error [dimensionless units])* × *(Unit of Measure)* ×

*(Labeled Count)* ÷ *(Average Weight of Labeled Count)*

## Paper Plates and Sanitary Paper Products

The following procedure is used to verify the size of paper plates and other sanitary paper products. It may also be used to verify the size declarations of other disposable dinnerware.

**Note:** Do not distort the item’s shape during measurement.

The count of sanitary paper products cannot be adequately determined by weighing. Variability in sheet weight and core weight requires that official tests be conducted by actual count. However, weighing can be a useful audit method. These products often declare total area as well as unit count and sheet size. If the actual sheet size measurements and the actual count comply with the average requirements, the total area declaration is assumed correct.

### Test Equipment

* Steel tapes and rulers. Determine measurements of length to the nearest division of the appropriate tape or ruler.
* Metric units:

For labeled dimensions 400 mm or less, linear measure: 300 mm in length, 1 mm divisions; or a 1 m ruler with 0.1 mm divisions, overall length tolerance of 0.4 mm.

For labeled dimensions greater than 400 mm, 30 m tape with 1 mm divisions.

* U.S. customary units:

For labeled dimensions 25 in or less, use a 36 in ruler with 1/64 in or 1/100 in divisions and an overall length tolerance of 1/64 in.

For dimensions greater than 25 in, use a 100 ft tape with 1/16 in divisions and an overall length tolerance of 0.1 in.

* Measuring Base

**Note:** A measuring base may be made of any flat, sturdy material approximately 38 cm (15 in) square. Two vertical side pieces approximately 30 mm (1 in) high and the same length as the sides of the measuring base are attached along two adjoining edges of the measuring base to form a 90° corner. Trim all white borders from two or more sheets of graph paper (at least 380 mm, 10 divisions per centimeter or 20 divisions per inch). Place one sheet on the measuring base and position it so that one corner of graph paper is snug in the corner of the measuring base and vertical sides. Tape the sheet to the measuring base. Overlap other sheets on the first sheet so that the lines of top and bottom sheet coincide, expanding the graph area to a size bigger than plates to be measured; tape these sheets to the measuring base. Number each line from the top and left side of base plates:  1, 2, 3, etc.

### Test Procedure

|  |
| --- |
| 1.\* Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample. |
|  |
| 2.\* Select an initial tare sample according to Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight.” |
|  |
| 1. Open each package and select one item from each. |

**Notes:**

1. Some packages of plates contain a combination of different-sized plates. In this instance, take a plate of each declared size from the package to represent all the plates of that size in the package. For example, if three sizes are declared, select three different plates from each package.
2. Occasionally, packages of plates declared to be one size contain plates that can be seen by inspection to be of different sizes in the same package. In this instance, select the smallest plate and use the methods below to determine the package error. If the smallest plate is not short measure by more than the MAV, measure each size of plate in the package and calculate the average dimensions.

**Example:**

*If five plates measure 21.41 cm (8.43 in) and 15 measure 21.74 cm (8.56 in), the average dimension for this package of 20 plates is 21.66 cm (8.53 in).*

|  |
| --- |
| 1. For paper plates: Place each item on the measuring base plate (or use the linear measure) with the eating surface down so two sides of the plate touch the sides of the measuring base. |
|  |
| 1. For other products: Use either the measuring base or a linear measure to determine actual labeled dimensions (e.g., packages of napkins, rolls of paper towels). If testing folded products, be sure that the folds are pressed flat so that the measurement is accurate. |
|  |
| 1. If the measurements reveal that the dimensions of the individual items vary, select at least 10 items from each package. Measure and average these dimensions. Use the average dimensions to determine package error in Step 7 below. |
|  |
| 1. The package error equals the actual dimensions minus the labeled dimensions. |

### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

## Special Test Requirements for Packages Labeled by Linear or Square Measure (Area)

Products labeled by length (such as yarn) or area, often require the application of tension to the ends of the product in order to straighten the product before measuring. When testing yarn and thread, apply tension and use the specialized equipment as defined by the latest version of ASTM D1907/D1907M, “Standard Test Method for Linear Density of Yarn (Yarn Number) by the Skein Method,” in conjunction with the sampling plans and package requirements described in this handbook. Use Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

## Polyethylene Sheeting, Bags, and Liners

Most polyethylene products are sold by length, width, thickness, area, and net weight. Accordingly, this procedure includes steps to test for each of these measurements.

(Amended 2017)

### Test Equipment

* A scale that meets the requirements in Section 2.2. “Measurement Standards and Test Equipment.”
* Steel tapes and rulers. Determine measurements of length to the nearest division of the appropriate tape or ruler.
* Metric units:

For labeled dimensions 400 mm or less, linear measure: 300 mm in length, 1 mm divisions; or a 1 m ruler with 0.1 mm divisions, overall length tolerance of 0.4 mm.

For labeled dimensions greater than 400 mm, 30 m tape with 1 mm divisions.

* U.S. customary units:

For labeled dimensions 25 in or less, use a 36 in ruler with 1/64 in or 1/100 in divisions and an overall length tolerance of 1/64 in.

For dimensions greater than 25 in, use a 100 ft tape with 1/16 in divisions and an overall length tolerance of 0.1 in.

* Deadweight dial micrometer (or equal) equipped with a flat anvil, 6.35 mm or (1/4 in) diameter or larger, and a 4.75 mm (3/16 in) diameter flat surface on the head of the spindle.
* The mass of the probe head (total of anvil, weight 102 g or [3.6 oz], spindle, etc.) must total 113.4 g (4 oz).
* The anvil and spindle head surfaces should be ground and lapped, parallel to within 0.002 mm (0.0001 in), and should move on an axis perpendicular to their surfaces.
* The dial spindle should be vertical, and the dial should be at least 50.8 mm (2 in) in diameter.
* The dial indicator should be continuously graduated to read directly to 0.002 mm (0.0001 in) and should be capable of making more than one revolution. It must be equipped with a separate indicator to indicate the number of complete revolutions. The dial indicator mechanism should be fully jeweled.
* The frame should be of sufficient rigidity that a load of 1.36 kg (3 lb) applied to the dial housing, exclusive of the weight or spindle presser foot, will not cause a change in indication on the dial of more than 0.02 mm (0.001 in).
* The indicator reading must be repeatable to 0.001 2 mm (0.000 05 in) at zero.
* The micrometer should be operated in an atmosphere free from drafts and fluctuating temperature and should be stabilized at ambient room temperature before use.
* Gage blocks covering the range of thicknesses to be tested should be used to check the accuracy of the micrometer
* T-square

### Test Procedure

1. Test Procedure for Polyethylene Sheeting
2. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample.
3. Be sure the product is not mislabeled. Check the label declaration to confirm that all of the declared dimensions are consistent with the required standards. The declaration on sheeting, film, and bags shall be equal to or greater than the weight calculated by using the formulas below.

* For values less than 453.6 kg (1000 lb), the final value shall be calculated to at least four digits and declared to three digits, truncating the final digits as calculated (e.g., a calculated value of 943.1 g [2.079 lb] is truncated to 943 g [2.07 lb]), a calculated value of 14.92 kg (32.89 lb) is truncated to 14.9 kg (32.8 lb), a calculated value of 124.4. kg (274.2 lb) is truncated to 124 kg (274 lb).
* For values of 453.6 kg (1000 lb) or more, the final value shall be calculated to at least five digits and declared to four digits, truncating the final digits as calculated (e.g., a calculated value of 570.44 kg [1257.6 lb] is truncated to 570.4 kg [1257 lb]).

**Example:**

**Label –**

**Polyethylene Sheeting**

**1.82 m (6 ft) × 30.48 m (100 ft)**

**101.6 µm (4 mil)**

**5.03 kg (11.1 lb*)***

3. Use the following formulas to compute a target net weight. The labeled weight shall equal or exceed the target net weight or the package is not in compliance and shall be considered a NIST Handbook 130, Uniform Method of Sale, Section 2.13. “Polyethylene Product” violation.

* SI (metric) Dimensions:

*Target Mass in Kilograms* = *(T* × *A* × *D)* ÷ *1 000*

*Where*: *T = nominal thickness in centimeters*

*A = nominal length in centimeters* × *nominal width (the nominal width for bags is twice the labeled width) in centimeters*

*D = minimum density in grams per cubic centimeter\**

Check the label for a density declaration and type of polyethylene. If the density (D)\* value is not declared, use the following as appropriate:

* For linear low density polyethylene plastics (LLPDE), the minimum density (D) shall be 0.92 g/cm3 (when D is not known).
* For linear medium density polyethylene plastics (LMDPE), the minimum density (D) shall be 0.93 g/cm3 (when D is not known).
* For high density polyethylene plastics (HDPE), the minimum density (D) shall be 0.94 g/cm3 (when D is not known).

\*Determined by the latest versions of ASTM Standard D1505, “Standard Test Method for Density of Plastics by the Density-Gradient Technique” and the ASTM Standard D883, “Standard Terminology Relating to Plastics.”

* U.S. Customary Dimensions:

*Target Weight in Pounds = T* × *A* × *D × 0.036 13*

*Where: T = nominal thickness in inches;*

*A = nominal area; that is the nominal length in inches* × *nominal width (the nominal width for bags is twice the labeled width) in inches;*

*D = minimum density in grams per cubic centimeter; 0.036 13 is a factor for converting g/cm3 to lb/in3*

1. Perform the calculations as shown in the following example. If the product complies with the label declaration, go to Step 5.

**Example:**

* *For metric units:*

*(0.010 16 cm* × *[(1.82 m* × *100 cm/m)* × *(30.48 m × 100 cm/m)]* × *0.92 g/cm3)* ÷ *1000 g/kg* = *a target weight of 5.18 kg*

*In this example, the labeled net mass of 5.03 kg does not meet the target net mass, so the product is not in compliance.*

* *For U.S. customary units:*

*(0.004 in)* × *[(6 ft* × *12 in/ft)* × *(100 ft* × *12 in/ft)]* × *0.92 g/cm3* × *0.03613* = *a target weight of 11.48 lb*

*In this example, the labeled net weight of 11.1 lb does not meet the target net weight, so the product is not in compliance.*

1. Select packages for tare samples according to Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight.”
2. Determine and record the gross weights of the initial tare sample.
3. Extend the product in the sample packages to their full dimensions and remove by hand all creases and folds.
4. Measure the length and width of the product to the closest 3 mm (1/8 in). Make all measurements at intervals uniformly distributed along the length and width of the sample and record the results. Compute the average length and width, and record.

* With rolls of product, measure the length of the roll at three points along the width of each roll and measure the width at a minimum of 10 points along the length of each roll.
* For folded products, such as drop cloths or tarpaulins, make three length measurements along the width of the sample and three width measurements along the length of the sample.

1. Determine and record the average tare weight according to Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight.”
2. Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine the lot conformance requirements for length, width, and weight.
3. If the sample failed to meet the package requirements for any of these declarations, no further measurements are necessary. The lot fails to conform.

**Note:** If the sample meets the package requirements for the declarations of length, width, and weight proceed to Step 12 to verifying the thickness declaration.

1. Measure the thickness of the plastic sheet with a micrometer using the following guide. Place the micrometer on a solid level surface. If the dial does not read zero with nothing between the anvil and the spindle head, set it at zero. Raise and lower the spindle head or probe several times; it should indicate zero each time. If it does not, find and correct the cause before proceeding.
2. Take measurements at five uniformly distributed locations across the width at each end and five locations along each side of each roll in the sample. If this is not possible, take measurements at five uniformly distributed locations across the width of the product for each package in the sample.
3. When measuring the thickness, place the sample between the micrometer surfaces and lower the spindle head or probe near, but outside, the area where the measurement will be made. Raise the spindle head or probe a distance of 0.008 mm to 0.01 mm (0.000 3 in to 0.000 4 in) and move the sheet to the measurement position. Drop the spindle head onto the test area of the sheet.
4. Read the dial thickness two seconds or more after the drop, or when the dial hand or digital readout becomes stationary. This procedure minimizes small errors that may occur when the spindle head or probe is lowered slowly onto the test area.
5. For succeeding measurements, raise the spindle head 0.008 mm to 0.01 mm (0.000 3 in to 0.000 4 in) above the rest position on the test surface, move to the next measurement location, and drop the spindle head onto the test area. Do not raise the spindle head more than 0.01 mm (0.000 4 in) above its rest position on the test area. Take measurements at least 6 mm (1/4 in) or more from the edge of the sheet.
6. Repeat Steps 12 through 16 above on the remaining packages in the sample and record all thickness measurements. Compute and record the average thickness for the individual package and apply the following MAV requirements.

(Amended 2012, 2017, and 2018)

1. Test Procedure for Polyethylene Bags and Liners
   * 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample.

2. Follow the steps in Section 4.5.2.a. “Test Procedure for Polyethylene Sheeting” for calculating the weight of polyethylene sheeting. Multiply the calculated weight times the count (the number of bags or liners), then multiply by two (to account for both sides of each bag or liner) to obtain your target net weight.

3. To determine the target net weight for bags with a cutout, (i.e., t-shirt or specialty bags), subtract from the target net weight the weight of the cutout. Use the following method to calculate the weight of the cutout:

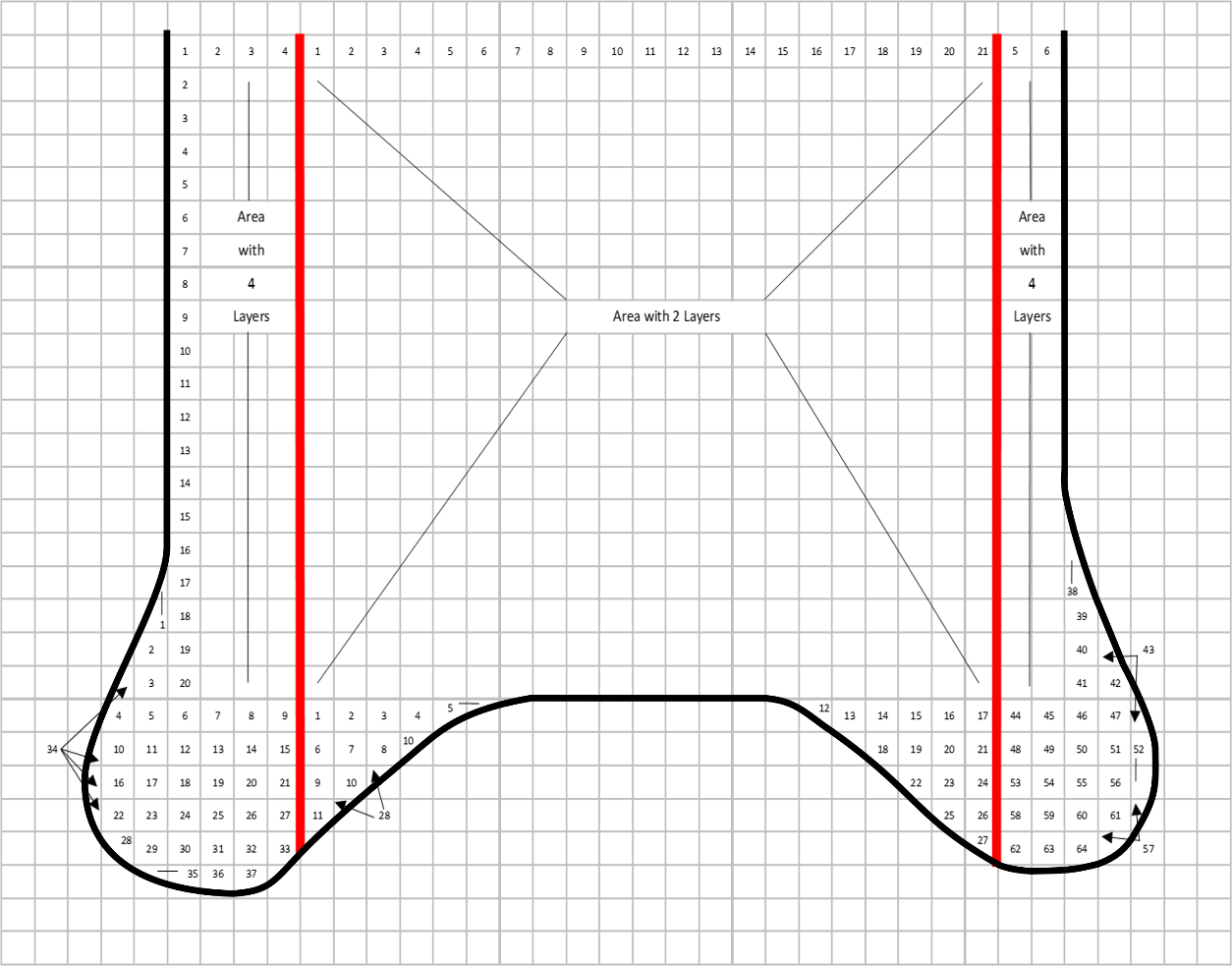
Trace the cutout on ruled graph paper with 0.5 cm (1/4 in) squares as shown in the diagram that follows. (see Figure 4-1. T-Shirt Bag.)

For t-shirt bags with a fold or gusset, you will need to draw an extra line up from the gusset to the edge of the graph paper. This will aid in accounting for the additional plastic layers within the bag. (see shaded area in Figure 4-1. T-Shirt Bag.)

* + Count the squares and divide this number by the number of squares per square inch (sq in) (i.e., 16-1/4 inch squares = 1 sq in) to determine the total area of the cutout. Adjust your total area by taking into account the number of layers for each region counted. (Figure 4‑2. Polyethylene Bag Outline on Graph.)
* Once the total area of the bag has been determined, take the total area of the cutout and divide it by the total area of the bag to calculate the percentage of the cutout.
* Compute and record the weight of the bag without the cutout by subtracting the calculated net weight of the cutout from the total target net weight of the bags being tested. The calculated net weight of the cutout is determined by multiplying the total target net weight of the bag by the percentage of the area of the cutout.



**Figure 4-1. T-Shirt Bag.**



**Figure 4-2. Polyethylene Bag Outline on Graph Paper**

**Example**:

* *To find the total area of the cutout, determine the area for the four-layer region and the area for the two-layer region and add them together.*

*Four-Layer Area: 4 [(6 × 20) + 64 additional boxes] ÷ 16 squares/sq in = 46 sq in*

*Two-Layer Area: 2 [(21 × 20) + 28 additional boxes] ÷ 16 squares/sq in = 56 sq in*

*The area of the cutout = 46 sq in + 56 sq in = 102 sq in*

* *If the total area for the bags prior to cutout is 836 sq in, then the percentage of the cutout is 12.2 %, (102 sq in ÷ 836 sq in = 0.1220 × 100)*
* *Multiply the theoretical weight by 12.2 % to determine the weight of the cutout for the bags, then subtract this from the target net weight to determine the weight of the bags.*

*If the calculated target net weight for a box of bags is 11.57 lb, then 12.2 % would weigh 1.41 lb (11.57 lb × 12.2 % = 1.41 lb).*

*Therefore, the target net weight of the product is: 11.57 lb − 1.41 lb = 10.16 lb*

(Added 2017)

### Evaluation of Results

1. Individual Thickness

**Note:** Refer to Appendix A, Table 2-10. “Exceptions to the Maximum Allowable Variations (MAVs) for Textiles, Polyethylene Sheeting and Film, Mulch and Soil Labeled by Volume, Packaged Firewood and Stovewood Labeled by Volume, and Packages Labeled by Count with 50 Items or Fewer, and Specific Agricultural Seeds Labeled by Count.”

(Amended 2010)

* On polyethylene with a declared thickness greater than 25 µm (1 mil or 0.001 in): an individual thickness measured may be up to 20 % less than the declared thickness.
* On polyethylene with labeled thickness less than or equal to 25 µm (1 mil or 0.001 in), individual thickness measurements may be up to 35 % below the labeled thickness.

Count the number of values that are smaller than specified MAVs (0.8 × labeled thickness if 25 µm [1 mil] or greater or 0.65 × labeled thickness, if less than 25 µm [1 mil]). If the number of values that fail to meet the thickness requirement exceeds the number of MAVs permitted for the sample size, the lot fails to conform to requirements. No further testing of the lot is necessary. If the number of MAVs for thickness measurements is less than or equal to the number permitted for the sample size, go on to Evaluation of Results – Average Thickness.

1. Average Thickness

The average thickness for any single package should be at least 96 % of the labeled thickness. This is an MAV of 4 % (refer to Appendix A, Table 2-10. “Exceptions to the MAVs for Textiles, Polyethylene Sheeting and Film, Mulch and Soil Labeled by Volume, Packaged Firewood and Stove Wood Labeled by Volume, and Packages Labeled by Count with 50 Items or Fewer,and Specific Agricultural Seeds Labeled by Count.”) Circle and count the number of package average thickness values that are smaller than 0.96 × labeled thickness. If the number of package average thicknesses circled exceeds the number of MAVs permitted for the sample size, the lot fails to conform to requirements. No further testing of the lot is necessary. If the number of MAVs for package average thickness is less than or equal to the number of MAVs permitted for the sample size, proceed to Section 2.3.7. “Evaluate for Compliance”to determine if the lot meets the package requirements for average thickness.

(Amended 2010)

## Packages Labeled by Linear or Square (Area) Measure

### Test Equipment

* A scale or balance that meets the requirements in Section 2.2. “Measurement Standards and Test Equipment.” Determine the suitability of the scale. Calculate the length or area of packaged product corresponding to MAV/6. If there is no suitable weighing device, all of the packages in the sample must be opened and measured.
* Steel tapes and rulers – determine measurements of length to the nearest division of the appropriate tape or ruler.
* Metric units:

For labeled dimensions 400 mm or less, linear measure: 300 mm in length, 1 mm divisions; or a 1 m ruler with 0.1 mm divisions, overall length tolerance of 0.4 mm.

For labeled dimensions greater than 400 mm, 30 m tape with 1 mm divisions.

* U.S. customary units:

For labeled dimensions 25 in or less, use a 36 in ruler with 1/64 in or 1/100 in divisions and an overall length tolerance of 1/64 in.

For dimensions greater than 25 in, use a 100 ft tape with 1/16 in divisions and an overall length tolerance of 0.1 in.

* T-square

### Test Procedure

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample. |
|  |
| 1. Select an initial tare sample according to Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight.” |
|  |
| 1. Gross weigh the first package in the tare sample and record this weight. |
|  |
| 1. Determine and record the measurements (to the nearest division of the appropriate tape or ruler) of the packaged goods (length, width, area; depending upon which dimensions are declared on the label) and weigh the goods from the first package opened for tare determination. |
|  |
| * Calculate and record the weight of the labeled measurements using the following formula:   *Weight of the labeled measurement* =  *(labeled measurement)* × *(contents weight) ÷ (contents measurement)* |
|  |
| * Look up and record the MAV in units of length or area measure (given in Appendix A, Table 2‑8. “Maximum Allowable Variations for Packages Labeled by Length, (Width) or Area.” |
|  |
| **Note:**See Appendix A, Table 2‑10. “Exceptions to the MAVs for Textiles, and Polyethylene Sheeting and Film, Mulch and Soil Labeled by Volume, Packaged Firewood and Stove Wood Labeled by Volume, and Packages Labeled by Count with 50 Items or Fewer, and Specific Agricultural Seeds Labeled by Count.” |
|  |
| 1. Determine and record the tare weight of the first package opened. |
|  |
| 1. Determine and record the measurements (length, width, area; depending upon which dimensions are declared on the label) of the product in the second package chosen for tare determination (to the nearest division of the appropriate tape or ruler). Determine and record the tare weight of this package. |
|  |
| 1. Calculate and record the weight of the labeled measurement for the second package using the following formula:   *Weight of the labeled measurement* =  *(labeled measurement)* × *(contents weight* ÷ *contents measurement)* |
|  |
| The weights of the labeled measurement for two packages must not differ by more than one division on the scale. If they do, open all packages in the sample, measure individually, and compare them against the labeled measure to determine the package errors. If the criterion is met, go to Step 8. |
|  |
| 1. Calculate the average weight of the labeled measurement and record. |
|  |
| 1. Determine and record the average tare weight according to Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight.” |
|  |
| 1. Compute and record the nominal gross weight by adding the average weight of the labeled measurements to the average tare weight. |
|  |
| 1. Compute package errors according to the following formula:   *Package error (weight)* =  *(actual package gross weight)* − *(nominal gross weight)* |
| 1. Convert the MAV to units of weight using the following formula:   *MAV (weight)* =  *(Avg. Wt. of label measurements* × *MAV [length])* ÷ *(labeled measurements)*  Convert the MAV to dimensionless units by dividing the MAV (weight) by the unit of measure and record. |
|  |

### Evaluation of Results

Follow the procedure in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

Convert back to dimensions when completing the report form using the following the formula:

*Average Package Error (dimension)* = *(Avg. Pkg. Error [dimensionless units])* × *(Unit of Measure)* ×*(Labeled unit of measure)* ÷ *(Avg. Weight of Labeled dimension)*

## Baler Twine – Test Procedure for Length

### Test Equipment

* + A scale that meets the requirements in Section 2.2. “Measurement Standards and Test Equipment.”

**Note:** A scale with 0.1 g (0.000 2 lb) increments must be used for weighing twine samples. The recommended minimum load for weighing samples is 20 divisions.

* + Steel tapes and rulers – Determine measurements of length to the nearest division of the appropriate tape or ruler.
* Metric units:

For labeled dimensions 400 mm or less, linear measure: 300 mm in length, 1 mm divisions; or a 1 m ruler with 0.1 mm divisions, overall length tolerance of 0.4 mm.

For labeled dimensions greater than 400 mm, 30 m tape with 1 mm divisions.

* U.S. customary units:

For labeled dimensions 25 in or less, use a 36 in ruler with 1/64 in or 1/100 in divisions and an overall length tolerance of 1/64 in.

For dimensions greater than 25 in, use a 100 ft tape with 1/16 in divisions and an overall length tolerance of 0.1 in.

* A hand-held straight-face spring scale of at least 4.53 kg (10 lb) capacity or a cordage-testing device that applies the specified tension to the twine being measured. When measuring twine samples or total roll length, apply 1.0 kg (2.20 lb) of tension to the twine.

### Test Procedure

1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample.
2. Select packages for tare samples. Determine gross weights of the initial tare sample and record.
3. Open the tare samples.  Use the procedures for tare determination in Section 2.3.5.1. “Determination of Tare Sample and Average Tare Weight” to compute the average tare weight and record this value.
4. Randomly select four balls of twine from the packages that were opened for tare.

From each of the four balls of twine:

* Measure and discard the first 10.05 m (33 ft) of twine from each roll. Accurate measurement requires applying tension to the ends of the twine before measuring in order to straighten the product.
* Take two 30.48 m (100 ft) lengths of twine from inside each roll.
* Weigh and record the weight of each piece separately and record the values. Compare the weight values to determine the variability of the samples. If the individual weights of the eight twine samples vary by more than one division on the scale, use one of the following steps: (1) if the lot is short, determine the actual length of the lightest-weight roll found in the lightest-weight package of the lot to confirm that the weight shortages reflect the shortages in the length of the rolls; or (2) determine the average weight-per-unit of measure by taking ten 30.48 m (100 ft) lengths from inside the lightest weight package. Use this value to recalculate its length and determine lot compliance

1. Weigh all of the sample lengths together and record the total value. Determine the total length of the samples (243.8 m or 800 ft, unless more than eight sample-lengths were taken) and record the value. Compute the average weight-per-unit-of-length by dividing the total weight by the total length of the pieces.
2. Determine the MAV for a package of twine (refer to Appendix A, Table 2‑8. “Maximum Allowable Variations for Packages Labeled by Length, (Width), or Area”).

* Record the total declared package length.
* Multiply the MAV from Appendix A, Table 2‑8. “Maximum Allowable Variations for Packages Labeled by Length, (Width), or Area” times the total package length to obtain the MAV for length and record this value.
* Multiply the weight per unit of length (from Step 4) times the MAV for the total declared package length to obtain the MAV by weight and record this value.
* Convert the MAV to dimensionless units and record.

1. Calculate the nominal gross weight and record.

Follow Section 2.3.6. “Determine Nominal Gross Weight and Package Error” to determine individual package errors. Determine errors using the following formula:

*Package error (weight)* = *(package gross weight)* – *(nominal gross weight)*

* To convert the package error in weight back to length, divide the weight by the average weight-per-unit-of-length.

### Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot compliance.

## Procedure for Checking the Area Measurement of Chamois

Chamois is a natural leather made from skins of sheep and lambs that have been oil-tanned. Chamois are irregularly shaped, varying in thickness and density,which makes area measurement difficult.

The area of chamois is verified using either Section 4.8.1. “Graph Paper Audit Procedure” which is to identify chamois that are potentially short measure or Section 4.8.2. “Gravimetric Test Procedure for Area Measurement” which is used for compliance testing. 

### Graph Paper Audit Procedure

Chamois is typically labeled in uniform sizes in terms of square decimeters and square feet, and are sized in increments of 2.32 dm2 (1/4 [ft](ftp://ft2)[2](ftp://ft2)) (e.g., 9.29 dm2 (1 [ft2](ftp://ftP2P)), 11.61 dm2 (11/4  [ft2](ftp://ft2)), and 13.93 dm2 (11/2 ft2).

#### Test Equipment

* Graph paper: 43.18 cm × 55.88 cm (17 in × 22 in) with 0.5 cm or 1/4 in squares.
* Ruler or steel tape: 1 mm or 1/16 in graduations.

#### Test Procedure

|  |
| --- |
| 1. Select a random sample of chamois. It is recommended that a minimum of three packages be tested. |
|  |
| 1. Place the graph paper on a smooth surface. Use a ruler or steel tape to verify the dimensions of squares at several random points across the page.Place the chamois on the graph paper and carefully draw around the outline of the chamois onto the paper.   **Note:**  Graph paper of an appropriate size that allows for tracing of the entire chamois shall be used. However, if a single sheet of appropriate-sized graph paper is not available, it may be necessary to tape sheets of graph paper together to create an area sufficient in size to measure the area for a chamois (e.g., chamois greater than 23.22 dm (2.5 ft)). |
|  |
| 1. Determine the area by counting the number of squares the chamois covers. Use a ruler or steel tape to help calculate the area. Add the number of partially covered squares. (see Figure 4-3. “Template for Checking the Area of a Chamois.”) |
|  |
| 1. Compute the total area and refer to Section 4.8.3. “Evaluation of Results” to determine if further action is necessary |
| *First Stage – Decision Criteria*  If the average of the samples is a plus error or a minus error that is 3 % or less of the labeled quantity, the audit test results should be accepted. Move on to inspect other chamois. If the average of the samples is a minus error that exceeds 3 % of the labeled area, the chamois may not be labeled accurately. To confirm the finding, use the gravimetric test procedure. |

Figure shows a representation of a piece of graph paper and the outline of a chamois to aid in the determination the area measurement.

**Figure 4.3. Template for Checking the Area of Chamois.**

### Gravimetric Test Procedure for Area Measurement

This method is intended for use in checking full, cut, or pattern shaped chamois.

#### Test Equipment

* Scale with a capacity of 1 kg that is accurate to at least ± 0.01 g and a load-receiving element of adequate size to properly hold the chamois (record to 0.1 g).
* Medium weight drawing paper (e.g., drawing paper, medium weight (100 lb), regular surface or comparable)
* Household iron set on the lowest heat temperature settings (e.g., silk, nylon)
* Ruler or steel tape: 1 mm or 1/16 in graduations
* Instrument for cutting paper (razor blade, scissors, x-acto® knife, or cutting board)
* Steel square

#### Test Procedure

|  |
| --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” “Use a Category A” sampling plan in the inspection; and select a random selection. |
|  |
| 1. Use a household iron set on the lowest heat setting (e.g., silk, nylon) to remove wrinkles. Continuously iron the chamois from the center of the chamois to the outer edges in all directions, to spread and flatten out the wrinkles (some wrinkles may not flatten). Use a swift, steady motion, being careful to not let the iron stay in contact with the chamois surface for too long. Excessive heat will shrink the chamois. You may not be able to remove all wrinkles. |
|  |
| 1. Immediately after ironing the sample, carefully draw around the outline of the chamois on the paper. Remove the chamois; carefully cut along the outline of the chamois. |
|  |
| 1. Lay out the pattern and using a steel square, cut an accurately measured rectangle (verifying all four corners are at a 90° angle) of a size not less than one-half the area of the pattern. Do this for each sample. Weigh the cutout rectangle and record the weight to the nearest 0.1 g Sample Weight 2 (W2). |
|  |
| 1. Weigh the entire cutout pattern (the outline of the chamois which includes the cutout rectangle), and record to the nearest 0.1 g Sample Weight 1 (*W1*).   **Note:** To ensure the proper weighing of the paper outline of the chamois and the cutout rectangle it is recommended that the pieces be folded in a way so that the entire pattern is centered and not hanging over the load receiving element. |
|  |
| 1. Calculate the area of the rectangle cut from the pattern by multiplying the length by width and record as Area (A) in centimeters or square inches. |
|  |
| 1. Calculate the area of the original chamois. |
| * For metric units – calculate the area of the original chamois being checked as follows:   *W1/W2* × *A* = *Chamois Area in cm2/100* = *Area in dm2* |
| * For U.S. customary units – calculate the area of the original chamois being checked as follows:   *W1/W2* × *A = Chamois Area in in2/144* = *Area in ft2* |

### Evaluation of Results

Compute the average error for the sample and follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot conformance.

The MAV for area declarations on chamois is 3 % of the labeled area as specified in Appendix A, Table 2‑8. “Maximum Allowable Variations for Packages Labeled by Length, (Width), or Area”.

(Amended 2019)

## Procedure for Checking the Contents of Specific Agriculture Seed Packages Labeled by Count

The following method shall be employed when using a mechanical seed counter to determine the number of seeds contained in a sample of soybean (*Glycine max*), corn (*Zea mays*), wheat (*Triticum aestivum*) and field bean (*Phaseolus vulgaris*).

### Test Equipment

* Mechanical seed counter
* Moisture proof container

### Test Procedure

|  |
| --- |
| 1. Testing samples shall be received and retained in moisture proof containers until the weight of the sample prepared for purity analysis is recorded. The sample shall be of at least 500 grams for soybean, corn, field beans, and 100 grams for wheat. |
|  |
| 1. The seed counter shall be calibrated daily prior to use. |
|  |
| * Prepare a calibration sample by counting 10 sets of 100 seeds. Visually examine each set to insure that it contains whole seeds. Combine the 10 sets of seeds to make a 1000 seed calibration sample. The seeds of the calibration sample should be approximately the same size and shape as the seeds in a sample being tested. |
|  |
| **Note:** If the seeds in a sample being tested are noticeably different in size or shape from those in the calibration sample, prepare another calibration sample with seeds of the appropriate size and shape. Periodically re-examine the calibration samples to insure that no seeds have been lost or added. |
|  |
| * Carefully pour the 1000 seed calibration sample into the seed counter. Start the counter and run it until all the seeds have been counted. |
|  |
| **Note**: The seeds should not touch as they run through the counter. Record the number of seeds as displayed on the counter read out. |
|  |
| * The seed count should not vary more than ± 2 seeds from 1000. If the count is not within this tolerance, clean the mirrors, adjust the feed rate and/or reading sensitivity. Rerun the calibration sample until it is within the ± 2 seed tolerance. |
|  |
| **Note**: If the seed counter fails the calibration procedure and sample has been checked to ensure that it contains 1000 seeds, do not use the counter until it has been repaired. |
|  |
| 1. Immediately after opening the container, mix and divide the sample to obtain a sample for purity analysis (refer to Appendix D: AOSA Rules for Testing Seeds). |
|  |
| 1. Record the weight of this sample in grams to the appropriate number of decimal places. |
|  |
| 1. Conduct the purity analysis to obtain pure seed for the seed count test. |
|  |
| 1. After the seed counter has been calibrated, test the pure seed portion from the purity test and record the number of seeds in the sample. |
|  |
| 1. Calculation of results. |
|  |
| * Calculate the number of seeds per pound to the nearest whole number using the following formula:   *Number of seeds per pound* = *453.6 g/lb* × *no. of seeds counted divided by*  *the weight (g) of sample analyzed for purity* |
|  |
| 1. Determine the Maximum Allowable Variation (MAV). |
|  |
| * Multiply the labeled seed count by 4 % for soybean, 2 % for corn, 5 % for field bean, and 3 % for wheat. |

**Note**: Express the maximum allowable variation (the number of seeds) to the nearest whole number. Consider the results of two tests in accord with the maximum allowable variation if the difference, expressed as the number of seeds, is equal to or less than the maximum allowable variation.

**Example:**

*Kind of seed: Corn*

*Label claim: 2275 seeds/lb*

*Lab Test: Purity working weight* = *500.3 g*

*Seed count of pure seed* = *2479 seeds*

*Number of seeds per pound* = *453.6 g/lb* × *2479 seeds divided by 500.3 g* = *2247.6 seeds/lb rounded to the nearest whole number* = *2248 seeds/lb*

*Calculate maximum allowable variation value for corn:*

*multiply label claim by 2 %*

*2275 seeds/lb* × *0.02* = *45.5 seeds/lb;*

*rounded to the nearest whole number* = *46 seeds/lb*

*Determine the difference between label claim and lab test:*

*2275 seeds/lb* – *2248 seeds/lb* = *27 seeds/lb*

*The difference between the lab test and the label claim is less than the maximum allowable variation (27*<*46); therefore, the two results are in accord with the maximum allowable variation.*

### 4.9.3. Evaluation of Results

Follow the procedures in Section 2.3.7. “Evaluate for Compliance” to determine lot compliance.

(Added 2010)

## 4.10. Structural Plywood and Wood-Based Structural Panels

### 4.10.1 Test Equipment

* Steel linear measure
  + For labeled dimensions exceeding 304 mm (12 in), use a measure with 0.05 mm or 1/32 in graduations.
* Calculator
* Worksheet for Plywood Sheet and Wood-Based Structural Panels (see Appendix C. Model Inspection Reports)
* Micrometer, caliper, or dial gauge 25 mm to 50 mm (1 in to 2 in) with 19.1 mm (3/4 in) anvils
  + A mechanism that applies constant pressure between 34 kPa (5 psi) and 69 kPa (10 psi) during the measurement.
* For “tongue and groove” (e.g., floor panels) and “shiplap” (e.g., exterior siding panels), a micrometer with a 152 mm (6 in) throat; 19.1 mm (3/4 in) anvils may be necessary.
  + A mechanism that applies constant pressure between 34 kPa (5 psi) and 69 kPa (10 psi) during the measurement.
* Gage blocks
* The latest version of U.S. Department of Commerce (DOC), Voluntary Product Standard PS 1- 19, “Structural Plywood.”
* The latest version of U.S. Department of Commerce (DOC), Voluntary Product Standard PS 2- 18, “Performance Standard for Wood-Based Structural-Use-Panels.”
* Aluminum foil and plastic bags
* Saw



### Test Procedure

Use this procedure to verify the length, width, and thickness of structural plywood and wood-based structural panels.

|  |  |
| --- | --- |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection. Select a random sample. | |
|  | |
| 1. Identify the Performance Category and actual size of each piece (e.g., 1.2 m × 2.4 m) (4 ft × 8 ft) from the latest version of Voluntary Product Standards PS 1-19, “Structural Plywood” or PS 2-18, “Performance Standard for Wood-Based Structural-Use-Panels”. | |
|  | |
| 1. Conduct a visual inspection of each piece to ensure there are no signs of water or other damage. Remove any pieces (e.g., top, sides) that have damage or have been exposed to the elements (e.g., weather, rain, moisture, sun) from the lot.   **Note:** Overlapping (e.g., shipped siding) or interlocking panels (e.g., tongue and groove floor panels) shall be measured according to the exposed face. Measurements are taken on the surface that will be exposed after installation and shall not include the overlap tab. | |
|  | |
| 1. Determining Length  * For sheet lengths up to 3 m (10 ft), take at least two measurements along the sheet’s length about one-quarter of the distance from the center line to each edge of the sheet (see Figure 4. Determining Length). Average the results to obtain the Average Length. | |
| **Take measurements at least**  **152 mm (6 in) in from each edge.**  **Figure 4. Determining Length.**  **Note:** Measurements should not be made across the ends of the board or where there is a knot or surface defect that may affect the measurement. Measurements should not be taken within 150 mm (6 in) from the edges of the sheet. | |
|  | |
| 1. Determining Width  * For sheet lenths up to to 3 m (10 ft), take at least two measurements across the sheet’s width about one-quarter of the distance from each end of the sheet (see Figure 5. Determining Width). Average the results to obtain the Average Width.   **Note:** Measurements should not be made anywhere across the sheet where there is a knot or surface defect that may affect the measurement. Measurements should not be taken within 150 mm (6 in) from the ends of the sheet. | |
| **Figure 5. Determining Width.**  **Take measurement at least**  **152 mm (6 in) in from each edge.** | |
|  | |
| 1. Determining Thickness  * Verify the accuracy of the micrometer, caliper, or dial gauge using the gage blocks. Use the micrometer, caliper, or dial gauge 25 mm to 50 mm (1 in to 2 in); 19.1 mm (3/4 in) anvils to measure thickness and record the actual dimensions on the “Worksheet for Plywood Sheets.” For “tongue and groove” (e.g., floor panels) and “shiplap” (e.g., exterior siding panels) a micrometer with a 152 mm (6 in) throat; 19.1 mm (3/4 in) anvils may be necessary. * Panel thickness shall be measured with a micrometer having 19.1 mm (3/4 in) (minus 0, plus 1.3 mm [0.050 in]) diameter anvils. * Measurements shall be taken at an applied anvil pressure of not less than 34 kPa (5 psi) or more than 69 kPa (10 psi) with the anvil center at 19 mm to 25 mm (3/4 in to 1 in) from the panel edge. * The location of the measurements shall be representative of general panel thickness at approximate mid-length, ± 50 mm (2 in) along each edge of the panel and the average of the four measurements shall be taken as the thickness of that panel (see Figure 6. Determining Thickness). If a measurement point contains a permissible grade characteristic that affects panel thickness, then the measurement point shall be shifted from that point. | |
| **Figure 6. Determining Thickness.**  **Take measurements at least**  **50 mm (2 in) in from each edge.** | |
|  | |
| 4.10.2.1. Labeling and Other Requirements for Structural Plywood and Wood-based Structural Panels | |
| **a. Structural Plywood Sheets** | |
|  | |
| 1. Shall be labeled in accordance with the latest version of Voluntary Product Standard PS 1-19 “Structural Plywood.” | |
|  | |
| 1. Includes grade, performance category (abbreviations: PERF CAT, CAT or Category are permitted), thickness, and mill number. | |
|  | |
| 1. Panel sizes are typically 1.2 m (4 ft) × 2.4 m (8 ft), or 2.7 m (9 ft) or 3 m (10 ft) on a nominal basis. | |
|  | |
| 1. Panel length and width information may be included on the label, tag, or printed directly on the unit. | |
|  | |
| 1. Panels shall bear the stamp of a qualified inspection and testing agency in accordance with the latest version of Voluntary Product Standard PS 1-19, “Structural Plywood,” Table 10, “Plywood Thickness” | |
|  | |
| 1. Panels shall bear the stamp of a qualified inspection and testing agency in accordance with the latest version of Voluntary Product Standard PS 1-19, “Structural Plywood,” Section 7.1. Certification. | |
|  | |
| 1. **Structural Panels** | |
|  | |
| 1. Shall be labeled in accordance with the latest version of Voluntary Product Standard PS 2-18 “Performance Standard for Wood-based Structural-Use Panels” for grade, span rating, performance ccategory (abbreviations PERF, CAT, CAT or Category are permitted), thickness and mill number. | |
|  | |
| 1. Performance category, such as 23/32 PERF CAT, means the sheet shall comply with thickness tolerances for 23/32 PERF CAT in the latest verson of Voluntary Product Standard PS 2-18 “Performance Standard for Wood-based Structural-Use Panels,” Table 1 – Panel Thickness Requirements. | |
|  | |
| 1. Panels shall bear the stamp of a qualified inspection and testing agency in accordance with the latest version of Voluntary Product Standard 2-18 “Performance Standard for Wood-based Structural-Use Panels,” Section 8.1. Certification. | |
| **Notes:**   1. When structural plywood sheets or structural panels are tested in retail stores, it is recommended that they be sorted by mill and then panel type (grade, thickness). 2. If a lot consists of mixed sheets or panels from different production runs and/or productions lots, be sure to record the codes for all sheets in the sample so the inspector and other interested parties can follow up on the information. 3. Record or attach a photograph of the information located on the grade stamp including the manufacturer, grade, standard (i.e., PS 1), mill number, and agency. | |
| 4.10.2.2. Moisture Shrinkage Allwance for Structural Plywood and Wood-based Structural Panels |
| Structural Plywood and Oriented Strand Board (OSB) shrink and swell with changes in moisture content. The standardized moisture content for Structural Plywood is 9 % (PS 1-19, “Structural Plywood,” Section 5.10. “Dimensional Tolerances and Squareness of Panels).” The equivalent standardized moisture content of OSB is 8 %. |
| 1. If the average error is a minus value, determine the moisture content on each piece using the latest version of ASTM D4442, “Standard Test Methods for Direct Moisture Content Measurement of Wood and Wood-Based Materials,” Method B. “Secondary Oven-Drying Method”.   **Note:** The inspection lot shall be put on hold (i.e., “inspection hold,” not permitted to be moved, sold, or otherwise distributed pending testing completion) while a determination is being made. |
|  |
| 1. Using a saw, cut a 15.24 cm × 15.24 cm (6 in × 6 in) piece from each sample at least 50 mm (2 in) from any edge. |
|  |
| 1. Tightly wrap each piece in aluminum foil and place each sample in a plastic bag to preserve moisture content during transport to the laboratory. |
|  |
| **a. Moisture Shrinkage Allowance – Thickness for Structural Plywood and OSB** |
|  |
| * 1. For structural plywood: 0.35 % adjustment per 1 % moisture content below 9 %. (see Table 4-1. “Determining Moisture Shrinkage Allowance for Structural Plywood”)   2. For OSB: 1.0 % adjustment per 1 % moisture content below 8 %. (see Table 4-2. “Determining Moisture Shrinkage Allowance for OSB”) |
|  |
| **b. Moisture Shrinkage Allowance – Length and Width for Structural Plywood and OSB** |
|  |
| 1. For Structural plywood: 0.04 % adjustment per 1 % moisture content below 9 %. (see Table 4-1. “Determining Moisture Shrinkage Allowance for Structural Plywood”) |
|  |
| 2. For OSB: 0.04 % adjustment per 1 % moisture content below 8 %. (see Table 4-2. “Determining Moisture Shrinkage Allowance for OSB”) |
|  |

| **Table 4-1. Determining Moisture Shrinkage Allowance for Structural Plywood** | | |
| --- | --- | --- |
| **If the Moisture Content is** | **Allow the Following Moisture Shrinkage Allowance for Thickness** | **Allow the Following Moisture Shrinkage Allowance for Length and Width** |
| 8.00 % - 8.99 % | 0.35 % | 0.04 % |
| 7.00 % - 7.99 % | 0.70 % | 0.08 % |
| 6.00 % - 6.99 % | 1.05 % | 0.12 % |
| 5.00 % - 5.99 % | 1.40 % | 0.16 % |
| 4.00 % - 4.99 % | 1.75 % | 0.20 % |
| 3.00 % - 3.99 % | 2.10 % | 0.24 % |
| 2.00 % - 2.99 % | 2.45 % | 0.28 % |
| 1.00 % - 1.99 % | 2.80 % | 0.32 % |
| 0.00 % - 0.99 % | 3.15 % | 0.36 % |

|  |  |  |
| --- | --- | --- |
| **Table 4-2. Determining Moisture Shrinkage Allowance for Oriented Strand Board (OSB)** | | |
| **If the Moisture Content is** | **Allow the Following Moisture Shrinkage Allowance for Thickness** | **Allow the Following Moisture Shrinkage Allowance for Length and Width** |
| 7.00 % - 7.99 % | 1.00 % | 0.04 % |
| 6.00 % - 6.99 % | 2.00 % | 0.08 % |
| 5.00 % - 5.99 % | 3.00 % | 0.12 % |
| 4.00 % - 4.99 % | 4.00 % | 0.16 % |
| 3.00 % - 3.99 % | 5.00 % | 0.20 % |
| 2.00 % - 2.99 % | 6.00 % | 0.24 % |
| 1.00 % - 1.99 % | 7.00 % | 0.28 % |
| 0.00 % - 0.99 % | 8.00 % | 0.32 % |

\*It is recommended that the inspector notify APA – The Engineered Wood Association, if any lots fail compliance.

APA

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|  |
| --- |
| 4.10.3 Evaluation of Results |
| 1. To determine lot conformance, return to Section 2.3.5. “Evaluate for Compliance.” |
|  |
| 1. Compliance with the Average Requirement and with the MAV in Appendix A., Table 2-8 “MAVs for Packages Labeled by Length, Width, or Area” is based on the average of multiple measurements on each sheet in the sample.  * Length – two measurements * Width – two measurements * Thickness – four measurements |
|  |
| 1. If the sample from the lot fails the Average Requirement, a statistical test is applied to a negative average error prior to determining if the sample passes or fails. |

(Added 2019)

## 4.11. Softwood Lumber

### 4.11.1. Test Equipment

* + For labeled dimension up to 304 mm (12 in) use a caliper with 0.01 mm (0.0005 in) graduations (or digital equivalent).
  + For labeled dimensions exceeding 304 mm (12 in), a steel linear measure with 1 mm or 1/16 in graduations.
* Set of gage blocks.
* Calculator
* Dimensional Lumber Worksheet
* Wood moisture meter (i.e., A meter equipped with a probe or dual probes and a hammer head handle for inserting the probes into the sample and that can have the moisture values manually or automatically corrected for different species of wood.)
* The latest version of U.S. Department of Commerce (DOC), Voluntary Product Standard PS-20 “American Softwood Lumber Standard.”

|  |
| --- |
| 4.11.2. Test Procedure This procedure may be used to verify the width, length, and thickness of regularly shaped dimensional lumber. Softwood lumber is generally represented by both the nominal dimension and the minimum dressed sizes. Testing is based on the minimum dressed sizes for both unseasoned (green) and dry lumber as found in the latest version of Voluntary Product Standard PS-20 “American Lumber Softwood Standard.” Lumber substitutes (i.e., composite) are not covered under Voluntary Product Standard PS-20 “American Lumber Softwood Standard.” and must be labeled by actual dimensions. |
|  |
| 1. Follow Section 2.3.1. “Define the Inspection Lot.” Use a “Category A” sampling plan in the inspection; select a random sample.    * The lot must be sorted by like items (i.e., species, grade, dry) including dimensions and mill number. Identify the nominal size of each piece (e.g., 38 mm × 89 mm [2 in × 4 in], 38 mm × 286 mm [2 in × 12 in], or 19 mm × 140 mm [1 in × 6 in]) and the minimum dressed size using the latest version of Voluntary Product Standards PS-20, “American Softwood Lumber Standard.”  * Conduct a visual inspection of each piece to ensure there are no signs of water or other damage. Remove any pieces (e.g., top, sides) that have damage or have been exposed to the elements (e.g., weather, rain, moisture, sun) from the lot. |
|  |
| 1. Verify the accuracy of the calipers using the gage blocks. Use the calipers to measure thickness and width and record the actual dimensions on the “Worksheet for Softwood Lumber.”  * For commodities labeled 3 m (10 ft) or less in length, take a minimum of three measurements across the thickness and three measurements across the width. Measurements should be evenly spaced at equal intervals (i.e., at locations approximately 1/4, 1/2, and 3/4 across the thickness and width). Calculate the average thickness and width measurement of each piece of wood. * For commodities labeled greater than 3 m (10 ft) in length, take one additional measurement per every additional 1.8 m (6 ft) or portion thereof.   **Note:** Do not take measurement within 150 mm (6 in) from the ends or in areas where the lumber has a knot or damage, this would affect the measursement. |
|  |
| 1. Use a steel linear measure to determine the length of the piece of wood and record the actual length on the worksheet.  * Take a minimum of three measurements across the length. Measurements should be evenly spaced at equal intervals (i.e., at locations across the length at approximate intervals of 1/4, 1/2, and 3/4 distance). Calculate the average length measurement of each piece of wood (see Figure 4-4. “Example of lumber dimensions measured.”)   **Note:** Do not take measurements in areas where the lumber has a knot or damage, this would affect the measurement.  section of lumber showing how to deterime to take measurements.  **Figure 4-4. Example of lumber dimensions measured.** |
| 4.11.2.1. Shrinkage Allowance Lumber is a product that shrinks and swells with changes in moisture content. The thickness and width of the lumber changes approximately 1 % for each 4 % change in moisture content and moisture shrinkage allowances shall be considered. The length of lumber changes only minimally (0.1 % to 0.2 %) when going from green to oven-dry, therefore no measurement adjustment or allowance is applicable to length measurements.   * 1. **Dry Lumber**   The latest version of Voluntary Product Standard PS-20 “American Softwood Lumber Standard” defines dry lumber as being 19 % or less in moisture content. |
|  |
| * 1. Compare the actual dimensions of thickness, width, and length of each piece to the minimum dressed sizes in NIST Handbook 130, “Uniform Regulation for the Method of Sale of Commodities” Table 1. “Softwood Lumber Sizes” and record the differences as errors on the worksheet. |
|  |
| 2. Calculate the average errors for thickness, width, and length. The dressed size can exceed the nominal value for an individual piece. |
|  |
| 1. If the average error for any thickness or width measurement is a minus value, or if the MAV is exceeded, perform a moisture test on each piece using a wood moisture meter to determine if a moisture shrinkage allowance should be applied. Apply the appropriate allowance to each piece, then re-calculate the average error and re-determine compliance with the MAV. If the average error is a minus value for any length measurement, or if the MAV is exceeded for any length measurement the lot fails.  No moisture shrinkage allowance is applied to length. (see Table 4-3. “Determining Moisture Shrinkage Allowance for Dry Lumber Thickness and Width Dimensions Only”)  * If the moisture content of the piece is equal to or greater than 19 %, the sample piece fails. No moisture shrinkage allowance is provided. |

|  |  |
| --- | --- |
| **Table 4-3. Determining Moisture Shrinkage Allowance for Dry Lumber**  **Thickness and Width Dimensions Only** | |
| **If the Moisture Content is:** | **Allow the Following Moisture Shrinkage Allowance:** |
| 15.00 % - 18.99 % | 1.00 % |
| 0.70 % for Redwood, Western Red Cedar, and Northern White Cedar |
| 11.00 % - 14.99 % | 2.00 % |
| 1.40 % for Redwood, Western Red Cedar, and Northern White Cedar |
| 7.00 % - 10.99 % | 3.00 % |
| 2.10 % for Redwood, Western Red Cedar, and Northern White Cedar |
| 3.00 % - 6.99 % | 4.00 % |
| 2.80 % for Redwood, Western Red Cedar, and Northern White Cedar |

|  |
| --- |
| * + - 1. **Unseasoned (Green) Lumber**   The latest version of Voluntary Product Standard PS 20 “American Lumber Softwood Standard” defines unseasoned (green) lumber as being over 19 % in moisture content.   * + 1. Compare the actual dimensions of thickness, width, and length of each piece to the minimum dressed sizes in NIST Handbook 130, “Uniform Regulation for the Method of Sale of Commodities,” Table 1. “Softwood Lumber Sizes” and record the differences as errors on the worksheet.     2. Calculate the average errors for thickness, width, and length. The dressed size can exceed the nominal value for an individual piece.  1. If the average error for any thickness or width measurement is a minus value, or if the MAV is exceeded, perform a moisture test on each piece using a wood moisture meter to determine if a moisture shrinkage allowance should be applied. Apply the appropriate allowance to each piece, then re-calculate the average error and re-determine compliance with the MAV. If the average error is a minus value for any length measurement, or if the MAV is exceeded for any length measurement the lot fails. No moisture shrinkage allowance is applied to length.  * If the moisture content of the piece is equal to or greater than 30 % the sample piece fails. No moisture allowance is provided. (see Table 4-4. “Determining Moisture Shrinkage Allowance for Unseasoned (Green) Lumber Thickness and Width Dimensions Only”) |

| **Table 4-4. Determining Moisture Shrinkage Allowance for Unseasoned (Green) Lumber**  **Thickness and Width Dimensions Only** | |
| --- | --- |
| **If the Moisture Content is** | **Allow the Following Moisture Shrinkage Allowance** |
| 26.00 % - 29.99 % | 1.00 % |
| 0.70 % for Redwood, Western Red Cedar, and Northern White Cedar |
| 22.00 % - 25.99 % | 2.00 % |
| 1.40 % for Redwood, Western Red Cedar, and Northern White Cedar |
| 18.00 % - 21.99 % | 3.00 % |
| 2.10 % for Redwood, Western Red Cedar, and Northern White Cedar |
| 14.00 % - 17.99 % | 4.00 % |
| 2.80 % for Redwood, Western Red Cedar, and Northern White Cedar |
| 10.00 % - 13.99 % | 5.00 % |
| 3.50 % for Redwood, Western Red Cedar, and Northern White Cedar |
| 6.00 % - 9.99 % | 6.00 % |
| 4.20 % for Redwood, Western Red Cedar, and Northern White Cedar |
| 2.00 % - 5.99 % | 7.00 % |
| 4.90 % for Redwood, Western Red Cedar, and Northern White Cedar |

|  |
| --- |
| 4.11.3. Evaluation of Results |
| 1. To determine lot conformance, return to Section 2.3.7. “Evaluate for Compliance.” |
|  |
| 1. If the sample pieces do not meet the average and MAV requirement based on the minimum dressed sizes after the shrinkage (moisture) allowances are considered, the lot fails. Place the Inspection Lot on hold.   \*Inspectors should notify the American Lumber Standard Committee (ALSC) of any lots that fail compliance. |
| \*Inspectors should notify the American Lumber Standard Committee (ALSC) of any lots that fail compliance.  American Lumber Standard Committee, Inc.  7470 New Technology Way, Suite F.  Frederick, MD 21703  (301) 972-1700 or (301) 540-8004  E-mail:[**alsc@alsc.org**](mailto:alsc@alsc.org)URL:[**www.alsc.org**](http://www.alsc.org/) |

(Added 2019)

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# Appendix A. Tables

| Table 1-1. Agencies Responsible for Package Regulations and Applicable Requirements | | | |
| --- | --- | --- | --- |
| **Commodity** | **Responsible Agency** | **NIST Handbook 133 Sampling Plans** | **Table of Maximum Allowable Variations** |
| Meat, Poultry, and Siluriformes\*  \*Siluriformes include, but are not limited to, “catfish” (fish of the family lctaluridae) and “basa” and “swai” (fish of the family Pangasiidae). | U.S. Department of Agriculture, Food Safety and Inspection Service and state and local weights and measures.  [www.nist.gov/pml/wmd/](http://www.nist.gov/pml/wmd/) | **Use Table 2‑1.** Sampling Plans for Category A to test packages at other than point of pack.  **Use Table 2‑2.** Sampling Plans for Category B to test packages in federally inspected meat and poultry plants. | **Table 2‑9.**  U.S. Department of Agriculture, Meat, Poultry, and Siluriformes Groups and Lower Limits for Individual Packages |
| Foods, drugs, and cosmetics subject to the Food, Drug, and Cosmetic Act including those packaged at the retail store level that have been in interstate commerce (e.g., seafood) or those made with ingredients that have been in interstate commerce and beer made from substitutes for malted barley (e.g., sorghum, rice, or wheat) and wine beverages with an alcohol content of less than 7 % by volume | U.S. Food and Drug Administration and state and local weights and measures  [www.fda.gov](http://www.fda.gov/) | **Use Table 2‑1.** Sampling Plans for Category A to test packages at all locations. | **Table 2‑5.** MAVs for Packages Labeled by Weight  **Table 2‑6.** MAVs for Packages Labeled by Liquid or Dry Volume  **Table 2‑7.** MAVs for Packages Labeled by Count  **Table 2‑8.** MAVs for Packages Labeled by Length (Width) or Area  ***Table 1-1. Continued on next page***  **Table 2‑10.** Exceptions to the MAVs for Textiles, Polyethylene Sheeting and Film, Mulch and Soil Labeled by Volume, Packaged Firewood and Stove Wood Labeled by Volume, and Packages Labeled by Count with 50 Items or Fewer, and Specific Agricultural Seeds Labeled by Count |
| Tobacco | U.S. Food and Drug Administration and local weights and measures  [www.fda.gov](http://www.fda.gov/) |
| Food products not subject to the Federal Food, Drug, and Cosmetic Act, including meat and poultry products packaged at the retail store level | State and local weights and measures  [www.nist.gov/pml/wmd/](http://www.nist.gov/pml/wmd/) |
| Non-food Consumer Products | Federal Trade Commission  [www.ftc.gov](http://www.ftc.gov/) |
| Non-food Consumer and Non-consumer Products | State and local weights and measures  [www.nist.gov/pml/weights-and-measures/resources/state-directors-c](https://www.nist.gov/pml/weights-and-measures/resources/state-directors-c) |  |
| Alcohol Products, except for beer made from substitutes for malted barley (e.g., sorghum, rice, or wheat) and wine beverages with an alcohol content of less than 7 % by volume, which are regulated by FDA | Alcohol and Tobacco Tax and Trade Bureau. State and local weights and measures  [www.ttb.gov](http://www.ttb.gov/) |
| Pesticides  (Refer to Section 1.4.1. “Net Quantity of Contents Compliance Requirements for Pesticides Labeled with Minimum Net Quantity of Contents Declarations.”) | U.S. Environmental Protection Agency and state and local weights and measures  [www.epa.gov](http://www.epa.gov/) |

(Amended 2018)

| Table 2-1. Sampling Plans for Category A | | | | | |
| --- | --- | --- | --- | --- | --- |
| **1** | **2** | **3** | **4** | **5** | **6** |
| **Inspection Lot**  **Size** | **Sample**  **Size** | **Sample Correction**  **Factor** | **Number of Minus Package Errors Allowed to Exceed the MAV1** | **Initial Tare Sample Size2** | |
| **Glass and Aerosol Packages** | **All Other Packages** |
| 1 | 1 | Apply MAV | 01 | 2 | 2 |
| 2 | 2 | 8.985 |
| 3 | 3 | 2.484 |
| 4 | 4 | 1.591 |
| 5 | 5 | 1.242 |
| 6 | 6 | 1.049 |
| 7 | 7 | 0.925 |
| 8 | 8 | 0.836 |
| 9 | 9 | 0.769 |
| 10 | 10 | 0.715 |
| 11 | 11 | 0.672 |
| 12 to 250 | 12 | 0.635 |
| 251 to 3 200 | 24 | 0.422 | 3 |
| More than 3 200 | 48 | 0.290 | 11 |
| 1For mulch and soils packaged by volume see Table 2‑10. Exceptions to the Maximum Allowable Variations – 1 package may exceed the MAV for every 12 packages in the sample.  2If sample size is 11 or fewer, the initial tare sample size and the total tare sample size is 2 samples. | | | | | |

| Table 2-2. Sampling Plans for Category B  (for Use in USDA-Inspected Meat and Poultry Plants Only) | | | |
| --- | --- | --- | --- |
| **1** | **2** | **3** | **4** |
| **Inspection Lot Size** | **Sample Size** | **Initial Tare Sample Size** | **Number of Packages Allowed to Exceed the MAVs in Table 2‑9** |
| 250 or Fewer | 10 | 2 | 0 |
| 251 or More | 30 | 5 |

| Table 2‑3. Category A | | | | | |
| --- | --- | --- | --- | --- | --- |
|  | **Total Number of Packages in Tare Sample**  **Note:**  Total number of packages to be opened for tare determination. Numbers include those packages opened for initial tare sample. | | | | |
| **Sample Size** | **12** | **24** | | **48** | |
| **Initial Tare Sample Size** | **2** | **2** | **3** | **2** | **3** |
| **Ratio of Rc/Rt** |  | | | | |
| If range of tare equals “zero,” use Initial Tare Sample Size.  If the ratio is “zero” based on a “zero” range of package error, open all of the packages in the sample. | 2 | 2 | 3 | 2 | 3 |
| If the ratio is greater than 0 but less than or equal to 0.2 | 12 | 24 | 24 | 48 | 48 |
| 0.21 to 0.60 | 12 | 24 | 24 | 48 | 48 |
| 0.61 to 0.70 | 12 | 24 | 24 | 47 | 47 |
| 0.71 to 0.80 | 12 | 23 | 23 | 47 | 47 |
| 0.81 to 1.00 | 12 | 23 | 23 | 46 | 46 |
| 1.01 to 1.10 | 11 | 23 | 23 | 46 | 46 |
| 1.11 to 1.20 | 11 | 23 | 23 | 45 | 45 |
| 1.21 to 1.30 | 11 | 22 | 22 | 45 | 45 |
| 1.31 to 1.50 | 11 | 22 | 22 | 44 | 44 |
| 1.51 to 1.60 | 11 | 22 | 22 | 43 | 43 |
| 1.61 to 1.70 | 11 | 21 | 21 | 42 | 42 |
| 1.71 to 1.80 | 10 | 21 | 21 | 42 | 42 |
| 1.81 to 1.90 | 10 | 21 | 21 | 41 | 41 |
| 1.91 to 2.00 | 10 | 20 | 20 | 41 | 41 |
| 2.01 to 2.10 | 10 | 20 | 20 | 40 | 40 |
| 2.11 to 2.20 | 10 | 20 | 20 | 39 | 39 |
| 2.21 to 2.30 | 10 | 19 | 19 | 39 | 39 |
| 2.31 to 2.40 | 9 | 19 | 19 | 38 | 38 |
| 2.41 to 2.50 | 9 | 19 | 19 | 37 | 37 |
| 2.51 to 2.60 | 9 | 18 | 18 | 37 | 37 |
| 2.61 to 2.70 | 9 | 18 | 18 | 36 | 36 |
| 2.71 to 2.80 | 9 | 18 | 18 | 35 | 35 |
| 2.81 to 2.90 | 9 | 17 | 17 | 34 | 34 |
| 2.91 to 3.00 | 8 | 17 | 17 | 34 | 34 |
| 3.01 to 3.10 | 8 | 17 | 17 | 33 | 33 |
| 3.11 to 3.30 | 8 | 16 | 16 | 32 | 32 |
| 3.31 to 3.40 | 8 | 16 | 16 | 31 | 31 |
| 3.41 to 3.50 | 8 | 15 | 15 | 30 | 30 |
| 3.51 to 3.60 | 7 | 15 | 15 | 30 | 30 |
| 3.61 to 3.70 | 7 | 15 | 15 | 29 | 29 |
| 3.71 to 3.90 | 7 | 14 | 14 | 28 | 28 |
| 3.91 to 4.00 | 7 | 14 | 14 | 27 | 27 |
| 4.01 to 4.10 | 7 | 13 | 13 | 27 | 27 |
| 4.11 to 4.20 | 7 | 13 | 13 | 26 | 26 |
| 4.21 to 4.30 | 6 | 13 | 13 | 25 | 25 |
| 4.31 to 4.40 | 6 | 12 | 12 | 25 | 25 |
| 4.41 to 4.60 | 6 | 12 | 12 | 24 | 24 |
| 4.61 to 4.70 | 6 | 12 | 12 | 23 | 23 |
| 4.71 to 4.80 | 6 | 11 | 11 | 23 | 23 |
| 4.81 to 4.90 | 6 | 11 | 11 | 22 | 22 |
| 4.91 to 5.00 | 5 | 11 | 11 | 22 | 22 |
| 5.01 to 5.10 | 5 | 11 | 11 | 21 | 21 |
| 5.01 to 5.10 | 5 | 11 | 11 | 21 | 21 |
| 5.11 to 5.20 | 5 | 10 | 10 | 21 | 21 |
| 5.21 to 5.40 | 5 | 10 | 10 | 20 | 20 |
| 5.41 to 5.60 | 5 | 10 | 10 | 19 | 19 |
| 5.61 to 5.70 | 5 | 9 | 9 | 19 | 19 |
| 5.71 to 5.80 | 5 | 9 | 9 | 18 | 18 |
| 5.81 to 5.90 | 4 | 9 | 9 | 18 | 18 |
| 5.91 to 6.10 | 4 | 9 | 9 | 17 | 17 |
| 6.11 to 6.20 | 4 | 8 | 8 | 17 | 17 |
| 6.21 to 6.50 | 4 | 8 | 8 | 16 | 16 |
| 6.51 to 6.70 | 4 | 8 | 8 | 15 | 15 |
| 6.71 to 6.80 | 4 | 7 | 7 | 15 | 15 |
| 6.81 to 7.00 | 4 | 7 | 7 | 14 | 14 |
| 7.01 to 7.20 | 3 | 7 | 7 | 14 | 14 |
| 7.21 to 7.40 | 3 | 7 | 7 | 13 | 13 |
| 7.41 to 7.60 | 3 | 6 | 6 | 13 | 13 |
| 7.61 to 8.00 | 3 | 6 | 6 | 12 | 12 |
| 8.01 to 8.20 | 3 | 6 | 6 | 11 | 11 |
| 8.21 to 8.50 | 3 | 5 | 5 | 11 | 11 |
| 8.51 to 8.80 | 3 | 5 | 5 | 10 | 10 |
| 8.81 to 9.00 | 2 | 5 | 5 | 10 | 10 |
| 9.01 to 9.30 | 2 | 5 | 5 | 9 | 9 |
| 9.31 to 9.70 | 2 | 4 | 4 | 9 | 9 |
| 9.71 to 10.40 | 2 | 4 | 4 | 8 | 8 |
| 10.41 to 10.90 | 2 | 4 | 4 | 7 | 7 |
| 10.91 to 11.30 | 2 | 3 | 3 | 7 | 7 |
| 11.31 to 12.50 | 2 | 3 | 3 | 6 | 6 |
| 12.51 to 13.20 | 2 | 3 | 3 | 5 | 5 |
| 13.21 to 13.90 | 2 | 2 | 3 | 5 | 5 |
| 13.91 to 16.00 | 2 | 2 | 3 | 4 | 4 |
| 16.01 to 19.10 | 2 | 2 | 3 | 3 | 3 |
| 19.11 to 19.20 | 2 | 2 | 3 | 2 | 3 |
| **Initial Tare Sample Size** | **2** | **2** | **3** | **2** | **3** |

| Table 2‑4. Category B | | |
| --- | --- | --- |
|  | **Total Number of Packages in Tare Sample**  **Note:**Total number of packages to be opened for tare determination. Numbers include those packages opened for initial tare sample. | |
| **Sample Size** | **10** | **30** |
| **Initial Tare Sample Size** | **2** | **5** |
| **Ratio of Rc/Rt** |  |  |
| If the ratio is zero, based on a “zero” range of tare, use Initial Tare Sample Size.  If the ratio is “zero” based on a “zero” range of package errors, open all the packages in the sample. | 2 | 5 |
| If the ratio is greater than 0 but less than or equal to 0.2 | 10 | 30 |
| 0.21 to 0.40 | 10 | 29 |
| 0.41 to 0.60 | 10 | 28 |
| 0.61 to 0.80 | 9 | 26 |
| 0.81 to 1.00 | 8 | 24 |
| 1.01 to 1.20 | 8 | 23 |
| 1.21 to 1.40 | 7 | 21 |
| 1.41 to 1.60 | 7 | 19 |
| 1.61 to 1.80 | 6 | 17 |
| 1.81 to 2.00 | 5 | 15 |
| 2.01 to 2.20 | 5 | 14 |
| 2.21 to 2.40 | 5 | 13 |
| 2.41 to 2.60 | 4 | 12 |
| 2.61 to 2.80 | 4 | 11 |
| 2.81 to 3.00 | 4 | 10 |
| 3.01 to 3.20 | 3 | 9 |
| 3.21 to 3.60 | 3 | 8 |
| 3.61 to 3.80 | 3 | 7 |
| 3.81 to 4.40 | 2 | 6 |
| If the ratio is greater than 4.40, use the Initial Tare Sample Size | 2 | 5 |

| Table 2‑5. Maximum Allowable Variations (MAVs) for Packages Labeled by Weight  Do Not Use this Table for Meat and Poultry Products Subject to USDA Regulations – Use Table 2‑9.  For Polyethylene Sheeting and Film, see Table 2‑10. Exceptions to the MAVs. | |
| --- | --- |
| **Labeled Quantity** | **Maximum Allowable Variations** |
| Less than 36 g, 0.08 lb, or 1.28 oz | 10 % of labeled quantity |
| 36 g or more to 54 g  **0.08 lb or more to 0.12 lb**  1.28 oz or more to 1.92 oz | 3.6 g  **0.008 lb**  1/8 oz |
| More than 54 g to 81 g  **More than 0.12 lb to 0.18 lb**  More than 1.92 oz to 2.88 oz | 5.4 g  **0.012 lb**  3/16 oz |
| More than 81 g to 117 g  **More than 0.18 lb to 0.26 lb**  More than 2.88 oz to 4.16 oz | 7.2 g  **0.016 lb**  ¼ oz |
| More than 117 g to 154 g  **More than 0.26 lb to 0.34 lb**  More than 4.16 oz to 5.44 oz | 9.0 g  **0.020 lb**  5/16 oz |
| More than 154 g to 208 g  **More than 0.34 lb to 0.46 lb**  More than 5.44 oz to 7.36 oz | 10.8 g  **0.024 lb**  3/8 oz |
| More than 208 g to 263 g  **More than 0.46 lb to 0.58 lb**  More than 7.36 oz to 9.28 oz | 12.7 g  **0.028 lb**  7/16 oz |
| More than 263 g to 317 g  **More than 0.58 lb to 0.70 lb**  More than 9.28 oz to 11.20 oz | 14.5 g  **0.032 lb**  1/2 oz |
| More than 317 g to 381 g  **More than 0.70 lb to 0.84 lb**  More than 11.20 oz to 13.44 oz | 16.3 g  **0.036 lb**  9/16 oz |
| More than 381 g to 426 g  **More than 0.84 lb to 0.94 lb**  More than 13.44 oz to 15.04 oz | 18.1 g  **0.040 lb**  5/8 oz |
| More than 426 g to 489 g  **More than 0.94 lb to 1.08 lb**  More than 15.04 oz to 17.28 oz | 19.9 g  **0.044 lb**  11/16 oz |
| More than 489 g to 571 g  More than 1.08 lb to 1.26 lb | 21.7 g  0.048 lb |
| More than 571 g to 635 g  More than 1.26 lb to 1.40 lb | 23.5 g  0.052 lb |
| More than 635 g to 698 g  More than 1.40 lb to 1.54 lb | 25.4 g  0.056 lb |
| More than 698 g to 771 g  More than 1.54 lb to 1.70 lb | 27.2 g  0.060 lb |
| More than 771 g to 852 g  More than 1.70 lb to 1.88 lb | 29.0 g  0.064 lb |
| More than 852 g to 970 g  More than 1.88 lb to 2.14 lb | 31.7 g  0.070 lb |
| More than 970 g to 1.12 kg  More than 2.14 lb to 2.48 lb | 35.3 g  0.078 lb |
| More than 1.12 kg to 1.25 kg  More than 2.48 lb to 2.76 lb | 39.0 g  0.086 lb |
| More than 1.25 kg to 1.45 kg  More than 2.76 lb to 3.20 lb | 42.6 g  0.094 lb |
| More than 1.45 kg to 1.76 kg  More than 3.20 lb to 3.90 lb | 49 g  0.11 lb |
| More than 1.76 kg to 2.13 kg  More than 3.90 lb to 4.70 lb | 54 g  0.12 lb |
| More than 2.13 kg to 2.63 kg  More than 4.70 lb to 5.80 lb | 63 g  0.14 lb |
| More than 2.63 kg to 3.08 kg  More than 5.80 lb to 6.80 lb | 68 g  0.15 lb |
| More than 3.08 kg to 3.58 kg  More than 6.80 lb to 7.90 lb | 77 g  0.17 lb |
| More than 3.58 kg to 4.26 kg  More than 7.90 lb to 9.40 lb | 86 g  0.19 lb |
| More than 4.26 kg to 5.30 kg  More than 9.40 lb to 11.70 lb | 99 g  0.22 lb |
| More than 5.30 kg to 6.48 kg  More than 11.70 lb to 14.30 lb | 113 g  0.25 lb |
| More than 6.48 kg to 8.02 kg  More than 14.30 lb to 17.70 lb | 127 g  0.28 lb |
| More than 8.02 kg to 10.52 kg  More than 17.70 lb to 23.20 lb | 140 g  0.31 lb |
| More than 10.52 kg to 14.33 kg  More than 23.20 lb to 31.60 lb | 167 g  0.37 lb |
| More than 14.33 kg to 19.23 kg  More than 31.60 lb to 42.40 lb | 199 g  0.44 lb |
| More than 19.23 kg to 24.67 kg  More than 42.40 lb to 54.40 lb | 226 g  0.50 lb |
| More than 24.67 kg  More than 54.40 lb | 2 % of labeled quantity |

(Amended 2004)

| Table 2‑6. Maximum Allowable Variations (MAVs) for Packages Labeled by  Liquid and Dry Volume  Do Not Use this Table for Meat and Poultry Products Subject to USDA Regulations.  For Mulch, see Table 2‑10. Exceptions to the Maximum Allowable Variations,  Use Table 2‑9 for USDA –Regulated Products. | |
| --- | --- |
| **Labeled Quantity** | **Maximum Allowable Variations (MAVs)** |
| 3 mL or less  **0.50 fl oz or less**  0.18 in3 or less | 0.5 mL  **0.02 fl oz**  0.03 in3 |
| More than 3 mL to 8 mL  More than 0.18 in3 to 0.49 in3 | 1.0 mL  0.06 in3 |
| More than 8 mL to 14 mL  More than 0.49 in3 to 0.92 in3 | 1.5 mL  0.09 in3 |
| More than 14 mL to 22 mL  **More than 0.50 fl oz to 0.75 fl oz**  More than 0.92 in3 to 1.35 in3 | 1.7 mL  **0.06 fl oz**  0.10 in3 |
| More than 22 mL to 66 mL  **More than 0.75 fl oz to 2.25 fl oz**  More than 1.35 in3 to 4.06 in3 | 3.8 mL  **0.13 fl oz**  0.23 in3 |
| More than 66 mL to 125 mL  **More than 2.25 fl oz to 4.25 fl oz**  More than 4.06 in3 to 7.66 in3 | 5.6 mL  **0.19 fl oz**  0.34 in3 |
| More than 125 mL to 170 mL  **More than 4.25 fl oz to 5.75 fl oz**  More than 7.66 in3 to 10.37 in3 | 7.3 mL  **0.25 fl oz**  0.45 in3 |
| More than 170 mL to 221 mL  **More than 5.75 fl oz to 7.50 fl oz**  More than 10.37 in3 to 13.53 in3 | 9.1 mL  **0.31 fl oz**  0.55 in3 |
| More than 221 mL to 347 mL  **More than 7.50 fl oz to 11.75 fl oz**  More than 13.53 in3 to 21.20 in3 | 11.2 mL  **0.38 fl oz**  0.68 in3 |
| More than 347 mL to 502 mL  **More than 11.75 fl oz to 17.00 fl oz**  More than 21.20 in3 to 30.67 in3 | 14.7 mL  **0.5 fl oz**  0.90 in3 |
| More than 502 mL to 621 mL  **More than 17 fl oz to 21 fl oz**  More than 30.67 in3 to 37.89 in3 | 18.6 mL  **0.63 fl oz**  1.13 in3 |
| More than 621 mL to 798 mL  **More than 21 fl oz to 27 fl oz**  More than 37.89 in3 to 48.72 in3 | 22.1 mL  **0.75 fl oz**  1.35 in3 |
| More than 798 mL to 916 mL  **More than 27 fl oz to 31 fl oz**  More than 48.72 in3 to 55.94 in3 | 26.0 mL  **0.88 fl oz**  1.58 in3 |
| More than 916 mL to 1.15 L  **More than 31 fl oz to 39 fl oz**  More than 55.94 in3 to 70.38 in3 | 29 mL  **1 fl oz**  1.80 in3 |
| More than 1.15 L to 1.62 L  **More than 39 fl oz to 55 fl oz**  More than 70.38 in3 to 99.25 in3 | 36 mL  **1.25 fl oz**  2.25 in3 |
| More than 1.62 L to 2.04 L  **More than 55 fl oz to 69 fl oz**  More than 99.25 in3 to 124.5 in3 | 44 mL  **1.5 fl oz**  2.70 in3 |
| More than 2.04 L to 2.51 L  **More than 69 fl oz to 85 fl oz**  More than 124.5 in3 to 153.3 in3 | 51 mL  **1.75 fl oz**  3.1 in3 |
| More than 2.51 L to 3.04 L  **More than 85 fl oz to 103 fl oz**  More than 153.3 in3 to 185.8 in3 | 59 mL  **2 fl oz**  3.6 in3 |
| More than 3.04 L to 4.73 L  **More than 103 fl oz to 160 fl oz**  More than 185.8 in3 to 288.7 in3 | 73 mL  **2.5 fl oz**  4.5 in3 |
| More than 4.73 L to 5.48 L  **More than 160 fl oz to 185.6 fl oz**  More than 288.7 in3 to 334.9 in3 | 88 mL  **3 fl oz**  5.4 in3 |
| More than 5.48 L to 7.09 L  **More than 185.6 fl oz to 240 fl oz**  More than 334.9 in3 to 443.1 in3 | 103 mL  **3.5 fl oz**  6.3 in3 |
| More than 7.09 L to 8.04 L  **More than 240 fl oz to 272 fl oz**  More than 443.1 in3 to 490.8 in3 | 118 mL  **4 fl oz**  7.2 in3 |
| More than 8.04 L to 10.17 L  **More than 272 fl oz to 344 fl oz**  More than 490.8 in3 to 620.8 in3 | 133 mL  **4.5 fl oz**  8.1 in3 |
| More than 10.17 L to 11.59 L  **More than 344 fl oz to 392 fl oz**  More than 620.8 in3 to 707.4 in3 | 147 mL  **5 fl oz**  9.0 in3 |
| More than 11.59 L to 16.56 L  **More than 392 fl oz to 560 fl oz**  More than 707.4 in3 to 1 010 in3 | 177 mL  **6 fl oz**  10.8 in3 |
| More than 16.56 L to 18.92 L  **More than 560 fl oz to 640 fl oz (5 gal)**  More than 1 010 in3 into 1 155 in3 | 207 mL  **7 fl oz**  12.6 in3 |
| More than 18.92 L to 23.65 L  **More than 640 fl oz to 800 fl oz**  More than 1 155 in3 to 1 443 in3 | 236 mL  **8 fl oz**  14.4 in3 |
| More than 23.65 L to 26.73 L  **More than 800 fl oz to 904 fl oz**  More than 1 443 in3 to 1 631 in3 | 266 mL  **9 fl oz**  16.2 in3 |
| More than 26.73 L  **More than 904 fl oz**  More than 1 631 in3 | **1 % of labeled quantity** |

(Amended 2004)

| Table 2‑7. Maximum Allowable Variations (MAVs) for Packages Labeled by Count | |
| --- | --- |
| **Labeled Quantity** | **Maximum Allowable Variations (MAVs)** |
| 17 or less | 0 |
| 18 to 50 | 1 |
| 51 to 83 | 2 |
| 84 to 116 | 3 |
| 117 to 150 | 4 |
| 151 to 200 | 5 |
| 201 to 240 | 6 |
| 241 to 290 | 7 |
| 291 to 345 | 8 |
| 346 to 400 | 9 |
| 401 to 465 | 10 |
| 466 to 540 | 11 |
| 541 to 625 | 12 |
| 626 to 725 | 13 |
| 726 to 815 | 14 |
| 816 to 900 | 15 |
| 901 to 990 | 16 |
| 991 to 1075 | 17 |
| 1076 to 1165 | 18 |
| 1166 to 1250 | 19 |
| 1251 to 1333 | 20 |
| 1334 or more | **1.5 % of labeled count rounded off to the nearest whole number** |

| Table 2‑8. Maximum Allowable Variations (MAVs) for Packages  Labeled by Length, Width, or Area  (For Textiles, Polyethylene Sheeting and Film – Use Table 2‑10. Exceptions to the MAVs) | |
| --- | --- |
| **Labeled Quantity** | **Maximum Allowable Variations (MAVs)**  **of Labeled Quantity** |
| 1 m or less  1 yd or less | 3 % |
| More than 1 m to 43 m  More than 1 yd to 48 yd | 1.5 % |
| More than 43 m to 87 m  More than 48 yd to 96 yd | 2 % |
| More than 87 m to 140 m  More than 96 yd to 154 yd | 2.5 % |
| More than 140 m to 301 m  More than 154 yd to 330 yd | 3 % |
| More than 301 m to 1 005 m  More than 330 yd to 1 100 yd | 4 % |
| More than 1 005 m or 1 100 yd | 5 % |
| **Maximum Allowable Variations (MAV) for Packages Labeled by Area** | |
| The MAV for packages labeled by area is 3 % of labeled quantity. | |

(Amended 2004)

| Table 2‑9. U.S. Department of Agriculture, Meat, Poultry, and Siluriformes Groups and Lower Limits for Individual Packages (Maximum Allowable Variations [MAVs]) | | |
| --- | --- | --- |
| **Definition of Group and Labeled Quantity** | | **Lower Limit for Individual Weights (MAVs)** |
| **Homogenous Fluid**  **When Filled**  (e.g., baby food or containers of lard) | **All Other Products** |
| Less than 85 g or 3 oz | | 10 % of labeled quantity |
| 85 g or more to 453 g  3 oz or more to 16 oz |  | 7.1 g  0.016 lb (0.25 oz) |
| More than 453 g  More than 16 oz | 85 g or more to 198 g  3 oz to 7 oz | 14.2 g  0.031 lb (0.5 oz) |
|  | More than 198 g to 1.36 kg  7 oz to 48 oz | 28.3 g  0.062 lb (1 oz) |
|  | More than 1.36 kg to 4.53 kg  More than 48 oz to 160 oz | 42.5 g  0.094 lb (1.5 oz) |
|  | More than 4.53 kg  More than 160 oz | 1 % of labeled quantity |

(Amended 2018)

| Table 2‑10. Exceptions to the Maximum Allowable Variations (MAVs) for Textiles, Polyethylene Sheeting and Film, Mulch and Soil Labeled by Volume, Packaged Firewood and Stove Wood Labeled by Volume, and Packages Labeled by Count with 50 Items or Fewer, and Specific Agricultural Seeds Labeled by Count. | |
| --- | --- |
|  | **Maximum Allowable Variations (MAVs)** |
| **Polyethylene Sheeting and Film** | **Thickness**  When the labeled thickness is 25 µm (1 mil or 0.001 in) or less, any individual thickness measurement of polyethylene film may be up to 35 % below the labeled thickness.  When the labeled thickness is greater than 25 µm (1 mil or 0.001 in), individual thickness measurements of polyethylene sheeting may be up to 20 % less than the labeled thickness.  The average thickness of a single package of polyethylene sheeting may be up to 4 % less than the labeled thickness.  **Weight**  The MAV for individual packages of polyethylene sheeting and film shall be 4 % of the labeled quantity. |
| **Textiles** | The MAVs are:  For packages labeled with dimensions of 60 cm (24 in) or more:  3 % of the labeled quantity for negative errors; and  6 % of the labeled quantity for plus errors.  For packages labeled with dimensions less than 60 cm (24 in):  6 % of the labeled quantity for negative errors; and  12 % for plus errors. |
| **Mulch And Soil Labeled By Volume** | The MAVs are:  For individual packages: 5 % of the labeled volume.  For samples: One package may exceed the MAV for every 12 packages in the sample (e.g., when the sample size is 12 or fewer, 1 package may exceed the MAV and when the sample size is 48 packages, 4 packages may exceed the MAV). |
| **Packaged Firewood and Stove Wood Labeled by Volume** | 20 % of labeled quantity  Note: Use Table 2-5 “Maximum Allowable Variations for Packages Labeled by Weight” for packaged artificial and compressed fireplace logs and stove wood pellets and chips labeled by weight. |
| **Specific Agricultural**  **Seeds Labeled**  **By Count** | The MAVS are:  For corn seed: 2 % of the labeled count  For soybean seed: 4 % of the labeled count  For field bean seed: 5 % of the labeled count  For wheat seed: 3 % of the labeled count |
| **Animal Bedding** | 5 % of the labeled volume |

(Amended 2010 and 2016)

| Table 2‑11. Sampling Plans and Accuracy Requirements for Packages Labeled by Low Count (50 or Fewer) and Packages Given Tolerances (Glass and Stemware) | | | |
| --- | --- | --- | --- |
|  | **1** | **2** | **3** |
| **Inspection Lot**  **Size** | **Sample Size** | **For Packages Labeled by Low Count**  **(50 or Fewer)** | **For Packages Given Tolerances**  **(Glasses and Stemware)** |
| **Number of Packages Allowed to Contain Less than the Labeled Count** | **Number of Package Errors that May Exceed the Allowable Difference** |
| 1 – 11 | 1-11 | 1 | 0 |
| 12 – 250 | 12 | 1 | 0 |
| 251 – 3200 | 24 | 2 | 1 |
| More than 3200 | 48 | 3 | 2 |

(Amended 2004)

# Appendix B. Random Number Tables

*Reproduced from Million Random Digits, used with permission of the Rand Corporation, Copyright, 1955, The Free Press (*[**www.rand.org/publications/classics/randomdigits**](http://www.rand.org/publications/classics/randomdigits))

All of the sampling plans presented in this handbook are based on the assumption that the packages constituting the sample are chosen at random from the inspection lot. Randomness in this instance means that every package in the lot has an equal chance of being selected as part of the sample. It does not matter what other packages have already been chosen, what the package net contents are, or where the package is located in the lot.

To obtain a random sample, two steps are necessary. First it is necessary to identify each package in the lot of packages with a specific number whether on the shelf, in the warehouse, or coming off the packaging line. Then it is necessary to obtain a series of random numbers. These random numbers indicate exactly which packages in the lot shall be taken for the sample.

**The Random Number Table**

The random number tables in Appendix B are composed of the digits from 0 through 9, with approximately equal frequency of occurrence. This appendix consists of 8 pages. On each page digits are printed in blocks of columns and blocks of rows. The printing of the table in blocks is intended only to make it easier to locate specific columns and rows.

**Random Starting Place**

Starting Page. The Random Digit pages are pages 161 through 167. You can use the day of the week to determine the starting page or use the first page for the first lot you test in a location, the second page for the second lot, and so on, moving to the following page for each new lot.

Starting Column and Row. You may choose a starting page in the random number table and with eyes closed, drop a pencil anywhere on the page to indicate a starting place in the table.

For example, assume that testing takes place on the 3rd day of the week. Start with Table 3 of Appendix B. Assume you dropped your pencil on the page and it has indicated a starting place at Column 22, Row 45. That number is 1. (see the “Illustration for Finding/Using Random Digits” on the next page.)

If one‑digit random numbers are needed, record them, going down the column to the bottom of the page and then to the top of the next column, and so on. Ignore duplicates and record zero (0) as ten (10). Following on from the last example, these numbers are 3, 2, 9, 8, etc. If two‑digit random numbers are needed, rule off the pages, and further pages if necessary, in columns of two digits each. If there is a single column left on the page, ignore this column, and rule the next page in columns of two. Again, ignore duplicate numbers and record 00 as 100. For example, using the same starting place as in the last example (Table 3, Column 22, Row 45), the recorded two‑digit numbers would be 11, 34, 26, 95, etc. When three‑digit numbers are needed, rule the page in columns of three. Record 000 as 1000. Starting on Table 3, Column 22, Row 45, the recorded numbers would be 119, 346, 269, 959, etc.

**Illustration for Finding/Using Random Digits:** Assume that testing takes place on the 3rd day of the week. Start with **Table 3**. Then assume you drop your pencil on the page, and it has showed a starting place at **Column 22**, **Row 45**. That number is **“1.”**

Continue to follow the instructions on the previous page. (see Appendix B. Random Number Tables, Section “Random Starting Place.”)

**Column 50**

**Column 30**

**Column 22**

**Column 8**

**Column 15**

**Column 5**

**Column 1**

**Row 1** 37100 62492 63642 47638 13925 80113 88067 42575 44078 62703

**Row 2** 53406 13855 38519 29500 62479 01036 87964 44498 07793 21599

**Row 3** 55172 81556 18856 59043 64315 38270 25677 01965 21310 28115

**Row 4** 40353 84807 47767 46890 16053 32415 60259 99788 55924 22077

**Row 5** 18899 09612 77541 57675 70153 41179 97535 82889 27214 03482

**Row 41** 09522 83855 85973 15888 29554 17995 37443 11461 42909 32634

**Row 42** 93714 15414 93712 02742 34395 21929 38928 31205 01838 60000

**Row 43** 15681 53599 58185 73840 88758 10618 98725 23146 13521 47905

**Row 44** 77712 23914 08907 43768 10304 61405 53986 61116 76164 54958

**Row 45** 78453 54844 61509 01245 91199 07482 02534 08189 62978 55516

**Digit Selected**

**Column 22; Row 45**

TABLE 1 – RANDOM DIGITS

11164 36318 75061 37674 26320 75100 10431 20418 19228 91792

21215 91791 76831 58678 87054 31687 93205 43685 19732 08468

10438 44482 66558 37649 08882 90870 12462 41810 01806 02977

36792 26236 33266 66583 60881 97395 20461 36742 02852 50564

73944 04773 12032 51414 82384 38370 00249 80709 72605 67497

49563 12872 14063 93104 78483 72717 68714 18048 25005 04151

64208 48237 41701 73117 33242 42314 83049 21933 92813 04763

51486 72875 38605 29341 80749 80151 33835 52602 79147 08868

99756 26360 64516 17971 48478 09610 04638 17141 09227 10606

71325 55217 13015 72907 00431 45117 33827 92873 02953 85474

65285 97198 12138 53010 94601 15838 16805 61004 43516 17020

17264 57327 38224 29301 31381 38109 34976 65692 98566 29550

95639 99754 31199 92558 68368 04985 51092 37780 40261 14479

61555 76404 86210 11808 12841 45147 97438 60022 12645 62000

78137 98768 04689 87130 79225 08153 84967 64539 79493 74917

62490 99215 84987 28759 19177 14733 24550 28067 68894 38490

24216 63444 21283 07044 92729 37284 13211 37485 10415 36457

16975 95428 33226 55903 31605 43817 22250 03918 46999 98501

59138 39542 71168 57609 91510 77904 74244 50940 31553 62562

29478 59652 50414 31966 87912 87154 12944 49862 96566 48825

96155 95009 27429 72918 08457 78134 48407 26061 58754 05326

29621 66583 62966 12468 20245 14015 04014 35713 03980 03024

12639 75291 71020 17265 41598 64074 64629 63293 53307 48766

14544 37134 54714 02401 63228 26831 19386 15457 17999 18306

83403 88827 09834 11333 68431 31706 26652 04711 34593 22561

67642 05204 30697 44806 96989 68403 85621 45556 35434 09532

64041 99011 14610 40273 09482 62864 01573 82274 81446 32477

17048 94523 97444 59904 16936 39384 97551 09620 63932 03091

93039 89416 52795 10631 09728 68202 20963 02477 55494 39563

82244 34392 96607 17220 51984 10753 76272 50985 97593 34320

96990 55244 70693 25255 40029 23289 48819 07159 60172 81697

09119 74803 97303 88701 51380 73143 98251 78635 27556 20712

57666 41204 47589 78364 38266 94393 70713 53388 79865 92069

46492 61594 26729 58272 81754 14648 77210 12923 53712 87771

08433 19172 08320 20839 13715 10597 17234 39355 74816 03363

10011 75004 86054 41190 10061 19660 03500 68412 57812 57929

92420 65431 16530 05547 10683 88102 30176 84750 10115 69220

35542 55865 07304 47010 43233 57022 52161 82976 47981 46588

86595 26247 18552 29491 33712 32285 64844 69395 41387 87195

72115 34985 58036 99137 47482 06204 24138 24272 16196 04393

07428 58863 96023 88936 51343 70958 96768 74317 27176 29600

35379 27922 28906 55013 26937 48174 04197 36074 65315 12537

10982 22807 10920 26299 23593 64629 57801 10437 43965 15344

90127 33341 77806 12446 15444 49244 47277 11346 15884 28131

63002 12990 23510 68774 48983 20481 59815 67248 17076 78910

40779 86382 48454 65269 91239 45989 45389 54847 77919 41105

43216 12608 18167 84631 94058 82458 15139 76856 86019 47928

96167 64375 74108 93643 09204 98855 59051 56492 11933 64958

70975 62693 35684 72607 23026 37004 32989 24843 01128 74658

85812 61875 23570 75754 29090 40264 80399 47254 40135 69916

TABLE 2 – RANDOM DIGITS

40603 16152 83235 37361 98783 24838 39793 80954 76865 32713

40941 53585 69958 60916 71018 90561 84505 53980 64735 85140

73505 83472 55953 17957 11446 22618 34771 25777 27064 13526

39412 16013 11442 89320 11307 49396 39805 12249 57656 88686

57994 76748 54627 48511 78646 33287 35524 54522 08795 56273

61834 59199 15469 82285 84164 91333 90954 87186 31598 25942

91402 77227 79516 21007 58602 81418 87838 18443 76162 51146

58299 83880 20125 10794 37780 61705 18276 99041 78135 99661

40684 99948 33880 76413 63839 71371 32392 51812 48248 96419

75978 64298 08074 62055 73864 01926 78374 15741 74452 49954

34556 39861 88267 76068 62445 64361 78685 24246 27027 48239

65990 57048 25067 77571 77974 37634 81564 98608 37224 49848

16381 15069 25416 87875 90374 86203 29677 82543 37554 89179

52458 88880 78352 67913 09245 47773 51272 06976 99571 33365

33007 85607 92008 44897 24964 50559 79549 85658 96865 24186

38712 31512 08588 61490 72294 42862 87334 05866 66269 43158

58722 03678 19186 69602 34625 75958 56869 17907 81867 11535

26188 69497 51351 47799 20477 71786 52560 66827 79419 70886

12893 54048 07255 86149 99090 70958 50775 31768 52903 27645

33186 81346 85095 37282 85536 72661 32180 40229 19209 74939

79893 29448 88392 54211 61708 83452 61227 81690 42265 20310

48449 15102 44126 19438 23382 14985 37538 30120 82443 11152

94205 04259 68983 50561 06902 10269 22216 70210 60736 58772

38648 09278 81313 77400 41126 52614 93613 27263 99381 49500

04292 46028 75666 26954 34979 68381 45154 09314 81009 05114

17026 49737 85875 12139 59391 81830 30185 83095 78752 40899

48070 76848 02531 97737 10151 18169 31709 74842 85522 74092

30159 95450 83778 46115 99178 97718 98440 15076 21199 20492

12148 92231 31361 60650 54695 30035 22765 91386 70399 79270

73838 77067 24863 97576 01139 54219 02959 45696 98103 78867

73547 43759 95632 39555 74391 07579 69491 02647 17050 49869

07277 93217 79421 21769 83572 48019 17327 99638 87035 89300

65128 48334 07493 28098 52087 55519 83718 60904 48721 17522

38716 61380 60212 05099 21210 22052 01780 36813 19528 07727

31921 76458 73720 08657 74922 61335 41690 41967 50691 30508

57238 27464 61487 52329 26150 79991 64398 91273 26824 94827

24219 41090 08531 61578 08236 41140 76335 91189 66312 44000

31309 49387 02330 02476 96074 33256 48554 95401 02642 29119

20750 97024 72619 66628 66509 31206 55293 24249 02266 39010

28537 84395 26654 37851 80590 53446 34385 86893 87713 26842

97929 41220 86431 94485 28778 44997 38802 56594 61363 04206

40568 33222 40486 91122 43294 94541 40988 02929 83190 74247

41483 92935 17061 78252 40498 43164 68646 33023 64333 64083

93040 66476 24990 41099 65135 37641 97613 87282 63693 55299

76869 39300 84978 07504 36835 72748 47644 48542 25076 68626

02982 57991 50765 91930 21375 35604 29963 13738 03155 59914

94479 76500 39170 06629 10031 48724 49822 44021 44335 26474

52291 75822 95966 90947 65031 75913 52654 63377 70664 60082

03684 03600 52831 55381 97013 19993 41295 29118 18710 64851

58939 28366 86765 67465 45421 74228 01095 50987 83833 37216

TABLE 3 – RANDOM DIGITS

37100 62492 63642 47638 13925 80113 88067 42575 44078 62703

53406 13855 38519 29500 62479 01036 87964 44498 07793 21599

55172 81556 18856 59043 64315 38270 25677 01965 21310 28115

40353 84807 47767 46890 16053 32415 60259 99788 55924 22077

18899 09612 77541 57675 70153 41179 97535 82889 27214 03482

68141 25340 92551 11326 60939 79355 41544 88926 09111 86431

51559 91159 81310 63251 91799 41215 87412 35317 74271 11603

92214 33386 73459 79359 65867 39269 57527 69551 17495 91456

15089 50557 33166 87094 52425 21211 41876 42525 36625 63964

96461 00604 11120 22254 16763 19206 67790 88362 01880 37911

28177 44111 15705 73835 69399 33602 13660 84342 97667 80847

66953 44737 81127 07493 07861 12666 85077 95972 96556 80108

19712 27263 84575 49820 19837 69985 34931 67935 71903 82560

68756 64757 19987 92222 11691 42502 00952 47981 97579 93408

75022 65332 98606 29451 57349 39219 08585 31502 96936 96356

11323 70069 90269 89266 46413 61615 66447 49751 15836 97343

55208 63470 18158 25283 19335 53893 87746 72531 16826 52605

11474 08786 05594 67045 13231 51186 71500 50498 59487 48677

81422 86842 60997 79669 43804 78690 58358 87639 24427 66799

21771 75963 23151 90274 08275 50677 99384 94022 84888 80139

42278 12160 32576 14278 34231 20724 27908 02657 19023 07190

17697 60114 63247 32096 32503 04923 17570 73243 76181 99343

05686 30243 34124 02936 71749 03031 72259 26351 77511 00850

52992 46650 89910 57395 39502 49738 87854 71066 84596 33115

94518 93984 81478 67750 89354 01080 25988 84359 31088 13655

00184 72186 78906 75480 71140 15199 69002 08374 22126 23555

87462 63165 79816 61630 50140 95319 79205 79202 67414 60805

88692 58716 12273 48176 86038 78474 76730 82931 51595 20747

20094 42962 41382 16768 13261 13510 04822 96354 72001 68642

60935 81504 50520 82153 27892 18029 79663 44146 72876 67843

51392 85936 43898 50596 81121 98122 69196 54271 12059 62539

54239 41918 79526 46274 24853 67165 12010 04923 20273 89405

57892 73394 07160 90262 48731 46648 70977 58262 78359 50436

02330 74736 53274 44468 53616 35794 54838 39114 68302 26855

76115 29247 55342 51299 79908 36613 68361 18864 13419 34950

63312 81886 29085 20101 38037 34742 78364 39356 40006 49800

27632 21570 34274 56426 00330 07117 86673 46455 66866 76374

06335 62111 44014 52567 79480 45886 92585 87828 17376 35254

64142 87676 21358 88773 10604 62834 63971 03989 21421 76086

28436 25468 75235 75370 63543 76266 27745 31714 04219 00699

09522 83855 85973 15888 29554 17995 37443 11461 42909 32634

93714 15414 93712 02742 34395 21929 38928 31205 01838 60000

15681 53599 58185 73840 88758 10618 98725 23146 13521 47905

77712 23914 08907 43768 10304 61405 53986 61116 76164 54958

78453 54844 61509 01245 91199 07482 02534 08189 62978 55516

24860 68284 19367 29073 93464 06714 45268 60678 58506 23700

37284 06844 78887 57276 42695 03682 83240 09744 63025 60997

35488 52473 37634 32569 39590 27379 23520 29714 03743 08444

51595 59909 35223 44991 29830 56614 59661 83397 38421 17503

90660 35171 30021 91120 78793 16827 89320 08260 09181 53616

TABLE 4 – RANDOM DIGITS

54723 56527 53076 38235 42780 22716 36400 48028 78196 92985

84828 81248 25548 34075 43459 44628 21866 90350 82264 20478

65799 01914 81363 05173 23674 41774 25154 73003 87031 94368

87917 38549 48213 71708 92035 92527 55484 32274 87918 22455

26907 88173 71189 28377 13785 87469 35647 19695 33401 51998

68052 65422 88460 06352 42379 55499 60469 76931 83430 24560

42587 68149 88147 99700 56124 53239 38726 63652 36644 50876

97176 55416 67642 05051 89931 19482 80720 48977 70004 03664

53295 87133 38264 94708 00703 35991 76404 82249 22942 49659

23011 94108 29196 65187 69974 01970 31667 54307 40032 30031

75768 49549 24543 63285 32803 18301 80851 89301 02398 99891

86668 70341 66460 75648 78678 27770 30245 44775 56120 44235

56727 72036 50347 33521 05068 47248 67832 30960 95465 32217

27936 78010 09617 04408 18954 61862 64547 52453 83213 47833

31994 69072 37354 93025 38934 90219 91148 62757 51703 84040

02985 95303 15182 50166 11755 56256 89546 31170 87221 63267

89965 10206 95830 95406 33845 87588 70237 84360 19629 72568

45587 29611 98579 42481 05359 36578 56047 68114 58583 16313

01071 08530 74305 77509 16270 20889 99753 88035 55643 18291

90209 68521 14293 39194 68803 32052 39413 26883 83119 69623

04982 68470 27875 15480 13206 44784 83601 03172 07817 01520

19740 24637 97377 32112 74283 69384 49768 64141 02024 85380

50197 79869 86497 68709 42073 28498 82750 43571 77075 07123

46954 67536 28968 81936 95999 04319 09932 66223 45491 69503

82549 62676 31123 49899 70512 95288 15517 85352 21987 08669

61798 81600 80018 84742 06103 60786 01408 75967 29948 21454

57666 29055 46518 01487 30136 14349 56159 47408 78311 25896

29805 64994 66872 62230 41385 58066 96600 99301 85976 84194

06711 34939 19599 76247 87879 97114 74314 39599 43544 36255

13934 46885 58315 88366 06138 37923 11192 90757 10831 01580

28549 98327 99943 25377 17628 65468 07875 16728 22602 33892

40871 61803 25767 55484 90997 86941 64027 01020 39518 34693

47704 38355 71708 80117 11361 88875 22315 38048 42891 87885

62611 19698 09304 29265 07636 08508 23773 56545 08015 28891

03047 83981 11916 09267 67316 87952 27045 62536 32180 60936

26460 50501 31731 18938 11025 18515 31747 96828 58258 97107

01764 25959 69293 89875 72710 49659 66632 25314 95260 22146

11762 54806 02651 52912 32770 64507 59090 01275 47624 16124

31736 31695 11523 64213 91190 10145 34231 36405 65860 48771

97155 48706 52239 21831 49043 18650 72246 43729 63368 53822

31181 49672 17237 04024 65324 32460 01566 67342 94986 36106

32115 82683 67182 89030 41370 50266 19505 57724 93358 49445

07068 75947 71743 69285 30395 81818 36125 52055 20289 16911

26622 74184 75166 96748 34729 61289 36908 73686 84641 45130

02805 52676 22519 47848 68210 23954 63085 87729 14176 45410

32301 58701 04193 30142 99779 21697 05059 26684 63516 75925

26339 56909 39331 42101 01031 01947 02257 47236 19913 90371

95274 09508 81012 42413 11278 19354 68661 04192 36878 84366

24275 39632 09777 98800 48027 96908 08177 15364 02317 89548

36116 42128 65401 94199 51058 10759 47244 99830 64255 40516

TABLE 5 – RANDOM DIGITS

47505 02008 20300 87188 42505 40294 04404 59286 95914 07191

13350 08414 64049 94377 91059 74531 56228 12307 87871 97064

33006 92690 69248 97443 38841 05051 33756 24736 43508 53566

55216 63886 06804 11861 30968 74515 40112 40432 18682 02845

21991 26228 14801 19192 45110 39937 81966 23258 99348 61219

71025 28212 10474 27522 16356 78456 46814 28975 01014 91458

65522 15242 84554 74560 26206 49520 65702 54193 25583 54745

27975 54923 90650 06170 99006 75651 77622 20491 53329 12452

07300 09704 36099 61577 34632 55176 87366 19968 33986 46445

54357 13689 19569 03814 47873 34086 28474 05131 46619 41499

00977 04481 42044 08649 83107 02423 46919 59586 58337 32280

13920 78761 12311 92808 71581 85251 11417 85252 61312 10266

08395 37043 37880 34172 80411 05181 58091 41269 22626 64799

46166 67206 01619 43769 91727 06149 17924 42628 57647 76936

87767 77607 03742 01613 83528 66251 75822 83058 97584 45401

29880 95288 21644 46587 11576 30568 56687 83239 76388 17857

36248 36666 14894 59273 04518 11307 67655 08566 51759 41795

12386 29656 30474 25964 10006 86382 46680 93060 52337 56034

52068 73801 52188 19491 76221 45685 95189 78577 36250 36082

41727 52171 56719 06054 34898 93990 89263 79180 39917 16122

49319 74580 57470 14600 22224 49028 93024 21414 90150 15686

88786 76963 12127 25014 91593 98208 27991 12539 14357 69512

84866 95202 43983 72655 89684 79005 85932 41627 87381 38832

11849 26482 20461 99450 21636 13337 55407 01897 75422 05205

54966 17594 57393 73267 87106 26849 68667 45791 87226 74412

10959 33349 80719 96751 25752 17133 32786 34368 77600 41809

22784 07783 35903 00091 73954 48706 83423 96286 90373 23372

86037 61791 33815 63968 70437 33124 50025 44367 98637 40870

80037 65089 85919 74391 36170 82988 52311 59180 37846 98028

72751 84359 15769 13615 70866 37007 74565 92781 37770 76451

18532 03874 66220 79050 66814 76341 42452 65365 07167 90134

22936 22058 49171 11027 07066 14606 11759 19942 21909 15031

66397 76510 81150 00704 94990 68204 07242 82922 65745 51503

89730 23272 65420 35091 16227 87024 56662 59110 11158 67508

81821 75323 96068 91724 94679 88062 13729 94152 59343 07352

94377 82554 53586 11432 08788 74053 98312 61732 91248 23673

68485 49991 53165 19865 30288 00467 98105 91483 89389 61991

07330 07184 86788 64577 47692 45031 36325 47029 27914 24905

10993 14930 35072 36429 26176 66205 07758 07982 33721 81319

20801 15178 64453 83357 21589 23153 60375 63305 37995 66275

79241 35347 66851 79247 57462 23893 16542 55775 06813 63512

43593 39555 97345 58494 52892 55080 19056 96192 61508 23165

29522 62713 33701 17186 15721 95018 76571 58615 35836 66260

88836 47290 67274 78362 84457 39181 17295 39626 82373 10883

65905 66253 91482 30689 81313 01343 37188 37756 04182 19376

44798 69371 07865 91756 42318 63601 53872 93610 44142 89830

35510 99139 32031 27925 03560 33806 85092 70436 94777 57963

50125 93223 64209 49714 73379 89975 38567 44316 60262 10777

25173 90038 63871 40418 23818 63250 05118 52700 92327 55449

68459 90094 44995 93718 83654 79311 18107 12557 09179 28416

TABLE 6 – RANDOM DIGITS

96195 07059 13266 31389 87612 88004 31843 83469 22793 14312

22408 94958 19095 58035 43831 32354 83946 57964 70404 32017

53896 23508 16227 56929 74329 12264 26047 66844 47383 42202

22565 02475 00258 79018 70090 37914 27755 00872 71553 56684

49438 20772 60846 69732 07612 70474 46483 21053 95475 53448

65620 34684 00210 04863 01373 19978 61682 69315 46766 83768

20246 26941 41298 04763 19769 25865 95937 03545 93561 73871

09433 09167 35166 32731 73299 41137 37328 28301 61629 05040

95552 73456 16578 88140 80059 50296 07656 01396 83099 09718

76053 05150 69125 69442 16509 03495 26427 58780 27576 31342

34822 35843 78468 82380 52313 71070 71273 10768 86101 51474

07753 04073 58520 80022 28185 16432 86909 82347 10548 83929

04204 94434 62798 81902 29977 57258 87826 35003 46449 76636

96770 19440 29700 42093 64369 69176 29732 37389 34054 28680

65989 62843 10917 34458 81936 84775 39415 10622 36102 16753

06644 94784 66995 61812 54215 01336 75887 57685 66114 76984

88950 46077 34651 12038 87914 20785 39705 73898 12318 78334

21482 95422 02002 33671 46764 50527 46276 77570 68457 62199

55137 61039 02006 69913 11291 87215 89991 26003 55271 08153

98441 81529 59607 65225 49051 28328 85535 37003 87211 10204

57168 30458 23892 07825 53447 53511 09315 42552 43135 57892

71886 65334 38013 09379 83976 42441 14086 33197 82671 05037

40418 59504 52383 07232 14179 59693 37668 26689 93865 78925

28833 76661 47277 92935 63193 94862 60560 72484 29755 40894

37883 62124 62199 49542 55083 20575 44636 92282 52105 77664

44882 33592 66234 13821 86342 00135 87938 57995 34157 99858

19082 13873 07184 21566 95320 28968 31911 06288 77271 76171

45316 29283 89318 55806 89338 79231 91545 55477 19552 03471

22788 55433 31188 74882 44858 69655 08096 70982 61300 23792

08293 86193 05026 21255 63082 92946 28748 25423 45282 57821

29223 70541 67115 84584 10100 33854 26466 77796 70698 99393

22681 80110 31595 09246 39147 11158 43298 36220 88841 11271

74580 90354 43744 22178 38084 60027 24201 71686 59767 33274

69093 71364 08107 96952 50005 30297 97417 89575 04676 35616

40456 91234 58090 65342 95002 28447 21'700 43137 13746 85959

72927 67349 83962 58912 59734 76323 02913 46306 53956 38936

61869 33093 81129 06481 89281 83629 81960 63704 56329 10357

40048 16520 07638 10797 22270 57350 72214 36410 95526 87614

68773 97669 28656 89938 12917 25630 08068 19445 76250 24727

09774 30751 49740 11385 91468 28900 76804 52460 52320 70493

46139 36689 82587 13586 35061 76128 38568 62300 43439 53434

26566 95323 32993 89988 12152 01862 93113 33875 31730 62941

06765 57141 48617 18282 13086 76064 83334 70192 15972 80429

35384 90380 12317 89702 33091 68835 62960 38010 52710 87604

49333 78482 36199 11355 86044 88760 03724 22927 91716 92332

45595 14044 56806 99126 85584 87750 78149 22723 48245 78126

79819 15054 76174 12206 06886 06814 43285 20008 75345 19779

11971 62234 74857 46401 20817 57591 41189 49604 29604 30660

11452 89318 53084 21993 62471 74101 61217 76536 58393 63718

38746 81271 96260 98137 60275 22647 33103 50090 29395 10016

TABLE 7 – RANDOM DIGITS

93369 13044 69686 78162 29132 51544 17925 56738 32683 83153

19360 55049 94951 76341 38159 31008 41476 05278 03909 02299

47798 89890 06893 65483 97658 74884 38611 27264 26956 83504

69223 32007 03513 61149 66270 73087 16795 76845 44645 44552

34511 50721 84850 34159 38985 75384 22965 55366 81632 78872

54031 59329 58963 52220 76806 98715 67452 78741 58128 00077

66722 85515 04723 92411 03834 12109 85185 37350 93614 15351

71059 07496 38404 18126 37894 44991 45777 02070 38159 23930

45478 86066 31135 33243 01190 47277 55146 56130 70117 83203

97246 91121 89437 20393 76598 99458 76665 83793 37448 32664

22982 25936 96417 34845 28942 65569 38253 77182 12996 19505

48243 62993 47132 85248 79160 90981 71696 79609 33809 60839

93514 14915 67960 82203 22598 94802 75332 95585 69542 79924

69707 98303 93069 16216 01542 51771 16833 20922 94415 27617

87467 91794 70814 12743 17543 04057 71231 11309 32780 83270

81006 81498 59375 30502 44868 81279 23585 49678 70014 10523

15458 83481 50187 43375 56644 72076 59403 65469 74760 69509

33469 12510 23095 48016 22064 39774 07373 10555 33345 21787

67198 07176 65996 18317 83083 11921 06254 68437 59481 54778

58037 92261 85504 55690 63488 26451 43223 38009 50567 09191

84983 68312 25519 56158 22390 12823 92390 28947 36708 25393

35554 02935 72889 68772 79774 14336 50716 63003 86391 94074

04368 17632 50962 71908 13105 76285 31819 16884 11665 16594

81311 60479 69985 30952 93067 70056 55229 83226 22555 66447

03823 89887 55828 74452 21692 55847 15960 47521 27784 25728

80422 65437 38797 56261 88300 35980 56656 45662 29219 49257

61307 49468 43344 43700 14074 19739 03275 99444 62545 23720

83873 82557 10002 80093 74645 33109 15281 38759 09342 69408

38110 16855 28922 93758 22885 36706 92542 60270 99599 17983

43892 91189 87226 56935 99836 85489 89693 49475 31941 78065

93683 09664 53927 49885 94979 88848 42642 93218 80305 49428

32748 02121 11972 96914 83264 89016 45140 20362 63242 86255

49211 92963 38625 65312 52156 36400 67050 64058 45489 24165

63365 64224 69475 57512 85097 05054 88673 96593 00902 53320

63576 26373 44610 43748 90399 06770 71609 90916 69002 57180

41078 47036 65524 68466 77613 20076 71969 47706 22506 81053

70846 89558 64173 15381 67322 70097 82363 90767 17879 32697

68800 64492 20162 32707 69510 82465 26821 79917 34615 35820

44977 89525 51269 63747 30997 97213 53016 65909 05723 50168

79354 63847 24395 53679 07667 67993 24634 78867 78516 00448

14954 22299 40156 52685 19093 06090 23800 06739 76836 19050

01711 98439 09446 33937 98956 85676 89493 05132 45886 49379

62328 55328 45738 93940 15772 81975 91017 21387 57949 13992

73004 62109 81907 71077 50322 66093 79921 61412 18347 21115

34218 89445 03609 52336 19005 15179 94958 99448 11612 76981

99159 01968 45886 86875 05196 64297 59339 39878 61548 56442

92858 29949 15817 93372 34732 61584 72007 58597 43802 51066

27396 97477 65554 71601 01540 26509 19487 39684 18676 41219

37103 45309 30129 43380 66638 10841 77292 40288 25826 61431

57347 97012 48428 20606 54138 75716 23741 50462 13221 47216

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# Appendix C. Model Inspection Report Forms

[Random Package Report 179](#_Toc22189427)

[Random Package Report – Example 180](#_Toc22189428)

[Standard Package Report 181](#_Toc22189429)

[Standard Package Report – Example 182](#_Toc22189430)

[Standard Package Report – Animal Bedding 183](#_Toc22189431)

[Measurement Grid and Package Error Worksheet for Cylindrical and Square or Rectangular Test Measures 184](#_Toc22189432)

[Ice Glazed Package Worksheet 185](#_Toc22189433)

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[Determining the Free Liquid and Net Volume of Oysters Worksheet 189](#_Toc22189437)

[Determining the Free Liquid and Net Volume of Oysters Worksheet – Example 190](#_Toc22189438)

[Chitterlings Worksheet – Category A 191](#_Toc22189439)

[Chitterlings Worksheet – Category A – Example 192](#_Toc22189440)

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[Borax Audit Worksheet 196](#_Toc22189444)

[Softwood Lumber Worksheet 197](#_Toc22189445)

[Softwood Lumber Worksheet 199](#_Toc22189446)

[Structural Plywood Sheets and Wood-Based Structural Panels Worksheet 201](#_Toc22189447)

[Structural Plywood Sheets and Wood-Based Structural Panels Worksheet 203](#_Toc22189448)

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Date:** | Random Package Report | | | | | | | | | **Sampling Plan:** □ **A** □ **B** | | | | **Report Number:** | | |
| **Location (name, address):** | | | | **Product/Brand Identity:** | | | | | | **Manufacturer:** | | | | **Container Description:** | | |
|  | | | | **Lot Codes:** | | | | | |  | | | |  | | |
| **1. Labeled Quantity:**  (Enter weight for each package in Column 1 below.) | **2. Unit of Measure:** | | | | **3. MAV:** (Look up the MAV for each package with a minus error (−), convert it to dimensionless units and enter this value in the Box 4 column below.) | | | | | | | **5. Inspection Lot Size:** | | **6. Sample Size (n):** | | |
| **7. Initial Tare Sample Size:** | **8. Number of MAVs Allowed:** | | | | **9. Range of Package Errors (Rc):** | | | **10. Range of Tare Weights (Rt):** | | | | **11. Rc/Rt :**  (Box 9 ÷ Box 10 = ) | | **12. Total No. of Tare Samples:** | | |
| **13. Avg. Tare Wt:**  □ **Used Dry Tare** □ **Wet Tare** □ **Unused Dry Tare** | | | | | | | | **13a.** □ **Tare Correction**  □ **Moisture Allowance**  □ **Not Applicable** | | | | | | **14. Nominal Gross Wt:**  (Labeled Wt + Box 13 − Box 13a =) | | |
|  | **Pkg 1** | **Pkg 2** | | | **Pkg 3** | | **Pkg 4** | **Pkg 5** | | **Pkg 6** | | **Pkg 7** | **Pkg 8** | **Pkg 9** | **Pkg 10** | |
| **a. Gross Wt** |  |  | | |  | |  |  | |  | |  |  |  |  | |
| **b. Tare Wt** |  |  | | |  | |  |  | |  | |  |  |  |  | |
| **c. Net Wt** |  |  | | |  | |  |  | |  | |  |  |  |  | |
| **d. Package Error** |  |  | | |  | |  |  | |  | |  |  |  |  | |
| **Product Description, Lot Code, Unit Price** | | | | | | | **Money Errors** | | | **Column 1**  **Labeled Net**  **Weight** | | | **Package Errors** | | **4.** **MAV**  **Dimen­sion­­less**  **Units** | |
|  | | | | | | | **−** | **+** | |  | | | **−** | **+** |  | |
| 1. | | | | | | |  |  | |  | | |  |  |  | |
| 2. | | | | | | |  |  | |  | | |  |  |  | |
| 3. | | | | | | |  |  | |  | | |  |  |  | |
| 4. | | | | | | |  |  | |  | | |  |  |  | |
| 5. | | | | | | |  |  | |  | | |  |  |  | |
| 6. | | | | | | |  |  | |  | | |  |  |  | |
| 7. | | | | | | |  |  | |  | | |  |  |  | |
| 8. | | | | | | |  |  | |  | | |  |  |  | |
| 9. | | | | | | |  |  | |  | | |  |  |  | |
| 10. | | | | | | |  |  | |  | | |  |  |  | |
| 11. | | | | | | |  |  | |  | | |  |  |  | |
| 12. | | | | | | |  |  | |  | | |  |  |  | |
| 13. | | | | | | |  |  | |  | | |  |  |  | |
| 14. | | | | | | |  |  | |  | | |  |  |  | |
| 15. | | | | | | |  |  | |  | | |  |  |  | |
| 16. | | | | | | |  |  | |  | | |  |  |  | |
|  | | | | | | | | | | | | **Totals** |  |  |  | |
| **15. Total Error:** | **16. Number of unreasonable minus (−) errors:** (Compare each package error with the MAV in Column 4.) | | | | | | **17. Is Box 16 greater than Box 8?**  □ **Yes,** lot fails  □ **No,** go to Box 18 | | | | **18. Avg. error in dimensionless units:**  (Box 15 ÷ Box 6 =) | | | **19. Avg. error in labeled units:** (Box 18 × Box 2 =) | | |
| **20. Does Box 18 = zero (0) or Plus (+)?**  □ **Yes,** lot passes, go to Box 25  □ **No**, go to Box 21 | | **21. Compute Sample Standard Deviation:** | | | | | **22. Sample Correction Factor:** | | | | **23. Compute Sample Error Limit: (Box 21 × Box 22 =)** | | | | | |
| **24. Disregarding the signs, is Box 18 larger than Box 23?**  □ **Yes,** lot fails, go to Box 25 □ **No,** lot passes, go to Box 25 | | | | | | | | | **25. Disposition of Inspection Lot:**  □ **Approved** □ **Rejected** | | | | | | | |
| **Comments:** | | | | | | | | | **Official’s Signature:** | | | | | | | |
|  | | | | | | | | | **Acknowledgement of Report:** | | | | | | | |
| **Date:**  *January 20, 2010* | Random Package Report – Example | | | | | | | | | **Sampling Plan:** 🗹 **A** □ **B** | | | | **Report Number:**  17 | | | |
| **Location (name, address):**  *L&O Market*  *MacCorkle Ave.*  *Charleston, WV 25171* | | | **Product/Brand Identity:**  *Ground Chuck* | | | | | | | **Manufacturer:**  *Meat Dept. – L&O Market* | | | | **Container Description:**  *2S Tray w/soaker and plastic wrap* | | | |
|  | | | **Lot Codes:**  *1, 19, 99* | | | | | | |  | | | |  | | | |
| **1. Labeled Quantity:**  (Enter weight for each package in Column 1 below.) | **2. Unit of Measure:**  *0.001 lb* | | | | | **3. MAV:** (Look up the MAV for each package with a minus error (−), convert it to dimensionless units and enter this value in the Box 4 column below.) | | | | | | **5. Inspection Lot Size:**  *23* | | **6. Sample Size (n):**  *12* | | | |
| **7. Initial Tare Sample Size**:  *2* | **8. Number of MAVs Allowed:**  *0* | | | | | **9. Range of Package Errors (Rc):**  *10* | | **10. Range of Tare Weights (Rt):**  *1* | | | | **11. Rc/Rt:**  (Box 9 ÷ Box 10 = )  *10* | | **12. Total No. of Tare Samples**:  *2* | | | |
| **13. Avg. Tare Wt:**  *0.020 lb*  🗹 **Used Dry Tare** □ **Wet Tare** □ **Unused Dry Tare** | | | | | | | | **13a.** □ **Tare Correction**  □ **Moisture Allowance**  🗹  **Not Applicable** | | | | | | **14. Nominal Gross Wt:**  (Labeled Wt + Box 13 − Box 13a =)  *Label Wt + 0.020 lb* | | | |
|  | **Pkg 1** | | **Pkg 2** | | | **Pkg 3** | **Pkg 4** | **Pkg 5** | | **Pkg 6** | | **Pkg 7** | **Pkg 8** | **Pkg 9** | | **Pkg 10** | |
| **a. Gross Wt** | *1.852 lb* | | *1.223 lb* | | |  |  |  | |  | |  |  |  | |  | |
| **b. Tare Wt** | *0.020 lb* | | *0.021 lb* | | |  |  |  | |  | |  |  |  | |  | |
| **c. Net Wt** | *1.832 lb* | | *1.202 lb* | | |  |  |  | |  | |  |  |  | |  | |
| **d. Package Error** | *−18* | | *−8* | | |  |  |  | |  | |  |  |  | |  | |
| **Product Description, Lot Code, Unit Price** | | | | | | | **Money Errors** | | | **Column 1**  **Labeled Net**  **Weight** | | | **Package Errors** | | | **4.** **MAV**  **Dimensionless**  **Units** | |
|  | | | | | | | **−** | **+** | |  | | | **−** | **+** | |  | |
| 1. *Ground Chuck – 1, 19, 99 – $1.79 per lb* | | | | | | |  |  | | *1.85 lb* | | | *18* |  | |  | |
| 2. | | | | | | |  |  | | *1.21 lb* | | | *7* |  | |  | |
| 3. | | | | | | |  |  | | *1.56 lb* | | | *8* |  | |  | |
| 4. | | | | | | |  |  | | *1.98 lb* | | | *14* |  | |  | |
| 5. | | | | | | | *$ 0.04* |  | | *1.07 lb* | | | *23* |  | | *44* | |
| 6. | | | | | | |  |  | | *1.55 lb* | | | *16* |  | |  | |
| 7. | | | | | | |  |  | | *1.02 lb* | | | *2* |  | |  | |
| 8. | | | | | | | *$ 0.04* |  | | *1.44 lb* | | | *25* |  | | *56* | |
| 9. | | | | | | |  |  | | *1.33 lb* | | | *16* |  | |  | |
| 10. | | | | | | |  |  | | *2.03 lb* | | | *20* |  | | *70* | |
| 11. | | | | | | |  |  | | *1.73 lb* | | | *14* |  | |  | |
| 12. | | | | | | |  |  | | *1.16 lb* | | | *11* |  | |  | |
| 13. | | | | | | |  |  | |  | | |  |  | |  | |
| 14. | | | | | | |  |  | |  | | |  |  | |  | |
| 15. | | | | | | |  |  | |  | | |  |  | |  | |
| 16. | | | | | | |  |  | |  | | |  |  | |  | |
|  | | | | | | | | | | | | **Totals** | *−174* |  | |  | |
| **15. Total Error:**  *− 174* | **16. Number of unreasonable minus (−) errors**: (Compare each package error with the MAV in Column 4.)  *0* | | | | | | **17. Is Box 16 greater than Box 8?**  □  **Yes,** lot fails  🗹  **No,** go to Box 18 | | | | **18. Avg. error in dimensionless units:**  (Box 15 ÷ Box 6 =)  *− 14.5* | | | **19. Avg. error in labeled units:** (Box 18 × Box 2 =)  *− 0.014 lb* | | | |
| **20. Does Box 18 = Zero (0) or Plus (+)?**  □ **Yes,** lot passes, go to Box 25  🗹 **No,** go to Box 21 | | | **21. Compute Sample Standard Deviation:**  *6.721* | | | | **22. Sample Correction Factor:**  *0.635* | | | | **23. Compute Sample Error Limit:** (Box 21 × Box 22 =)  *4.267* | | | | | | |
| **24. Disregarding the signs, is Box 18 larger than Box 23?**  🗹 **Yes**, lot fails, go to Box 25 □ **No**, lot passes, go to Box 25 | | | | | | | | **25. Disposition of Inspection Lot:**  □ **Approved** 🗹 **Rejected** | | | | | | | | | |
| **Comments** | | | | | | | | **Official’s Signature:** | | | | | | | | | |
|  | | | | | | | | **Acknowledgement of Report:** | | | | | | | | | |

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| **Date:** | | Standard Package Report | | | | | | | | | | | | | | **Sampling Plan:** □ **A** □ **B** | | | | | | | **Report Number:** | | |
| **Location (name, address):** | | | | | | | | **Product/Brand Identity:** | | | | | | | | **Manufacturer:** | | | | | | | **Container Description**: | | |
|  | | | | | | | | **Lot Codes:** | | | | | | | |  | | | | | | |  | | |
| **1. Labeled Quantity:** | | **2. Unit of Measure:** | | | | | | **3. MAV:** | | | **4. MAV (dimensionless units):**  (Box 3 ÷ Box 2 =) | | | | | | | **5. Inspection Lot Size:** | | | | | **6. Sample Size (n):** | | |
| **7. Initial Tare Sample Size:** | | **8.  Number of MAVs**  **Allowed:** | | | | | | **9. Range of Package Errors (Rc):** | | | **10. Range of Tare Weights (Rt):** | | | | | | | **11. Rc/Rt:**  (Box 9 ÷ 10 =) | | | | | **12. Total Number of Tare Samples:** | | |
| **13. Average Tare Wt:**  □ **Used Dry Tare** □ **Wet Tare** □ **Unused Dry Tare** | | | | | | | | **13a.** □ **Tare Correction**  □ **Moisture Allowance**  □ **Vacuum Pack**  □ **Not Applicable** | | | | | | | | | | **14. Nominal Gross Wt:**  (Box 1 + Box 13 − Box 13a =) | | | | | | | |
|  | | | **Pkg 1** | **Pkg 2** | | | **Pkg 3** | | | **Pkg 4** | | **Pkg 5** | | | **Pkg 6** | | | **Pkg 7** | **Pkg 8** | | **Pkg 9** | | | | **Pkg 10** |
| **a. Gross Wt** | | |  |  | | |  | | |  | |  | | |  | | |  |  | |  | | | |  |
| **b. Tare Wt** | | |  |  | | |  | | |  | |  | | |  | | |  |  | |  | | | |  |
| **c. Net Wt** | | |  |  | | |  | | |  | |  | | |  | | |  |  | |  | | | |  |
| **d.  Package Error** | | |  |  | | |  | | |  | |  | | |  | | |  |  | |  | | | |  |
| **−** | **+** | | | | **−** | | | | **+** | | | | **−** | | | | **+** | | | **−** | | | | **+** | |
| 1. |  | | | | 13. | | | |  | | | | 25. | | | |  | | | 37. | | | |  | |
| 2. |  | | | | 14. | | | |  | | | | 26. | | | |  | | | 38. | | | |  | |
| 3. |  | | | | 15. | | | |  | | | | 27. | | | |  | | | 39. | | | |  | |
| 4. |  | | | | 16. | | | |  | | | | 28. | | | |  | | | 40. | | | |  | |
| 5. |  | | | | 17. | | | |  | | | | 29. | | | |  | | | 41. | | | |  | |
| 6. |  | | | | 18. | | | |  | | | | 30. | | | |  | | | 42. | | | |  | |
| 7. |  | | | | 19. | | | |  | | | | 31. | | | |  | | | 43. | | | |  | |
| 8. |  | | | | 20. | | | |  | | | | 32. | | | |  | | | 44. | | | |  | |
| 9. |  | | | | 21. | | | |  | | | | 33. | | | |  | | | 45. | | | |  | |
| 10. |  | | | | 22. | | | |  | | | | 34. | | | |  | | | 46. | | | |  | |
| 11. |  | | | | 23. | | | |  | | | | 35. | | | |  | | | 47. | | | |  | |
| 12. |  | | | | 24. | | | |  | | | | 36. | | | |  | | | 48. | | | |  | |
| **Total:** | **Total:** | | | | **Total:** | | | | **Total:** | | | | **Total:** | | | | **Total:** | | | **Total:** | | | | **Total:** | |
| **15. Total Error:** | | **16. Number of unreasonable minus (−) errors (compare each package error with Box 4):** | | | | | | | | | **17. Is Box 16 greater than Box 8?**  □ Yes, lot fails  □ No, go to Box 18 | | | | | | | **18. Average error in dimensionless units:**  (Box 15 ÷ Box 6 =) | | | | **19. Average error in labeled units:**  (Box 18 × Box 2 =) | | | |
| **20. Does Box 18 = Zero (0) or Plus (+)?**  □ **Yes,** lot passes, go to Box 25  □ **No,** go to Box 21 | | | | | | **21. Compute Sample Standard Deviation:** | | | | | **22. Sample Correction Factor:** | | | | | | | **23. Compute Sample Error Limit:**  (Box 21 × Box 22 =) | | | | | | | |
| **24. Disregarding the signs, is Box 18 larger than Box 23?**  □ **Yes,** lot fails, go to Box 25 □ **No,** lot passes, go to Box 25 | | | | | | | | | | | | | | **25. Disposition of Inspection Lot:**  □ **Approved** □ **Rejected** | | | | | | | | | | | |
| **Comments:** | | | | | | | | | | | | | | **Official’s Signature**: | | | | | | | | | | | |
|  | | | | | | | | | | | | | | **Acknowledgement of Report:** | | | | | | | | | | | |

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| **Date:**  *January 20, 2010* | | | Standard Package Report – Example | | | | | | | | | | | | | **Sampling Plan:** 🗹 **A** □ **B** | | | | | | | | **Report Number:**  *16* | | |
| **Location (name, address):**  *Volunteer Market*  *18765 Alcoa Highway*  *Knoxville, TN 37920* | | | | | | **Product/Brand Identity:**  *Community Group Cookies (Thin Mints)* | | | | | | | | | | **Manufacturer:**  *ABC Cookies Inc.*  *1069 Capitol Avenue*  *Nashville, TN 37204* | | | | | | | | **Container Description:**  *Cardboard Box/*  *Plastic Liner* | | |
|  | | | | | | **Lot Codes:**  *April 2009 A & B* | | | | | | | | | |  | | | | | | | |  | | |
| **1. Labeled Quantity:**  *453 g (1 lb)* | | | **2. Unit of Measure:**  *0.001 lb* | | | | | **3. MAV:**  *0.044 lb* | | | **4. MAV (dimensionless units):**  (Box 3 ÷ Box 2 =) *44* | | | | | | | | **5. Inspection Lot Size:**  *172* | | | | | **6. Sample Size (n):**  *12* | | |
| **7. Initial Tare Sample Size:**    *2* | | | **8. Number of MAVs Allowed:**  *0* | | | | | **9. Range of Package Errors (Rc):**  *24* | | | **10. Range of Tare Weights (Rt):**  *2* | | | | | | | | **11. Rc/Rt:**  (Box 9 ÷ 10 =)  *12* | | | | | **12. Total Number of Tare Samples:**  *2* | | |
| **13. Average Tare Wt:**  *0.014 lb*  🗹 **Used Dry Tare** □ **Wet Tare** □ **Unused Dry Tare** | | | | | | | | **13a.** □ **Tare Correction**  □ **Moisture Allowance**  □ **Vacuum Pack**  🗹 **Not Applicable** | | | | | | | | | | | **14. Nominal Gross Wt:**  (Box 1 + Box13 − Box 13a =)  *1.014 lb* | | | | | | | |
|  | | **Pkg 1** | | **Pkg 2** | | | **Pkg 3** | | | **Pkg 4** | | **Pkg 5** | | | **Pkg 6** | | | **Pkg 7** | | **Pkg 8** | | **Pkg 9** | | | | **Pkg 10** |
| **a. Gross Wt** | | *1.052 lb* | | *1.026 lb* | | |  | | |  | |  | | |  | | |  | |  | |  | | | |  |
| **b. Tare Wt** | | *0.015 lb* | | *0.013 lb* | | |  | | |  | |  | | |  | | |  | |  | |  | | | |  |
| **c. Net Wt** | | *1.037 lb* | | *1.013 lb* | | |  | | |  | |  | | |  | | |  | |  | |  | | | |  |
| **d.  Package Error** | | *37* | | *13* | | |  | | |  | |  | | |  | | |  | |  | |  | | | |  |
| **−** | **+** | | | | **−** | | | | **+** | | | | **−** | | | | **+** | | | | **−** | | | | **+** | |
| 1. | *38* | | | | 13. | | | |  | | | | 25. | | | |  | | | | 37. | | | |  | |
| 2. | *12* | | | | 14. | | | |  | | | | 26. | | | |  | | | | 38. | | | |  | |
| 3. | *8* | | | | 15. | | | |  | | | | 27. | | | |  | | | | 39. | | | |  | |
| 4. | *4* | | | | 16. | | | |  | | | | 28. | | | |  | | | | 40. | | | |  | |
| 5. *3* |  | | | | 17. | | | |  | | | | 29. | | | |  | | | | 41. | | | |  | |
| 6. *2* |  | | | | 18. | | | |  | | | | 30. | | | |  | | | | 42. | | | |  | |
| 7. | *12* | | | | 19. | | | |  | | | | 31. | | | |  | | | | 43. | | | |  | |
| 8. *3* |  | | | | 20. | | | |  | | | | 32. | | | |  | | | | 44. | | | |  | |
| 9. | *4* | | | | 21. | | | |  | | | | 33. | | | |  | | | | 45. | | | |  | |
| 10. *1* |  | | | | 22. | | | |  | | | | 34. | | | |  | | | | 46. | | | |  | |
| 11. *0* |  | | | | 23. | | | |  | | | | 35. | | | |  | | | | 47. | | | |  | |
| 12. | *6* | | | | 24. | | | |  | | | | 36. | | | |  | | | | 48. | | | |  | |
| **Total:**  *9* | **Total:**  *84* | | | | **Total:** | | | | **Total:** | | | | **Total:** | | | | **Total:** | | | | **Total:** | | | | **Total:** | |
| **15. Total Error:**  *+ 75* | | | **16. Number of unreasonable minus (−) errors (compare each package error with Box 4):**  *0* | | | | | | | | **17. Is Box 16 greater than Box 8?**  □ **Yes,** lot fails  🗹 **No,** go to Box 18 | | | | | | | | **18. Average error in dimensionless units:**  (Box 15 ÷ Box 6 =)  *+ 6.25* | | | | **19. Average error in labeled units:**  (Box 18 × Box 2 =)  *+ 0.006 lb* | | | |
| **20. Does Box 18 = Zero (0) or Plus (+)?**  🗹 **Yes,** lot passes, go to Box 25  □ **No,** go to Box 21 | | | | | | **21. Compute Sample Standard Deviation:** | | | | | **22. Sample Correction Factor:** | | | | | | | | **23. Compute Sample Error Limit:**  (Box 21 × Box 22 =) | | | | | | | |
| **24. Disregarding the signs, is Box 18 larger than Box 23?**  □ **Yes**, lot fails, go to Box 25 □ **No,** lot passes, go to Box 25 | | | | | | | | | | | | | | **25. Disposition of Inspection Lot:**  🗹 **Approved** □ **Rejected** | | | | | | | | | | | | |
| **Comments:**  *Lot Passes* | | | | | | | | | | | | | | **Official’s Signature:** | | | | | | | | | | | | |
|  | | | | | | | | | | | | | | **Acknowledgement of Report:** | | | | | | | | | | | | |

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| **Date:** | Standard Package Report –  Animal Bedding | | | | **Sampling Plan A** – Table 2-1., Appendix A. in NIST Handbook 133 | | **Report Number:** |
| **Location (name, address):** | | | **Product/Brand Identity:** | | **Manufacturer:** | | **Container Description:** |
| **Lot Codes:** | |
| **1. Labeled Quantity (Usable Volume):** | **2. Unit of Measure:** | | **3. MAV:**  (5 % of labeled quantity) | | **4. MAV:**  (0.05 × Box 1. Usable Volume) | **5. Inspection Lot Size:** | **6. Sample Size (n):** |
| **7. Number of Unreasonable Package Errors Allowed for Sample Size:** |
| **Gross Weight for Audit Testing** | | | **Package Error** | | **Test Notes** | | |
| **−** | **+** |
| 1. | |  |  |  |  | | |
| 2. | |  |  |  |  | | |
| 3. | |  |  |  |  | | |
| 4. | |  |  |  |  | | |
| 5. | |  |  |  |  | | |
| 6. | |  |  |  |  | | |
| 7. | |  |  |  |  | | |
| 8. | |  |  |  |  | | |
| 9. | |  |  |  |  | | |
| 10. | |  |  |  |  | | |
| 11. | |  |  |  |  | | |
| 12. | |  |  |  |  | | |
|  | | | Total: | Total: |  | | |
| **8. Total Error:** | **9. Number of unreasonable minus (−) errors (compare each package error with Box 4):** | | | | **10. Is Box 9 greater than Box 7?**  □ **Yes,** lot fails go to Box 17  □ **No,** go to Box 11. | **11. Calculate Average Error**:  (Box 8 ÷ Box 6 =) | |
| **12. Does Box 11 = Zero (0) or Plus (+)?**  □ **Yes,** lot passes, go to Box 17  □ **No,** go to Box 13, 14, 15 & 16 | | | **13. Compute Sample Standard Deviation:** | | **14. Sample Correction Factor:** | **15. Compute Sample Error Limit (SEL):** (Box 13 × Box 14 =) | |
| **16. Disregarding the signs, is Box 11 larger than Box 15?**  □ **Yes,** lot fails, go to Box 17  □ No, lot passes, go to Box 17 | | | | | **17. Disposition of Inspection Lot:**  □ **Approve** □ **Reject** | | |
| **Comments:** | | | | | **Official’s Signature:** | | |
| **Acknowledgement of Report:** | | |

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| Measurement Grid and Package Error Worksheet  for Cylindrical and Square or Rectangular Test Measures |
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| **Complete this for Cylindrical Test Measures** |
| Sample Package \_\_\_\_\_\_\_\_\_\_\_\_\_\_ Labeled Expanded Volume (L): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_  A. Interior Height of Test Measure: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_ B. Radius of Test Measure (r): \_\_\_\_\_\_\_\_\_\_\_  C. Average Depth (Sum of Measurements ÷ 9): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_  D. Average Height of Product (= A − C): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_  E. Volume (L): \_\_\_\_\_\_\_\_\_\_\_\_\_ = 3.14159265 × r2 (B2): \_\_\_\_\_\_\_\_\_\_ × D: \_\_\_\_\_\_\_\_ ÷ 1 000 000  F. Package Error (L): \_\_\_\_\_\_\_\_\_\_\_\_ = Labeled Volume (L): \_\_\_\_\_\_\_\_\_\_\_\_ − E (L): \_\_\_\_\_\_\_\_\_\_\_\_\_  Volume is calculated using: *Volume in liters = πr2h For example: if r2 is 23035 and height of product is 109.26 then* ((Pi) 3.14159265 × r2 (23035) × 109.26) ÷ 1 000 000 = 7.90 L |

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| **Complete this for Square or Rectangular Test Measures** |
| Sample Package \_\_\_\_\_\_\_\_\_\_\_\_\_\_ Labeled Expanded Volume (L): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_  A. Interior Height of Test Measure: \_\_\_\_\_\_\_\_\_\_\_ B. Area of Test Measure Base (L × W): \_\_\_\_\_\_\_\_\_\_\_  C. Average Depth (Sum of Measurements ÷ 9): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_  D. Average Height of Product (= A − C): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_  E. Volume (L): \_\_\_\_\_\_\_\_\_\_\_ = B. Area of Test Measure Base: \_\_\_\_\_\_\_\_\_\_ × D: \_\_\_\_\_\_\_\_ ÷ 1 000 000  F. Package Error (L): \_\_\_\_\_\_\_\_\_\_\_\_ = Labeled Volume (L): \_\_\_\_\_\_\_\_\_\_\_\_ − E (L): \_\_\_\_\_\_\_\_\_\_\_\_\_  Volume is calculated using: *Volume in liters = (lw)h For example: If length and width are 609.6 the area of the measure’s base is 371612. If the Average Height of the Product is 109.26 then:*  \* Area of Test Measure Base (371612) × Average Height of Bedding (109.26) ÷ 1 000 000 = 40.6 L |

(Added 2016)

Ice Glazed Package Worksheet

**STEP**

1. Package Price (if standard pack) $ \_\_\_\_\_\_\_\_\_\_\_\_ Price Per Pound (if random pack) $ \_\_\_\_\_\_\_\_\_\_\_\_\_\_

Lot Size: \_\_\_\_\_\_\_\_\_\_\_\_ Sample Size: \_\_\_\_\_\_\_\_\_\_\_ Unit of Measure: \_\_\_\_\_\_\_\_\_

1. Number each package. Weigh each package for the Gross Package Weight and enter in Row 1.
2. Enter Labeled Net Weight in Row 2. (If dual units determine the larger unit.) \_\_\_\_\_\_\_\_\_\_\_
3. Record the Maximum Allowable Variation (MAV) in Row 3.
4. Weigh the receiving pan = \_\_\_\_\_\_\_\_\_\_\_\_\_ (enter in Row 4). (Clean and dry the receiving pan and verify the weight after each use. Thoroughly clean the sieve.)
5. Deglaze the product. Remove each package from the low temperature storage. Open the package immediately and place the contents in the sieve or other draining device (e.g., colander) under a gentle spray of cold water. Carefully agitate the product. Handle with care to avoid breaking the product. Continue the spraying process until all the ice glaze that is seen or felt is removed.
6. Without shifting the product, incline the sieve to an angle of 17° to 20° (incline to facilitate drainage) and drain for two minutes using a stopwatch.
7. Immediate transfer the entire product to the receiving pan to determine the net weight.
8. To calculate the net weight (receiving pan and product) – (receiving pan)  = Net Weight (enter in Row 5)
9. Calculate ± Package error (net weight [Row 5] – labeled net weight [Row 2]) = ± Error, (enter in Row 6).

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Row** | **Package** | **1** | **2** | **3** | **4** | **5** | **6** | **7** | **8** | **9** | **10** | **11** | **12** |
| **1** | Gross Pkg. Weight  (Step 2) |  |  |  |  |  |  |  |  |  |  |  |  |
| **2** | Labeled Net  Weight  (Step 3) |  |  |  |  |  |  |  |  |  |  |  |  |
| **3** | MAV  (Step 4) |  |  |  |  |  |  |  |  |  |  |  |  |
| **4** | Receiving Pan Weight  (Step 5) |  |  |  |  |  |  |  |  |  |  |  |  |
| **5** | Net Weight  (Step 9) |  |  |  |  |  |  |  |  |  |  |  |  |
| **6** | ± Error  (Step 10) |  |  |  |  |  |  |  |  |  |  |  |  |

Used Dry Tare \_\_\_\_\_\_\_

Transfer data from the “Ice Glazed Package Worksheet” to the “Ice Glazed Package Report”

(Added 2010)

Ice Glazed Package Worksheet – Example

**STEP**

1. Package Price (if standard pack) $ *6.99*  Price Per Pound (if random pack) $  *\_\_\_\_\_\_\_\_\_\_\_\_\_*

Lot Size:  *6*  Sample Size:  *6*  Unit of Measure:  *0.001 lb*

1. Number each package. Weigh each package for the Gross Package Weight and enter Row 1.
2. Enter Labeled Net Weight in Row 2. (If dual units determine the larger unit.) *1 lb/453 g*
3. Record the Maximum Allowable Variation (MAV) in Row 3.
4. Weigh the receiving pan = *0.795 lb*  (enter in Row 4). (Clean and dry the receiving pan and verify the weight after each use. Thoroughly clean the sieve.)
5. Deglaze the product. Remove each package from the low temperature storage. Open the package immediately and place the contents in the sieve or other draining device (e.g., colander) under a gentle spray of cold water. Carefully agitate the product. Handle the product with care to avoid breaking the product. Continue the spraying process until all the ice glaze that is seen or felt is removed.
6. Without shifting the product, incline the sieve to an angle of 17° to 20° (incline to facilitate drainage) and drain for two minutes using a stopwatch.
7. Immediately transfer the entire product to the receiving pan to determine the net weight.
8. To calculate the net weight (receiving pan and product) – (receiving pan)  = Net Weight (enter in Row 5)
9. Calculate ± Package error (net weight [Row 5] – labeled net weight [Row 2]) = ± Error, (enter in Row 6).

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Row** | **Package** | **1** | **2** | **3** | **4** | **5** | **6** | **7** | **8** | **9** | **10** | **11** | **12** |
| **1** | Gross Pkg. Weight  (Step 2) | *1.180* | *1.205* | *1.110* | *1.150* | *1.000* | *1.210* |  |  |  |  |  |  |
| **2** | Labeled Net  Weight  (Step 3) | *1.000* | *1.000* | *1.000* | *1.000* | *1.000* | *1.000* |  |  |  |  |  |  |
| **3** | MAV  (Step 4) | *0.044* | *0.044* | *0.044* | *0.044* | *0.044* | *0.044* |  |  |  |  |  |  |
| **4** | Receiving Pan Weight  (Step 5) | *0.795* | *0.795* | *0.795* | *0.795* | *0.795* | *0.795* |  |  |  |  |  |  |
| **5** | Net Weight  (Step 9) | *0.985* | *0.975* | *1.000* | *1.030* | *0.930* | *0.980* |  |  |  |  |  |  |
| **6** | ± Error  (Step10) | *−0.015* | *−0.025* | *0* | *+0.030* | *−0.070* | *−0.020* |  |  |  |  |  |  |

Used Dry Tare *0.025 lb*

Transfer data from the “Ice Glazed Package Worksheet” to the “Ice Glazed Package Report”

(Added 2010)

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Date:** | | | | | Ice Glazed Package Report | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Sampling Plan:** □ **A** □ **B** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Report Number:** | | | | | | |
| **Location (name, address):** | | | | | | | | | | | | | | | | | **Product/Brand Identity:** | | | | | | | | | | | | | | | | | | | | | | | | | | **Manufacturer:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Container Description:** | | | | | | |
|  | | | | | | | | | | | | | | | | | **Lot Codes:** | | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | |
| **1. Standard Pack Labeled Quantity:**  (If random packed, enter weight for each package in Column 1 below.) | | | | | | | | | | | **2. Unit of Measure:** | | | | | | | | | | | | | | | | | | | | **3. MAV:** Look up the MAV for each package with a minus (−) error, enter value in the Box 4 column below. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **5. Inspection Lot Size:** | | | | | | | | | | | | | | **6. Sample Size (n):** | | | | | |
| **7. Price per lb:**  **7a. Standard Pack: Package Price** \_\_\_\_\_\_\_\_\_\_\_ **divide by (Box 1) =** \_\_\_\_\_\_\_\_\_\_\_\_  **7b.  Random Pack:**  **Labeled Price per lb** \_\_\_\_\_\_\_\_\_\_\_ | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **8. No. of MAVs Allowed:** | | | | | | |
|  | | | **Pkg 1** | | | | | | **Pkg 2** | | | | | | **Pkg 3** | | | | | | | | | **Pkg 4** | | | | **Pkg 5** | | | | | **Pkg 6** | | | | | | **Pkg 7** | | | | | | | **Pkg 8** | | | | | | | | **Pkg 9** | | | | | | **Pkg 10** | | | | | | | **Pkg 11** | | | | | | | | | | **Pkg 12** | | | |
| **Pkg. Gross Wt** | | |  | | | | | |  | | | | | |  | | | | | | | | |  | | | |  | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | | | |  | | | |
| **a. Labeled Net Wt** | | |  | | | | | |  | | | | | |  | | | | | | | | |  | | | |  | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | | | |  | | | |
| **b. Gross**:  Rec. Pan & deglazed product Wt | | |  | | | | | |  | | | | | |  | | | | | | | | |  | | | |  | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | | | |  | | | |
| **c. Tare:** Rec. PanWt | | |  | | | | | |  | | | | | |  | | | | | | | | |  | | | |  | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | | | |  | | | |
| **d. Net Wt :**  (Box b − Box c= ) | | |  | | | | | |  | | | | | |  | | | | | | | | |  | | | |  | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | | | |  | | | |
| **e. Package Error:**  (Box d − Box a = ) | | |  | | | | | |  | | | | | |  | | | | | | | | |  | | | |  | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | | | |  | | | |
| **Package #** | **Column 1**  **Labeled Net Weight**  (random pack only) | | | | | | | | | | | | | | | | | | | | **Package Errors** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **4. MAV**  **Dimensionless Units** | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
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| 3 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| 4 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| 5 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| 6 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| 7 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| 8 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| 9 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| 10 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| 11 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| 12 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| **Totals** |  | | | | | | | | | | | | | | | | | | | | **f**. | | | | | | | | | | | | | | | **g**. | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | |
| **9. Total Error:**  (add Row e or Box f + g) | | | | **10. Number of Unreasonable Minus (−) Errors:** (compare each package error with the MAV in the Box 4 column) | | | | | | | | | | | | | | | | | | | | | | | | | | | **11. Is Box 10 greater than Box 8?**  □ **Yes,** lot fails  □ **No,** go to Box 12 | | | | | | | | | | | | | | | | | | | **12. Avg. Error:** (Box 9 ÷ Box 6 = ) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **13. Does Box 12 = Zero (0) or Plus (+)?**  □ **Yes,** lot passes, go to Box 18  □ **No,** go to Box 14 | | | | | | | | | | | | | **14. Compute Sample Standard Deviation:** | | | | | | | | | | | | | | | | | | **15. Sample Correction Factor:** | | | | | | | | | | | | | | | | | | | **16. Compute Sample Error Limit:**  (Box 14 × Box 15 =) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **17. Disregarding the signs, is Box 12 larger than Box 16?**  □ Yes, lot fails, go to Box 18  □ No, lot passes, go to Box 18 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **18. Disposition of Inspection Lot:**  □ **Approved** □ **Rejected** | | | | | | | | | | | | | | | | | | | | | | | | | | | **19. Economic Impact:**  (Box 12 × Box 7 × Box 5 = ) | | | | | | | | | | | | | | | | | | | | | | |
| **Comments:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Official’s Signature:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Acknowledgement of Report:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Date:**  *January 20, 2010* | | | | | | | Ice Glazed Package Report – Example | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Sampling Plan:** 🗹 **A** □ **B** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Report Number:**  *103* | | | | | | |
| **Location (name, address):**  *Ocean Fresh Market*  *101 8th Street*  *Key West, FL* | | | | | | | | | | | | | | | | | **Product/Brand Identity:**  *Raw/Peeled Shrimp 71 – 90 Count* | | | | | | | | | | | | | | | | | | | | | | | | | | **Manufacturer:**  *Ocean Fresh* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Container Description:**  *Plastic* | | | | | | |
|  | | | | | | | | | | | | | | | | | Lot Codes: | | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | |
| **1. Standard Pack Labeled Quantity:** *453 g (1 lb)*  (If random packed, enter weight for each package in Column 1 below.) | | | | | | | | | | | **2. Unit of Measure:**  *0.001 lb* | | | | | | | | | | | | | | | | | | | | **3. MAV:** Look up the MAV for each package with a minus (−) error, enter value in the Box 4 column below.  *0.044 lb* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **5. Inspection Lot Size:**  *6* | | | | | | | | | | | | | | **6. Sample Size (n):**  *6* | | | | | |
| 7. Price per lb:  **7a. Standard Pack: Package Price** **$** *6.99*  **divide by (Box 1) =** **$** *6.99*  **7b.  Random Pack:  Labeled Price per lb** \_\_\_\_\_\_\_\_\_\_\_ | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 8. No. of MAVs Allowed  *0* | | | | | | |
|  | | **Pkg 1** | | | | | | | | **Pkg 2** | | | | | | **Pkg 3** | | | | | | | | | **Pkg 4** | | | | | **Pkg 5** | | | | | | | **Pkg 6** | | | | | **Pkg 7** | | | | | | | **Pkg 8** | | | | | | | | **Pkg 9** | | | | | | | **Pkg 10** | | | | | | | | | **Pkg 11** | | | | | | | **Pkg 12** |
| **Pkg. Gross Wt** | | *1.180* | | | | | | | | *1.205* | | | | | | *1.100* | | | | | | | | | *1.150* | | | | | *1.000* | | | | | | | *1.210* | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  |
| **a. Labeled Net Wt** | | *1.000* | | | | | | | | *1.000* | | | | | | *1.000* | | | | | | | | | *1.000* | | | | | *1.000* | | | | | | | *1.000* | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  |
| **b. Gross:** Rec. Pan & deglazed product Wt | |  | | | | | | | |  | | | | | |  | | | | | | | | |  | | | | |  | | | | | | |  | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  |
| **c. Tare:** Rec. Pan Wt | | *0.795* | | | | | | | | *0.795* | | | | | | *0.795* | | | | | | | | | *0.795* | | | | | *0.795* | | | | | | | *0.795* | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  |
| **d. Net Wt**  (Box b − Box c= ) | | *0.985* | | | | | | | | *0.975* | | | | | | *1.000* | | | | | | | | | *1.030* | | | | | *0.930* | | | | | | | *0.980* | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  |
| **e. Package Error**  (Box d − Box a = ) | | *− 0.015* | | | | | | | | *− 0.025* | | | | | | *0* | | | | | | | | | *+ 0.030* | | | | | *− 0.070* | | | | | | | *− 0.020* | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  |
| **Package #** | **Column 1**  **Labeled Net Weight**  (random pack only) | | | | | | | | | | | | | | | | | | | | **Package Errors** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **4.**  **MAV**  **Dimensionless Units** | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
|  |  | | | | | | | | | | | | | | | | | | | | **−** | | | | | | | | | | | | | | | **+** | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
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| 3 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| 4 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| 5 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| 6 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| 7 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| 8 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| 9 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| 10 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| 11 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| 12 |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | |  | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| **Totals** |  | | | | | | | | | | | | | | | | | | | | **f**. | | | | | | | | | | | | | | | **g**. | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | |
| **9. Total Error:**  (add Row e or Box f + g)  *− 0.100* | | | | | | | 1. **Number of Unreasonable Minus (−) Errors:** (compare each package error with the MAV in the Box 4 column)   *1* | | | | | | | | | | | | | | | | | | | | | | | | **11. Is Box 10 greater than Box 8?**  🗹 **Yes**, lot fails  □ **No,** go to Box 12 | | | | | | | | | | | | | | | | | | | **12. Avg. error:** (Box 9 ÷ Box 6 = )  *− 0.016* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **13. Does Box 12 = Zero (0) or Plus (+)?**  □ **Yes,** lot passes, go to Box 18  □ **No,** go to Box 14 | | | | | | | | | | | | | **14. Compute Sample Standard Deviation:** | | | | | | | | | | | | | | | | | | **15. Sample Correction Factor:** | | | | | | | | | | | | | | | | | | | **16. Compute Sample Error Limit:**  (Box 14 × Box 15 =) | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **17. Disregarding the signs, is Box 12 larger than Box 16?**  □ **Yes,** lot fails, go to Box 18  □ **No,** lot passes, go to Box 18 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **18. Disposition of Inspection Lot:**  □ **Approved** 🗹  **Rejected** | | | | | | | | | | | | | | | | | | | | | | | | | | | **19. Economic Impact:**  (Box 12 × Box 7 × Box 5 = )  *− 0.016 × $6.99 × 6 = $0.67* | | | | | | | | | | | | | | | | | | | | | | |
| **Comments:**  *Product found to contain less than the stated net contents. Failed due to MAV.* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Official’s Signature:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Acknowledgement of Report:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Date:** | | | | | | | | Determining the Free Liquid and Net Volume of Oysters Worksheet | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Report Number:** | | | | | | | | | | | |
| **Location (name, address):** | | | | | | | | | | | | | | | | | | | | **Product/Brand Identity:** | | | | | | | | | | | | | | | | | | | | | | | | | **Manufacturer:** | | | | | | | | | | | | | | | | | | | | | | | | **Container Description:** | | | | | | | | | | | |
|  | | | | | | | | | | | | | | | | | | | | **Lot Codes:** | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | |
| **1. Labeled Quantity:** | | | | | | | | **2. Unit of Measure:** | | | | | | | | | | | | **3. Inspection Lot Size:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **4. Sample Size:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Amount of Free Liquid**  **Values** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Steps:** | | | | | | | | | | | | **Pkg 1** | | | | | | **Pkg 2** | | | | | | | | **Pkg 3** | | | | | | **Pkg 4** | | | | | | **Pkg 5** | | | | | | **Pkg 6** | | | | | | | | **Pkg 7** | | | | | | | **Pkg 8** | | | | | | | **Pkg 9** | | | | | | | | | | **Pkg 10** | | | | |
| **1. Weight of Dry Receiving Pan** | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
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| **2. Gross Weight of Package** | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **Reference Temperature of Oysters**  7 °C (± 1) [45 °F (± 2)] | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **3. Tare Weight of Package** | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **4. Net Weight of Oysters & Liquid** (Step 2 – Step 3 = ) | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
|  | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **5. Weight of Receiving Pan and Drained Liquid** | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **6. Weight of Free Liquid** (Step 5 – Step 1 = ) | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **7. Percentage (%) of Free Liquid**  (Step 6 ÷ Step 4 × 100 =) | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **Net Volume** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1. Test the oysters at the temperature of 7 °C (± 1) [45 °F (± 2)].  2. Establish the level of fill of the package using a depth gage.  3. Empty and dry the package.  4. Refill the package with water to the level of the depth gage.  5. Record the amount of delivered water and then sum the quantities to obtain the total volume in the package. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Amount of Free Liquid** | | | | | | | | | | | | **Quantity of Water Delivered into Package** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | | | | | | | | | | | **Pkg 1** | | | | | | **Pkg 2** | | | | | | | | **Pkg 3** | | | | | | **Pkg 4** | | | | | | **Pkg 5** | | | | | | **Pkg 6** | | | | | | | | **Pkg 7** | | | | | | | **Pkg 8** | | | | | | | **Pkg 9** | | | | | | | | | | **Pkg 10** | | | | |
| **8. Flask Size** | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **9. Flask Size** | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **10. Graduate or Cylinder** | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **11. Graduate or Cylinder** | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **12. Total**  (8 + 9 + 10 = ) | | | | | | | | | | | |  | | | | | |  | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | |  | | | | | | | | | |  | | | | |
| **Comments:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Date:**  *December 20, 2013* | | | | | | Determining the Free Liquid and Net Volume  of Oysters Worksheet – Example | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **Report Number**:  *1 of 2* | | | | | | | | | | | | |
| **Location (name, address):**  *Superchain Market*  *Main Street*  *Bradenton, FL* | | | | | | | | | | | | | | | | | | | **Product/Brand Identity:**  *World’s Best Oysters – Oyster Standard* | | | | | | | | | | | | | | | | | | | | | | | | | | **Manufacturer**:  *World’s Best Packing*  *Beach Road, AL* | | | | | | | | | | | | | | | | | | | | | | | **Container Description:**  *Clear Plastic Tub with metal pull top* | | | | | | | | | | | | |
|  | | | | | | | | | | | | | | | | | | | **Lot Codes:**  *12/26/2012* | | | | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | | | | | | | | | | | |  | | | | | | | | | | | | |
| **1. Labeled Quantity:**  *12 fl oz (355 ml)* | | | | | | **2. Unit of Measure:**  *0.001 lb* | | | | | | | | | | | | | **3. Inspection Lot Size:**  *206* | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | **4. Sample Size:**  *12* | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Amount of Free Liquid**  **Values** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Steps:** | | | | | | | | | | | | | | **Pkg 1** | | | | | | | | | **Pkg 2** | | | | | | **Pkg 3** | | | | | | **Pkg 4** | | | | | | **Pkg 5** | | | | | | | **Pkg 6** | | | | | | | | **Pkg 7** | | | | | | | **Pkg 8** | | | | | | | | | **Pkg 9** | | | | | | | **Pkg 10** | |
| **1. Weight of Dry Receiving Pan** | | | | | | | | | | | | | | *11.841* | | | | | | | | | *11.841* | | | | | | *11.841* | | | | | | *11.841* | | | | | | *11.841* | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
|  | | | | | | | | | | | | | |  | | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
| **2. Gross Weight of Package** | | | | | | | | | | | | | | *0.871* | | | | | | | | | *0.884* | | | | | | *0.920* | | | | | | *0.869* | | | | | | *0.8632* | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
| **Reference Temperature of Oysters**  7 °C (± 1) [45 °F (± 2)] | | | | | | | | | | | | | | *44 °F* | | | | | | | | | *46 °F* | | | | | | *44 °F* | | | | | | *47 °F* | | | | | | *45.5 °F* | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
| **3. Tare Weight of Package** | | | | | | | | | | | | | | *0.060* | | | | | | | | | *0.060* | | | | | | *0.060* | | | | | | *0.059* | | | | | | *0.060* | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
| **4. Net Weight of Oysters & Liquid** (Step 2 – Step 3 = ) | | | | | | | | | | | | | | *0.811* | | | | | | | | | *0.824* | | | | | | *0.86* | | | | | | *0.81* | | | | | | *0.803* | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
|  | | | | | | | | | | | | | |  | | | | | | | | |  | | | | | |  | | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
| **5. Weight of Receiving Pan and Drained Liquid** | | | | | | | | | | | | | | *12.020* | | | | | | | | | *12.121* | | | | | | *12.120* | | | | | | *12.031* | | | | | | *12.242* | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
| **6. Weight of Free Liquid**  (Step 5 – Step 1 = ) | | | | | | | | | | | | | | *0.179* | | | | | | | | | *0.28* | | | | | | *0.279* | | | | | | *0.19* | | | | | | *0.401* | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
| **7. Percentage (%) of Free Liquid** (Step 6 ÷ Step 4 × 100 =) | | | | | | | | | | | | | | *22 %* | | | | | | | | | *33 %* | | | | | | *32 %* | | | | | | *23 %* | | | | | | *49 %* | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | |
| **Net Volume** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 1. Test the oysters at the temperature of 7 °C (± 1) [45 °F (± 2)].  2. Establish the level of fill of the package using a depth gage.  3. Empty and dry the package.  4. Refill the package with water to the level of the depth gage.  5. Record the amount of delivered water and then sum the quantities to obtain the total volume in the package. | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Amount of Free Liquid** | | | | | | | | | | | | | | **Quantity of Water Delivered into Package** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | | | | | | | | | | | | | | **Pkg 1** | | | | | | | | **Pkg 2** | | | | | **Pkg 3** | | | | | | | **Pkg 4** | | | | | | **Pkg 5** | | | | | | | **Pkg 6** | | | | | | | | **Pkg 7** | | | | | | | **Pkg 8** | | | | | | | | | **Pkg 9** | | | | | | | **Pkg 10** | | |
| **8. Flask Size** | | | | | | | | | | | | | |  | | | | | | | |  | | | | |  | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | | |
| **9. Flask Size** | | | | | | | | | | | | | |  | | | | | | | |  | | | | |  | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | | |
| **10. Graduate or Cylinder** | | | | | | | | | | | | | |  | | | | | | | |  | | | | |  | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | | |
| **11. Graduate or Cylinder** | | | | | | | | | | | | | |  | | | | | | | |  | | | | |  | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | | |
| **12. Total**  (8 + 9 + 10 = ) | | | | | | | | | | | | | |  | | | | | | | |  | | | | |  | | | | | | |  | | | | | |  | | | | | | |  | | | | | | | |  | | | | | | |  | | | | | | | | |  | | | | | | |  | | |
| **Comments:** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Inspector:** | | | | Chitterlings Worksheet – Category A  (Net Weight & Purge Determinations) | | | | | | |
| **Date:** | | | |
| **Packer:** | | | | | **Lot Code:** | | | **Drain Pan Tare:** | **Unit of Measure:** | |
| **Brand:** | | |
| **Package Number** | **A** | **B** | **C** | | **D** | **E** | **If Error *Exceeds* MAV = Fail** | **F** | **G** | |
| **Labeled Net**  **Weight** | **Package**  **Gross**  **Weight** | **Package**  **Tare**  **Weight** | | **Actual Package Net**  **Weight**  B – C = | **Package Error**  D – A = | **Purged Net Wt**  **Weight of Drained Chitterlings (or Purged Liquid) and**  **Drain Pan − Drain Pan Tare =** | **Purge %**  (A – F) × 100  A | |
| **1** |  |  |  | |  |  |  |  |  | % |
| **2** |  |  |  | |  |  |  |  |  | % |
| **3** |  |  | |  |  |  |  |  | % |
| **4** |  |  | |  |  |  |  |  | % |
| **5** |  |  | |  |  |  |  |  | % |
| **6** |  |  | |  |  |  |  |  | % |
| **7** |  |  | |  |  |  |  |  | % |
| **8** |  |  | |  |  |  |  |  | % |
| **9** |  |  | |  |  |  |  |  | % |
| **10** |  |  | |  |  |  |  |  | % |
| **11** |  |  | |  |  |  |  |  | % |
| **12** |  |  | |  |  |  |  |  | % |
| **Number of Unreasonable Errors Allowed:**  **Table 2-9. MAV:** | | | **E1 − Total Error :** | | | | | **G1 − Total Purge:** | | % |
| **E2 – Average Error :**  (E1 ÷ n = ) | | | | | **G2 – Average Purge:**  (G1 ÷ n = ) | | % |
| **G3 – Adjusted Average Purge:** (G2 – Purge Sample Error Limit [PSEL] = ) | | | | | | | % |
| **NET WEIGHT COMPLIANCE:**  (1)If any of the minus package errors (see Column E) exceed the MAV, the sample fails. (2) If none exceeds the MAV and the Average Error (E2) is a positive number, the sample passes. (3) If the Average Error (E2) is a minus number, calculate the sample standard deviation and enter it below. (4) Use the Sample Correction Factor (SCF) to calculate the Sample Error Limit (SEL). (5) Disregarding the signs, (a) if the Average Error (E2) is larger than the SEL, the sample fails or (b) if the Average Error is less than the SEL the sample passes.  **Standard Deviation: × 0.635 (SCF)**= **(SEL)** □  **Passed** □ **Failed** | | | | | | | | | | |
| **PURGE COMPLIANCE:** MAVs are not applied in the purge test (1) If the Average Purge Error (G2) is less than or equal to 20 %, the sample passes. (2) If the Average Purge Error is greater than 20 %, calculate the sample standard deviation and enter it below. (3) Use the Sample Correction Factor (SCF) to calculate the Purge Sample Error Limit (PSEL) in percent. (4) Subtract the PSEL from the Average Purge (G2) to obtain an Adjusted Average Purge (AAP) and enter that value in G3. (5)(a) If the AAP (G3) is greater than 20 %, the sample fails or (b) if the AAP (G3) is 20 % or less, the sample passes.  **Standard Deviation: × 0.635 (SCF)** = **(PSEL)** **Purge (G3)** □ **Passed** □ **Failed** | | | | | | | | | | |
| **Sample Disposition:** | | | | | | | | | | |

|  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Inspector:**  *S. Inspector* | | | | Chitterlings Worksheet – Category A – Example  (Net Weight & Purge Determinations Worksheet) | | | | | | |
| **Date:** *July 12, 2016* | | | |
| **Packer:** *Packer Inc.*  *1000 Roadway*  *PackingTown, USA* | | | | | **Lot Code:** *a342012* | | | **Drain Pan Tare:**  *0.997 lb* | **Unit of Measure:**  *lb* | |
| **Brand:** *Allbrand* | | |
| **Package Number** | **A** | **B** | **C** | | **D** | **E** | **If Error *Exceeds***  **MAV = Fail** | **F** | **G** | |
| **Labeled Net**  **Weight** | **Package**  **Gross**  **Weight** | **Package Tare**  **Weight** | | **Actual Package  Net**  **Weight**  B – C = | **Package Error**  D – A = | **Purged Net Wt**  **Weight of Drained Chitterlings (or Purged Liquid) and Drain Pan − Drain Pan Tare =** | **Purge %**  (A – F) × 100  A | |
| **1** | *5 lb* | *5.130* | *0.032* | | *5.098* | *0.098* |  | *4.19* | *16.2* | % |
| **2** |  | *5.160* | *0.033* | | *5.127* | *0.127* |  | *4.21* | *15.8* | % |
| **3** | *5.012* | *0.032* | | *4.980* | *− 0.020* |  | *4.17* | *16.6* | % |
| **4** | *5.170* | *0.034* | | *5.136* | *0.136* |  | *4.20* | *16.0* | % |
| **5** | *5.020* | *0.033* | | *4.987* | *− 0.013* |  | *4.18* | *16.4* | % |
| **6** | *5.102* | *0.032* | | *5.070* | *0.070* |  | *4.22* | *15.6* | % |
| **7** | *5.051* | *0.033* | | *5.018* | *0.018* |  | *4.24* | *15.2* | % |
| **8** | *5.116* | *0.032* | | *5.084* | *0.084* |  | *4.20* | *16.0* | % |
| **9** | *5.120* | *0.034* | | *5.086* | *0.086* |  | *4.19* | *16.2* | % |
| **10** | *5.023* | *0.032* | | *4.991* | *− 0.009* |  | *4.20* | *16.0* | % |
| **11** | *5.122* | *0.032* | | *5.090* | *0.090* |  | *4.26* | *14.8* | % |
| **12** | *5.020* | *0.033* | | *4.987* | *− 0.013* |  | *4.18* | *16.4* | % |
| **Number of Unreasonable Errors Allowed:** NONE  **Table 2-9. MAV:** *0.0.094 lb* | | | **E1 − Total Error:** *0.054 lb* | | | | | **G1 − Total Purge:** *191.2* | | % |
| **E2 – Average Error:** *0.0045 lb*  (E1 ÷ n = ) | | | | | **G2 – Average Purge:** *15.9*  (G1 ÷ n = ) | | % |
| **G3 – Adjusted Average Purge:** (G2 – Purge Sample Error Limit [PSEL] = ) | | | | | | | % |
| **NET WEIGHT COMPLIANCE:**  (1)If any of the minus package errors (see Column E) exceed the MAV, the sample fails. (2) If none exceeds the MAV and the Average Error (E2) is a positive number, the sample passes. (3) If the Average Error (E2) is a minus number, calculate the sample standard deviation and enter it below. (4) Use the Sample Correction Factor (SCF) to calculate the Sample Error Limit (SEL). (5) Disregarding the signs, (a) if the Average Error (E2) is larger than the SEL, the sample fails or (b) if the Average Error is less than the SEL the sample passes.  **Standard Deviation:** *0.0601***× 0.635 (SCF)**= *0.0382* **(SEL)** 🗹 **Passed** □ **Failed** | | | | | | | | | | |
| **PURGE COMPLIANCE:** MAVs are not applied in the purge test (1) If the Average Purge Error (G2) is less than or equal to 20 %, the sample passes. (2) If the Average Purge Error is greater than 20 %, calculate the sample standard deviation and enter it below. (3) Use the Sample Correction Factor (SCF) to calculate the Purge Sample Error Limit (PSEL) in percent. (4) Subtract the PSEL from the Average Purge (G2) to obtain an Adjusted Average Purge (AAP) and enter that value in G3. (5)(a) If the AAP (G3) is greater than 20 %, the sample fails or (b) if the AAP (G3) is 20 % or less, the sample passes.  **Standard Deviation:** *2.420* **× 0.635 (SCF)** = *1.536* **(PSEL)** **Purge (G3)** *18.83*% 🗹 **Passed** □ **Failed** | | | | | | | | | | |
| **Sample Disposition:***Lot passes on both criteria.* | | | | | | | | | | |

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| **Inspector:** | | | | Chitterlings Worksheet – Category B  (For Use Inside a USDA Inspected Packing Plant Net Weight & Purge Determination) | | | | | | |
| **Date:** | | | |
| **Packer:** | | | | | **Lot Code:** | | | **Drain Pan Tare:** | **Unit of Measure:** | |
| **Brand:** | | |
| **Package Number** | **A** | **B** | **C** | | **D** | **E** | I**f Error *Exceeds* MAV = Fail** | **F** | **G** | |
| **Labeled Net**  **Weight** | **Package**  **Gross**  **Weight** | **Package**  **Tare**  **Weight** | | **Actual**  **Package**  **Net**  **Weight**  B – C = | **Package Error**  D – A = | **Purged Net Wt**  **Drained Chitterlings (or Purged Liquid) and Pan − Drain Pan Tare =** | **Purge %**  (A – F) × 100  A | |
| **1** |  |  |  | |  |  |  |  |  | % |
| **2** |  |  |  | |  |  |  |  |  | % |
| **3** |  |  | |  |  |  |  |  | % |
| **4** |  |  | |  |  |  |  |  | % |
| **5** |  |  | |  |  |  |  |  | % |
| **6** |  |  | |  |  |  |  |  | % |
| **7** |  |  | |  |  |  |  |  | % |
| **8** |  |  | |  |  |  |  |  | % |
| **9** |  |  | |  |  |  |  |  | % |
| **10** |  |  | |  |  |  |  |  | % |
| **Number of Unreasonable Errors Allowed:** NONE  **Table 2-9. MAV:** | | | **E1 – Total Error:** | | | | | **G1 –Total Purge:** | | % |
| **E2 – Average Error:**  (E1 ÷ n = ) | | | | | **G2 – Average Purge:**  (G1 ÷ n = ) | | % |
| **NET WEIGHT COMPLIANCE:** (1)If any of the minus package errors (see Column E) exceed the MAV the sample fails. (2) If none of the package errors exceeds the MAV and the Average Error (E2) is a positive number the sample passes. (3) If the Average Error (E2) is a minus number the sample fails.  □ **Passed** □ **Failed** | | | | | | | | | | |
| **PURGE COMPLIANCE:** MAVs are not applied in the purge test (1) If the Average Purge Error (G2) is less than or equal to 20 %, the sample passes. (2) If the Average Purge Error (G2) is greater than 20 %, the sample fails.  **Purge:** □ **Passed** □  **Failed** | | | | | | | | | | |
| **Sample Disposition:** | | | | | | | | | | |

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| **Inspector:**   *S. Inspector* | | | | Chitterlings Worksheet – Category B – Example  (for use Inside a USDA Inspected Packing Plant Net Weight & Purge Determinations) | | | | | | |
| **Date:**  *July 14, 2016* | | | |
| **Packer:**   *Packer Inc.*  *1000 Roadway*  *PackingTown, USA* | | | | | **Lot Code:** *a34526* | | | **Drain Pan Tare:**  *0.997 lb* | **Unit of Measure:**  *lb* | |
| Brand:  *Allbrand* | | |
| **Package Number** | **A** | **B** | **C** | | **D** | **E** | I**f Error *Exceeds* MAV = Fail** | **F** | **G** | |
| **Labeled Net**  **Weight** | **Package**  **Gross**  **Weight** | **Package**  **Tare**  **Weight** | | **Actual**  **Package**  **Net**  **Weight**  B – C = | **Package Error**  D – A = | **Purged Net Wt**  **Drained Chitterlings**  **(or Purged Liquid) and Pan − Drain Pan Tare =** | **Purge %**  (A – F) × 100  A | |
| **1** | *5* | *5.130* | *0.032* | | *5.098* | *0.098* |  | *4.19* | *16.2* | % |
| **2** |  | *5.160* | *0.033* | | *5.127* | *0.127* |  | *4.21* | *15.8* | % |
| **3** | *5.012* | *0.032* | | *4.980* | *− 0.020* |  | *4.17* | *16.6* | % |
| **4** | *5.170* | *0.034* | | *5.136* | *0.136* |  | *4.20* | *16.0* | % |
| **5** | *5.020* | *0.033* | | *4.987* | *− 0.013* |  | *4.18* | *16.4* | % |
| **6** | *5.102* | *0.032* | | *5.070* | *0.070* |  | *4.22* | *15.6* | % |
| **7** | *5.051* | *0.033* | | *5.018* | *0.018* |  | *4.24* | *15.2* | % |
| **8** | *5.116* | *0.032* | | *5.084* | *0.084* |  | *4.20* | *16.0* | % |
| **9** | *5.120* | *0.034* | | *5.086* | *0.086* |  | *4.19* | *16.2* | % |
| **10** | *5.023* | *0.032* | | *4.991* | *− 0.009* |  | *4.20* | *16.0* | % |
| **Number of Unreasonable Errors Allowed:** NONE  **Table 2-9. MAV:** 0.094 lb | | | **E1 – Total Error** *0.057 lb* | | | | | **G1 –Total Purge:**  *160* | | % |
| **E2 – Average Error** *0.057 lb*  (E1 ÷ n = ) | | | | | **G2 – Average Purge:** *16*  (G1 ÷ n = ) | | % |
| **NET WEIGHT COMPLIANCE:** (1)If any of the minus package errors (see Column E) exceed the MAV the sample fails. (2) If none of the package errors exceeds the MAV and the Average Error (E2) is a positive number the sample passes. (3) If the Average Error (E2) is a minus number the sample fails.  🗹  **Passed** □ **Failed** | | | | | | | | | | |
| **PURGE COMPLIANCE:** MAVs are not applied in the purge test (1) If the Average Purge Error (G2) is less than or equal to 20 %, the sample passes. (2) If the Average Purge Error (G2) is greater than 20 %, the sample fails.  **Purge:** □ **Passed** □ **Failed** | | | | | | | | | | |
| **Sample Disposition:** | | | | | | | | | | |

| **Date:** | | | | | Peat Moss Labeled by Volume Package Worksheet – Dimensional Procedure | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| **Labeled Quantity** | | | | | **Converted to Metric:** | | | | | **Largest Quantity:** | | | | | | | | | **Manufacturer:** | | | | | | | | | | | | | | | |
|  | | | | |  | | | | |  | | | | | | | | | **Product:** | | | | | | | | | | | | | | | |
| **Lot Size:** | | | | | | | | | | **Sample Size:** | | | | | | | | | **Lot Code:** | | | | | | | | | **Plant Number:** | | | | | | |
| 1 cubic foot = 1728 cu in \*Total Volume (cubic feet) = L × W × H ÷ 1728 or \*Total Volume (L)  (cubic meter) = L × W × H ÷ 1 000 000 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Dimensions Measured in:** □ **mm** □ **in Package Error in:** □ **mL** □ **cu in** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
|  | **Length** | | | | | | | | | **Avg** | **Width** | | | | | | | | | **Avg** | | **Height** | | | | | | | | | **Avg** | | **Total\*** | |
| **1.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **2.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **3.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **4.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **5.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **6.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **7.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **8.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **9.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **10.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **11.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **12.** |  | |  |  | | |  |  | |  |  | |  |  | |  |  | | |  | |  |  | |  | |  | | |  |  | |  | |
| **Step 1.** What is the MAV for this labeled quantity in Table 2-6?   * + - * \_\_\_\_\_\_\_\_\_\_ **mL** □ \_\_\_\_\_\_\_\_\_\_ **cu in** | | | | | | | | | | | | | | | | | | | | | | | | | | **Total Package Error:** | | | | | | | | |
| **Step 2.** How many minus errors exceed the MAV \_\_\_\_\_\_\_? If the number of unreasonable errors exceeds the number permitted for the sample size in Table 2-1., the sample fails; go to Step 7. If there are no Unreasonable Errors, sum the package errors, and calculate the Average Error entering it in Step 3. Go to Step 4. | | | | | | | | | | | | | | | | | | | | | | | | | | **Step 3: Average Package Error:** | | | | | | | | |
| **Step 4.** If the Average Error is zero or a positive number, the sample passes; go to Step 7. If the Average Error is a negative number, go to Step 5.  **Step 5.** Calculate the Sample Standard Deviation (*s*) and multiply (*s*) by the Sample Correction Factor (*SCF*) for the sample size to obtain the Sample Error Limit (*SEL*); go to Step 6.  ***(s)****\_\_\_\_\_\_\_\_\_\_\_\_\_\_ ×* **(*SCF*)**\_\_\_\_\_\_\_\_\_\_\_ **= *SEL*** *\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_* | | | | | | | | | | | | | | | | | | | | | | | | | | **Box 6.** Disregarding the signs, is the *SEL* in Step 5 larger than the Average Package Error in Step 3? If yes, the sample passes, go to Step 7 and approve the lot. If no, the sample fails, go to Step 7 and reject the lot. | | | | | | | | |
| **Step 7.** Action Taken: □ Lot Rejected □ Lot Approved | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| **Random Numbers: Enter the numbers as you select them in the top row and reorder them in the bottom row.** | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | |
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| **Date:** | Borax Audit Worksheet  Use only IF the sample fails the net weight test. Use the lightest package in the sample. | |
| **Inspector:** |
| 1. **Product:** | | 1. **Lot Code:** |
| 1. **Declared Net Weight on the Package:** | |  |
| 1. **Declared Volume on the Borax Package:** | |  |
| 1. **Gross Weight of Package:** | |  |
| 1. **Tare Weight of Package:** | |  |
| 1. **Net Weight of Package:** | |  |
| 1. **Volume of Dry Measure – Look up the volume of the dry measure in milliliters used to calculate the volume and enter it below**:   **=** **mL**  Dry Measure: Dry Pint = 550.6 mL; Dry Quart = 1101 mL; Liter = 1000 mL | | |
| 1. **Empty Weight of Dry Measure:** | |  |
| 1. **Gross Weight of Dry Measure + Borax:** | |  |
| 1. **Net Weight of Borax in the Dry Measure:**   (Box 10 – Box 9) = | |  |
| 1. **Net Volume of Borax:**   (Box 7 ÷ Box 11) × Box 8 = | |  |
| 1. **Refer to Step 10 to determine if the sample is in compliance or if further action is required.** | | |
| (Added 2016) | | |

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| Softwood Lumber Worksheet | | | | | | | | | | | | | | | | | |
| MAV for Packages Labeled by Length, Width, or Area (Table 2-8)  (**Note:** Lumber of a predetermined dimension as defined by NIST Handbook 130, “Uniform Packaging and Labeling Regulations).   * 1 m (1 yd) or less in 3 % of labeled quantity. * More than 1 m (1 yd) to 43 m (48 yd) is 1.5 % of labeled quantity. | | | | | | | | | | | | | | | | | |
| **Section 1. Compliance with Maximum Allowable Variation**   1. Calculate the MAV for labeled thickness = \_\_\_\_\_\_\_. Do any of the minus errors for thickness exceed the MAV?   □ Yes, go to Section 5. □ No, go to Section 2   1. Calculate the MAV for length = \_\_\_\_\_\_\_\_\_\_\_\_\_\_. Do any of the minus errors for width exceed the MAV?   □ Yes, go to Section 5. □ No, go to Section 3   1. Calculate the MAV for labeled width = \_\_\_\_\_\_\_\_. Do any of the minus errors for length exceed the MAV?   □ Yes, go to Section 5. □ No, go to Section 4 | | | | | | | | | | | | | | | | | |
| **Section 2. Compliance with the Average Requirement – Thickness**  4. Calculate the Average Error for labeled thickness \_\_\_\_\_\_\_. The sample passes this requirement if the Average Error is zero or a positive number. Go to Section 3. If the Average Error is a negative number, go to Step 5.  5. Calculate the Sample Standard Deviation (*s*) and multiply (*s*) by the Sample Correction Factor (*SCF*) for the sample size to obtain the Sample Error Limit (*SEL*). Go to Step 6.  *(s)\_\_\_\_\_\_\_\_\_\_\_\_\_\_ ×* (*SCF*)\_\_\_\_\_\_\_\_\_\_\_ = *SEL \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_*  6. Disregarding the signs, is the *SEL* in Step 5 larger than the Average Error in Step 4? If yes, the lot passes on thickness. If no, go to Section 3. | | | | | | | | | | | | | | | | | |
| **Section 3. Compliance with the Average Requirement – Length**  7. Calculate the Average Error for labeled length\_\_\_\_\_\_\_. The sample passes this requirement if the Average Error is zero or a positive number. Go to Section 4. If the Average Error is a negative number, go to Step 8.  8. Calculate the Sample Standard Deviation (*s*) and multiply (*s*) by the Sample Correction Factor (*SCF*) for the sample size to obtain the Sample Error Limit (*SEL*). Go to Step 9.  *(s)\_\_\_\_\_\_\_\_\_\_\_\_\_\_ ×* (*SCF*)\_\_\_\_\_\_\_\_\_\_\_ = *SEL \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_*  9. Disregarding the signs, is the *SEL* in Step 8 larger than the Average Error in Step 7? If yes, the lot passes on length. If no, go to Section 4. | | | | | | | | | | | | | | | | | |
| **Section 4. Compliance with the Average Requirement – Width**  10. Calculate the Average Error for labeled width\_. The sample passes this requirement if the Average Error is zero or a positive number. Go to Section 6. If the Average Error is a negative number, go to Step 11.  11. Calculate the Sample Standard Deviation (*s*) and multiply (*s*) by the Sample Correction Factor (*SCF*) for the sample size to obtain the Sample Error Limit (*SEL*). Go to Step 12.  *(s)\_\_\_\_\_\_\_\_\_\_\_\_\_\_ ×* (*SCF*)\_\_\_\_\_\_\_\_\_\_\_ = *SEL \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_*  12. Disregarding the signs, is the *SEL* in Step 11 larger than the Average Error in Step 10?  □ Yes, approve the lot. □ No, go to Section 5 | | | | | | | | | | | | | | | | | |
| **Section 5. Determine Moisture Shrinkage Allowance**  If the average error for any thickness or width measurement is a minus value, or if the MAV is exceeded, perform a moisture test on each piece to determine if a moisture shrinkage allowance should be applied. Apply the appropriate allowance to each piece, then re-calculate the average error and re-determine compliance with the MAV. If the average error is a minus value for any length measurement, or if the MAV is exceeded for any length measurement the lot fails. No moisture shrinkage allowance is applied to length. | | | | | | | | | | | | | | | | | |
| **Piece Number** | | **Moisture Content** | | | **Moisture Shrinkage Allowance** | | |  | | **Piece Number** | | **Moisture Content** | | | | **Moisture Shrinkage Allowance** | |
| 1. | |  | | |  | | |  | | 7. | |  | | | |  | |
| 2. | |  | | |  | | |  | | 8. | |  | | | |  | |
| 3. | |  | | |  | | |  | | 9. | |  | | | |  | |
| 4. | |  | | |  | | |  | | 10. | |  | | | |  | |
| 5. | |  | | |  | | |  | | 11. | |  | | | |  | |
| 6. | |  | | |  | | |  | | 12. | |  | | | |  | |
|  | | | | | | | | | | | | | | | | | |
| **Section 6. Action Taken:** □ Lot Rejected □ Lot Approved | | | | | | | | | | | | | | | | | |
| **Comments:** | | | | | | | | | **Official Name/Signature:** | | | | | | | | |
| **Date:** | | | | | | | | |
| **Random Numbers: Enter the numbers as you select them in the top row and reorder them in the bottom row.** | | | | | | | | | | | | | | | | | |
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| Softwood Lumber Worksheet | | | | | | | | | |
| **Product:** | | | | **Mill Number and Agency:** | | | | | |
| **Labeled Dimensions:** | | | | **Address:** | | | **City/State/Zip:** | | |
| **Length:** | | | |
| **Width:** | | | | **Brand/Grade/Surface:** | | | **Testing Location:** | | |
| **Thickness:** | | | |
|  | | | | | | | | | |
| **Piece Number** | **Average**  **Length** | **Average**  **Width** | **Average**  **Thickness** | |  | **Piece**  **Number** | **Average**  **Length** | **Average**  **Width** | **Average**  **Thickness** |
| 1. |  |  |  | | 7. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  |  |  |  | |  |  |  |  |
| 2. |  |  |  | | 8. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  |  |  |  | |  |  |  |  |
| 3. |  |  |  | | 9. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
| 4. |  |  |  | | 10. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  | | | | |  | | | |
| 5. |  |  |  | | 11. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  | | | | |  | | | |
| 6. |  |  |  | | 12. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  | | | | | | | | | |
| **Total Average:** |  |  |  | |  | | | | |
| **Average Error:** |  |  |  | |
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| Structural Plywood Sheets and Wood-Based Structural Panels Worksheet | | | | | | | | | | | | |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| MAV for Packages Labeled by Length, Width, or Area (Table 2-8)  (**Note:** Structural Plywood Sheets or Wood-Based Structural Panels of a predetermined dimension is considered a “package” as defined by NIST Handbook 130, “Uniform Packaging and Labeling Regulations).   * 1 m (1 yd) or less in 3 % of labeled quantity. * More than 1 m (1 yd) to 43 m (48 yd) is 1.5 % of labeled quantity. | | | | | | | | | | | | |
| **Section 1. Compliance with Maximum Allowable Variation**   1. Calculate the MAV for labeled thickness = \_\_\_\_\_\_\_. Do any of the minus errors for thickness exceed the MAV?   □ Yes, go to Section 5. □ No, go to Section 2   1. Calculate the MAV for length = \_\_\_\_\_\_\_\_\_\_\_\_\_\_. Do any of the minus errors for width exceed the MAV?   □ Yes, go to Section 5. □ No, go to Section 3   1. Calculate the MAV for labeled width = \_\_\_\_\_\_\_\_. Do any of the minus errors for length exceed the MAV?   □ Yes, go to Section 5. □ No, go to Section 4 | | | | | | | | | | | | |
| **Section 2. Compliance with the Average Requirement – Thickness**  4. Calculate the Average Error for labeled thickness \_\_\_\_\_\_\_. The sample passes this requirement if the Average Error is zero or a positive number. Go to Section 3. If the Average Error is a negative number, go to Step 5.  5. Calculate the Sample Standard Deviation (*s*) and multiply (*s*) by the Sample Correction Factor (*SCF*) for the sample size to obtain the Sample Error Limit (*SEL*). Go to Step 6.  *(s)\_\_\_\_\_\_\_\_\_\_\_\_\_\_ ×* (*SCF*)\_\_\_\_\_\_\_\_\_\_\_ = *SEL \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_*  6. Disregarding the signs, is the *SEL* in Step 5 larger than the Average Error in Step 4? If yes, the lot passes on thickness. If no, go to Section 3. | | | | | | | | | | | | |
| **Section 3. Compliance with the Average Requirement – Length**  7. Calculate the Average Error for labeled length\_\_\_\_\_\_\_. The sample passes this requirement if the Average Error is zero or a positive number. Go to Section 4. If the Average Error is a negative number, go to Step 8.  8. Calculate the Sample Standard Deviation (*s*) and multiply (*s*) by the Sample Correction Factor (*SCF*) for the sample size to obtain the Sample Error Limit (*SEL*). Go to Step 9.  *(s)\_\_\_\_\_\_\_\_\_\_\_\_\_\_ ×* (*SCF*)\_\_\_\_\_\_\_\_\_\_\_ = *SEL \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_*  9. Disregarding the signs, is the *SEL* in Step 8 larger than the Average Error in Step 7? If yes, the lot passes on length. If no, go to Section 4. | | | | | | | | | | | | |
| **Section 4. Compliance with the Average Requirement – Width**  10. Calculate the Average Error for labeled width \_\_\_\_\_\_\_. The sample passes this requirement if the Average Error is zero or a positive number. Go to Section 6. If the Average Error is a negative number, go to Step 11.  11. Calculate the Sample Standard Deviation (*s*) and multiply (*s*) by the Sample Correction Factor (*SCF*) for the sample size to obtain the Sample Error Limit (*SEL*). Go to Step 12.  *(s)\_\_\_\_\_\_\_\_\_\_\_\_\_\_ ×* (*SCF*)\_\_\_\_\_\_\_\_\_\_\_ = *SEL \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_*  12. Disregarding the signs, is the *SEL* in Step 11 larger than the Average Error in Step 10? If yes, approve the lot.  □ Yes, approve the lot. □ No, go to Section 5 | | | | | | | | | | | | |
|  | | | | | | | | | | | | |
| **Section 5. Determine Moisture Shrinkage Allowance**  If the average error for any dimension (thickness, length, width) is a minus value, or if the MAV is exceeded for any piece, perform a moisture test on each piece to determine if a shrinkage allowance should be applied. Apply the appropriate allowance to each piece, then re-calculate the average error and re-determine compliance with the MAV. | | | | | | | | | | | | |
| **Piece Number** | **Moisture Content** | | **Moisture Shrinkage Allowance** | |  | **Piece Number** | **Moisture Content** | | | **Moisture Shrinkage Allowance** | | |
| 1. |  | |  | |  | 7. |  | | |  | | |
| 2. |  | |  | |  | 8. |  | | |  | | |
| 3. |  | |  | |  | 9. |  | | |  | | |
| 4. |  | |  | |  | 10. |  | | |  | | |
| 5. |  | |  | |  | 11. |  | | |  | | |
| 6. |  | |  | |  | 12. |  | | |  | | |
|  | | | | | | | | | | | | |
| **Section 6. Action Taken:** □ Lot Rejected □ Lot Approved | | | | | | | | | | | | |
| Comments: | | | | | | Official Name/Signature: | | | | | | |
| Date: | | | | | | |
| **Random Numbers:** Enter the numbers as you select them in the top row and reorder them in the bottom row. | | | | | | | | | | | | |
|  |  |  |  |  |  |  |  |  |  | |  |  |
|  |  |  |  |  |  |  |  |  |  | |  |  |
| (Rev. 01/2020) | | | | | | | | | | | | |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Structural Plywood Sheets and Wood-Based Structural Panels Worksheet | | | | | | | | | |
| **Product:** | | | | **Mill Number and Agency:** | | | | | |
| **Labeled Dimensions:** | | | | **Address:** | | | **City/State/Zip:** | | |
| **Length:** | | | |
| **Width:** | | | | **Brand/Grade/Surface:** | | | **Testing Location:** | | |
| **Thickness:** | | | |
|  | | | | | | | | | |
| **Piece Number** | **Average**  **Length** | **Average**  **Width** | **Average**  **Thickness** | |  | **Piece**  **Number** | **Average**  **Length** | **Average**  **Width** | **Average**  **Thickness** |
| 1. |  |  |  | | 7. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  |  |  |  | |  |  |  |  |
| 2. |  |  |  | | 8. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  |  |  |  | |  |  |  |  |
| 3. |  |  |  | | 9. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
| 4. |  |  |  | | 10. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  | | | | |  | | | |
| 5. |  |  |  | | 11. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  | | | | |  | | | |
| 6. |  |  |  | | 12. |  |  |  |
| Error: |  |  |  | | Error: |  |  |  |
|  | | | | | | | | | |
| **Total Average:** |  |  |  | |  | | | | |
| **Average Error:** |  |  |  | |

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# Appendix D. AOSA Rules for Testing Seeds

AOSA Rules for Testing Seeds – Section 2: Preparation of Working Samples

**Volume 1. Principles and Procedures**

(Provided by the Association of Official Seed Analyst)

SECTION 2: PREPARATION OF WORKING SAMPLES

The laboratory analysis for law enforcement, labeling, and general information as to seed quality, should determine the following for the sample analyzed: (1) the purity composition, (2) the rate of occurrence of noxious-weed seeds per unit weight, and (3) the percentage germination of the pure seed under consideration. Additional information, such as, seed count, detection of seed treatment, bulk examination for contaminants, tetrazolium viability, detection of fungal endophtyes, and seed moisture content may be determined using approved procedures.

2.1 Definitions

1. **Seed unit:** the structure usually regarded as a seed in planting practices and in commercial channels. Refer to section 3.2 e for pure seed unit descriptions.
2. Working samples:
3. **Purity working sample:** the sub-sample taken from the submitted sample on which the purity analysis is performed.

**2.2 Obtaining the working sample**

The working sample on which the actual analysis is performed shall be taken from the submitted sample in such a manner that it will be representative. A suitable type of mechanical divider (conical, centrifugal, riffle, etc.) should be used. To avoid damage when dividing large-seeded crop kinds such as beans, peas, etc., prevent the seeds from falling great distances onto hard surfaces.

1. **Mechanical dividers. –** This method is suitable for most kinds of seeds. The apparatus divides a sample into two approximately equal parts. The submitted sample is mixed by passing it through the divider, recombining the two parts and passing the whole sample through a second time and similarly a third time. After mixing, the sample shall be reduced by passing the seed through the divider repeatedly, removing half the sample on each occasion. This process of successive halving is continued until a working sample of approximately, but not less than the minimum weight(s) stated in Table 2A is obtained.

Use of compressed air or a vacuum is highly recommended for cleaning mechanical dividers.

1. **Centrifugal divider (Gamet type):** This divider is suitable for all kinds of seed though it is not recommended for oilseeds (such as rapeseed, canola, mustards, flax) and kinds susceptible to damage (such as peas, soybeans, etc.) and the extremely chaffy types.

The divider makes use of centrifugal force to mix and scatter seeds over the dividing surface. The seed flows downward through a hopper onto a shallow rubber cup or spinner. Upon rotation of the spinner by an electric motor the seeds are thrown out by centrifugal force and fall downward. The circle or area where the seeds fall is equally divided into two parts by a stationary baffle so that approximately half the seeds fall in one spout and half in the other spout. The centrifugal divider tends to give variable results when not carefully operated, and therefore the following procedure must be used:

(a) Preparation of the apparatus:

(i) Level the divider using the adjustable feet.

(ii) Check the divider and four containers for cleanliness. Note that seeds can be trapped under the spinner and become a source of contamination.

(b) Sample mixing:

(i) Place a container under each spout.

(ii) Feed the whole sample into the hopper; when filling the hopper, the seed must always be poured centrally.

(iii) After the sample has been poured into the hopper, the spinner is operated and the seed passes into the two containers. Turn off spinner.

(iv) Full containers are replaced by empty containers. The contents of the two full containers are fed centrally into the hopper together, the seed being allowed to blend as it flows in. The spinner is operated.

(v) The sample mixing procedure is repeated at least once more.

(c) Sample reduction:

(i) Full containers are replaced by empty containers. The contents of one full container are set aside and the contents of the other container are fed into the hopper. The spinner is operated.

(ii) The successive halving process is continued until the working sample(s) of not less than the minimum weight(s) required stated in Table 2A are obtained.

(iii) Ensure that the divider and containers are clean after each mixing operation.

1. **Soil/Riffle divider:** This divider is suitable for most kinds of seed. For round-seeded kinds such as *Brassica* species, the collection containers should be covered to prevent the seeds from bouncing out.

This divider consists of a hopper with attached channels or ducts, a frame to hold the hopper, four collection containers and a pouring pan. Ducts or channels lead from the hopper to the collection containers, alternate ones leading to opposite sides. Riffle dividers are available in different sizes for different sizes of seed. The width and number of channels and spaces are important. The minimum width of the channels must be at least two times the largest diameter of the seed or any possible contaminants being mixed.

This apparatus, similar to the centrifugal divider, divides the sample into approximately equal parts.

(a) Preparation of the apparatus:

(i) Place the riffle divider on a firm, level clean surface. Ensure the divider is level.

(ii) Ensure that the divider and the four sample collection containers are clean. Check all channels, joints and seams of the divider and collection containers to ensure there are no seeds or other plant matter present before each use.

(iii) Two clean empty collection containers shall be placed under the channels to receive the mixed seed.

(b) Sample mixing:

(i) Pour the whole sample into the divider by running the seed backwards and forwards along the edge of the divider so that all the channels and spaces of the divider receive an equal amount of seed.

(ii) The two full containers shall be replaced with two clean empty containers.

(iii) The contents of one full container shall be poured into the divider by holding the long edge of the pan against the long edge of the riffle hopper and then rotating the bottom up so that the seeds pour across all channels at the same time, followed by the other full container using the same procedure.

(iv) This process of mixing the entire submitted sample shall be repeated at least one more time before successive halving begins.

(c) Sample reduction:

(i) The contents of one full container are set aside. Empty containers are placed under each channel, and the contents of the other container is poured into the hopper by holding the long edge of the pan against the long edge of the riffle hopper and then rotating the bottom up so that the seeds pour across all channels at the same time.

(ii) The successive halving process is continued until the working sample(s) of not less than the minimum weight(s) required stated in Table 2A are obtained.

(iii) Ensure that the divider and collection containers are clean after each mixing operation. Check all channels of the divider, the joints and seams.

**(3)** **Boerner divider:** This divider is suitable for most kinds of seed, including chaffy species, peas, beans, soybeans, etc.

This divider consists of a hopper, a cone, and a series of baffles which direct the seed into two spouts. The baffles are arranged in a circle at the top and form equal width alternate channels and spaces. The channels lead to one spout, the spaces to the other. The width and number of channels and spaces are important. Five channels and spaces should be regarded as a minimum. The more channels the better but the minimum width of the channels must be at least two times the largest diameter of the seed or any possible contaminants being mixed.

1. Preparation of the apparatus: Ensure that the divider and the two sample collecting pans are clean.

(b) Sample mixing:

(i) Place a collecting pan under each spout.

(ii) Close the valve at the bottom of the divider.

(iii) Pour the seed centrally into the hopper.

(iv) Quickly open the valve. Gravity will distribute the seed evenlythrough the channels and spaces.

(v) To mix the seed, repeatthe steps at least twice for free flowing seed and three times for chaffy grasses.

1. Sample reduction: The contents of one full collection pan are set aside. Repeat steps in 2 “sampling mixing”. To improve the randomness of reduction, choose collection pans from alternate sides for the successive halving process. The successive halving process is continued until the working sample(s) of not less than the minimum weight(s) required stated in Table 2A are obtained.
2. **Non-mechanical methods.**
3. **Hand-halving method:** This method can be used when a proper mechanical divider is not available.

Procedure:

(a) Seed is poured evenly onto a clean smooth surface.

(b) The sample shall be thoroughly mixed using a flat-edged spatula and placed into a pile.

(c) The pile shall be divided in half using a straight edge or ruler.

(d) Each half portion is divided in half.

(e) Each of the portions is divided into half again. There are now eight portions.

(f) Arrange the eight portions into two rows of four.

(g) Alternate portions should be combined to obtain two halves for example, combine the first portion from Row 1 with the second portion from Row 2. Remove the remaining four portions.

(h) Repeat Steps (a) to (g) until sufficient portions of seed are taken to constitute a working sample(s) of not less than the minimum weight(s) required stated in Table 2A are obtained.

2.3.  **Size of working samples.**

* 1. **Weighing the working sample. –** The weight of the working sample shall be determined to the number of decimal places indicated below:

|  |  |
| --- | --- |
| **Weight of Working Sample in Grams** | **Number of**  **Decimal Places** |
| Less than 1.000 | 4 |
| 1.000 to 9.999 | 3 |
| 10.00 to 99.99 | 2 |
| 100.0 to 999.9 | 1 |
| 1000 or more | 0 |

AOSA Rules for Testing Seeds – Section 12: Mechanical Seed Count

Volume 1. Principles and Procedures

(Provided by the Association of Official Seed Analyst)

SECTION 12: MECHANICAL SEED COUNT

The following method shall be employed when using a mechanical seed counter to determine the number of seeds contained in a sample of soybean (*Glycine max*), corn (*Zea mays*), wheat (*Triticum aestivum*) and field bean (*Phaseolus vulgaris*).

**12.1 Samples.**

Samples for testing shall be of at least 500 grams for soybean, corn and field beans and 100 grams for wheat and received in moisture proof containers. Samples shall be retained in moisture proof containers until the weight of the sample prepared for purity analysis is recorded.

**12.2 Seed counter calibration.**

The seed counter shall be calibrated daily prior to use.

(a) Prepare a calibration sample by counting 10 sets of 100 seeds. Visually examine each set to insure that it contains whole seeds. Combine the 10 sets of seeds to make a 1,000 seed calibration sample. The seeds of the calibration sample should be approximately the same size and shape as the seeds in a sample being tested. If the seeds in a sample being tested are noticeably different in size or shape from those in the calibration sample, prepare another calibration sample with seeds of the appropriate size and shape. Periodically re-examine the calibration samples to insure that no seeds have been lost or added.

(b) Carefully pour the 1,000 seed calibration sample into the seed counter. Start the counter and run it until all the seeds have been counted. The seeds should not touch as they run through the counter. Record the number of seeds as displayed on the counter read out. The seed count should not vary more than ±2 seeds from 1,000. If the count is not within this tolerance, clean the mirrors, adjust the feed rate and/or reading sensitivity. Rerun the calibration sample until it is within the ±2 seed tolerance. If the seed counter continues to fail the calibration procedure and the calibration sample has been checked to ensure that it contains 1,000 seeds, do not use the counter until it has been repaired.

**12.3 Sample preparation.**

Immediately after opening the moisture proof container, mix and divide the submitted sample, in accordance with Section 2.2, to obtain a sample for purity analysis and record the weight of this sample in grams to the appropriate number of decimal places (refer to Section 2.3 a). Conduct the purity analysis to obtain pure seed for the seed count test.

**12.4 Conducting the test.**

After the seed counter has been calibrated, test the pure seed portion from the purity test and record the number of seeds in the sample.

**12.5 Calculation of results.**

Calculate the number of seeds per pound to the nearest whole number using the following formula:

|  |  |
| --- | --- |
| *Number of seeds per pound =* | *453.6 g/lb × no. of seeds counted* |
| *weight (g) of sample analyzed for purity* |

**12.6 Tolerances for results from different laboratories.**

Multiply the labeled seed count or first seed count test result by four percent for soybean samples, two percent for corn (round, flat or plateless) samples, five percent for field bean samples and three percent for wheat samples. Express the tolerance (the number of seeds) to the nearest whole number. Consider the results of two tests in tolerance if the difference, expressed as the number of seeds, is equal to or less than the tolerance.

**Example:**

*Kind of seed: Corn*

*Label claim (1st test): 2275 seed/lb*

*Lab Test (2nd test): Purity working weight = 500.3 g*

*Seed count of pure seed = 2479 seeds*

|  |  |  |
| --- | --- | --- |
| *Number of seeds per pound =* | *453.6 g/lb × 2479 seeds* | *= 2247.6 seeds/lb* |
| *500.3 g* |

*Rounded to the nearest whole number = 2248 seeds/lb*

Calculate tolerance value for corn:

*multiply label claim by 2%*

*2275 seeds/lb × 0.02 = 45.5 seeds/lb;*

*rounded to the nearest whole number = 46 seeds/lb*

Determine the difference between label claim and lab test:

*2275 seeds/lb – 2248 seeds/lb = 27 seeds/lb*

The difference between the lab test (2nd test) and the label claim (1st test) is less than the tolerance (27 < 46); therefore, the two results are in tolerance.

# Appendix E. General Tables of Units of Measurement

These tables have been prepared for the benefit of those requiring tables of units for occasional ready reference. In Section 4. Tables of Units of Measurement of this Appendix, the tables are carried out to a large number of decimal places and exact values are indicated by underlining. In most of the other tables, only a limited number of decimal places are given, therefore making the tables better adapted to the average user.

Section 1. Tables of Metric Units of Measurement

In the metric system of measurement, designations of multiples and subdivisions of any unit may be arrived at by combining with the name of the unit the prefixes deka, hecto, and kilo meaning, respectively, 10, 100, and 1000, and deci, centi, and milli, meaning, respectively, one‑tenth, one‑hundredth, and one-thousandth. In some of the following metric tables, some such multiples and subdivisions have not been included for the reason that these have little, if any currency in actual usage.

In certain cases, particularly in scientific usage, it becomes convenient to provide for multiples larger than 1000 and for subdivisions smaller than one‑thousandth. Accordingly, the following prefixes have been introduced and these are now generally recognized:

yotta, (Y) meaning 1024 deci, (d), meaning 10‑1

zetta, (Z), meaning 1021 centi, (c), meaning 10‑2

exa, (E), meaning 1018 milli, (m), meaning 10‑3

peta, (P), meaning 1015 micro, (µ), meaning 10‑6

tera, (T), meaning 1012 nano, (n), meaning 10‑9

giga, (G), meaning 109 pico, (p), meaning 10‑12

mega, (M), meaning 106 femto, (f), meaning 10‑15

kilo, (k), meaning 103 atto, (a), meaning 10‑18

hecto, (h), meaning 102 zepto, (z), meaning 10‑21

deka, (da), meaning 101 yocto, (y), meaning 10‑24

Thus a kilometer is 1000 meters and a millimeter is 0.001 meter.

|  |  |
| --- | --- |
| Units of Length | |
|  |  |
| 10 millimeters (mm) | = 1 centimeter (cm) |
| 10 centimeters | = 1 decimeter (dm) = 100 millimeters |
| 10 decimeters | = 1 meter (m) = 1000 millimeters |
| 10 meters | = 1 dekameter (dam) |
| 10 dekameters | = 1 hectometer (hm) = 100 meters |
| 10 hectometers | = 1 kilometer (km) = 1000 meters |

|  |  |
| --- | --- |
| Units of Area | |
|  |  |
| 100 square millimeters (mm2) | = 1 square centimeter (cm2) |
| 100 square centimeters | = 1 square decimeter (dm2) |
| 100 square decimeters | = 1 square meter (m2) |
| 100 square meters | = 1 square dekameter (dam2) = 1 are |
| 100 square dekameters | = 1 square hectometer (hm2) = 1 hectare (ha) |
| 100 square hectometers | = 1 square kilometer (km2) |

|  |  |
| --- | --- |
| Units of Liquid Volume | |
|  |  |
| 10 milliliters (mL) | = 1 centiliter (cL) |
| 10 centiliters | = 1 deciliter (dL) = 100 milliliters |
| 10 deciliters | = 1 liter[[3]](#footnote-4) = 1000 milliliters |
| 10 liters | = 1 dekaliter (daL) |
| 10 dekaliters | = 1 hectoliter (hL) = 100 liters |
| 10 hectoliters | = 1 kiloliter (kL) = 1000 liters |

|  |  |
| --- | --- |
| Units of Volume | |
|  |  |
| 1000 cubic millimeters (mm3) | = 1 cubic centimeter (cm3) |
| 1000 cubic centimeters | = 1 cubic decimeter (dm3) |
|  | = 1 000 000 cubic millimeters |
| 1000 cubic decimeters1 | = 1 cubic meter (m3) |
|  | = 1 000 000 cubic centimeters |
|  | = 1 000 000 000 cubic millimeters |

| Units of Mass | |
| --- | --- |
|  |  |
| 10 milligrams (mg) | = 1 centigram (cg) |
| 10 centigrams | = 1 decigram (dg) = 100 milligrams |
| 10 decigrams | = 1 gram (g) = 1000 milligrams |
| 10 grams | = 1 dekagram (dag) |
| 10 dekagrams | = 1 hectogram (hg) = 100 grams |
| 10 hectograms | = 1 kilogram (kg) = 1000 grams |
| 1000 kilograms | = 1 megagram (Mg) or 1 metric ton(t) |

Section 2. Tables of U.S. Units of Measurement[[4]](#footnote-5)

In these tables where foot or mile is underlined, it is survey foot or U.S. statute mile rather than international foot or mile that is meant.

| Units of Length | |
| --- | --- |
|  |  |
| 12 inches (in) | = 1 foot (ft) |
| 3 feet | = 1 yard (yd) |
| 16½ feet | = 1 rod (rd), pole, or perch |
| 40 rods | = 1 furlong (fur) = 660 feet |
| 8 furlongs | = 1 U.S. statute mile (mi) = 5280 feet |
| 1852 meters (m) | = 6076.115 49 feet (approximately) |
|  | = 1 international nautical mile |

| Units of Area**[[5]](#footnote-6)** | |
| --- | --- |
|  |  |
| 144 square inches (in2) | = 1 square foot (ft2) |
| 9 square feet | = 1 square yard (yd2) |
|  | = 1296 square inches |
| 272¼ square feet | = 1 square rod (rd2) |
| 160 square rods | = 1 acre = 43 560 square feet |
| 640 acres | = 1 square mile (mi2) |
| 1 mile square | = 1 section of land |
| 6 miles square | = 1 township |
|  | = 36 sections = 36 square miles |

|  |  |
| --- | --- |
| Units of Volume3 | |
|  |  |
| 1728 cubic inches (in3) | = 1 cubic foot (ft3) |
| 27 cubic feet | = 1 cubic yard (yd3) |

|  |  |
| --- | --- |
| Gunter’s or Surveyors Chain Units of Measurement | |
|  |  |
| 0.66 foot (ft) | = 1 link (li) |
| 100 links | = 1 chain (ch) |
|  | = 4 rods = 66 feet |
| 80 chains | = 1 U.S. statute mile (mi) |
|  | = 320 rods = 5280 feet |

|  |  |
| --- | --- |
| Units of Liquid Volume**[[6]](#footnote-7)** | |
|  |  |
| 4 gills (gi) | = 1 pint (pt) = 28.875 cubic inches (in3) |
| 2 pints | = 1 quart (qt) = 57.75 cubic inches |
| 4 quarts | = 1 gallon (gal) = 231 cubic inches |
|  | = 8 pints = 32 gills |

| Apothecaries Units of Liquid Volume | |
| --- | --- |
|  |  |
| 60 minims | = 1 fluid dram (fl dr or ƒ Ӡ) |
|  | = 0.225 6 cubic inch (in3) |
| 8 fluid drams | = 1 fluid ounce (fl oz or ƒ ℥) |
|  | = 1.804 7 cubic inches |
| 16 fluid ounces | = 1 pint (pt) |
|  | = 28.875 cubic inches |
|  | = 128 fluid drams |
| 2 pints | = 1 quart (qt) = 57.75 cubic inches |
|  | = 32 fluid ounces = 256 fluid drams |
| 4 quarts | = 1 gallon (gal) = 231 cubic inches |
|  | = 128 fluid ounces = 1024 fluid drams |

|  |  |
| --- | --- |
| Units of Dry Volume**[[7]](#footnote-8)** | |
|  |  |
| 2 pints (pt) | = 1 quart (qt) = 67.200 6 cubic inches (in3) |
| 8 quarts | = 1 peck (pk) = 537.605 cubic inches |
|  | = 16 pints |
| 4 pecks | = 1 bushel (bu) = 2150.42 cubic inches |
|  | = 32 quarts |

| Avoirdupois Units of Mass[[8]](#footnote-9)  (The “grain” is the same in avoirdupois, troy, and apothecaries units of mass.) | |
| --- | --- |
| 1 µlb | = 0.000 001 pound (lb) |
| 2711/32 grains (gr) | = 1 dram (dr) |
| 16 drams | = 1 ounce (oz) |
|  | = 437½ grains |
| 16 ounces | = 1 pound (lb) |
|  | = 256 drams |
|  | = 7000 grains |
| 100 pounds | = 1 hundredweight (cwt)[[9]](#footnote-10) |
| 20 hundredweights | = 1 ton (tn)[[10]](#footnote-11) |
|  | = 2000 pounds7 |

|  |  |
| --- | --- |
| In “gross” or “long” measure, the following values are recognized: | |
| 112 pounds (lb) | = 1 gross (or long) hundredweight (cwt) 7 |
| 20 gross (or long) hundredweights | = 1 gross (or long) ton |
|  | = 2240 pounds7 |

|  |  |
| --- | --- |
| Troy Units of Mass  (The “grain” is the same in avoirdupois, troy, and apothecaries units of mass.) | |
| 24 grains (gr) | = 1 pennyweight (dwt) |
| 20 pennyweights | = 1 ounce troy (oz t) = 480 grains |
| 12 ounces troy | = 1 pound troy (lb t) |
|  | = 240 pennyweights = 5760 grains |

| Apothecaries Units of Mass  (The “grain” is the same in avoirdupois, troy, and apothecaries units of mass.) | |
| --- | --- |
| 20 grains (gr) | = 1 scruple (s ap or ℈) |
| 3 scruples | = 1 dram apothecaries (dr ap or Ӡ) |
|  | = 60 grains |
| 8 drams apothecaries | = 1 ounce apothecaries (oz ap or ℥) |
|  | = 24 scruples = 480 grains |
| 12 ounces apothecaries | = 1 pound apothecaries (lb ap) |
|  | = 96 drams apothecaries |
|  | = 288 scruples = 5760 grains |

Section 3. Notes on British Units of Measurement

In Great Britain, the yard, the avoirdupois pound, the troy pound, and the apothecaries pound are identical with the units of the same names used in the United States. The tables of British linear measure, troy mass, and apothecaries mass are the same as the corresponding United States tables, except for the British spelling “drachm” in the table of apothecaries mass. The table of British avoirdupois mass is the same as the United States table up to 1 pound; above that point the table reads:

|  |  |
| --- | --- |
| 14 pounds | = 1 stone |
| 2 stones | = 1 quarter = 28 pounds |
| 4 quarters | = 1 hundredweight = 112 pounds |
| 20 hundredweight | = 1 ton = 2240 pounds |

The present British gallon and bushel – known as the “Imperial gallon” and “Imperial bushel” – are, respectively, about 20 % and 3 % larger than the United States gallon and bushel. The Imperial gallon is defined as the volume of 10 avoirdupois pounds of water under specified conditions, and the Imperial bushel is defined as 8 Imperial gallons. Also, the subdivision of the Imperial gallon as presented in the table of British apothecaries fluid measure differs in two important respects from the corresponding United States subdivision, in that the Imperial gallon is divided into 160 fluid ounces (whereas the United States gallon is divided into 128 fluid ounces), and a “fluid scruple” is included. The full table of British measures of capacity (which are used alike for liquid and for dry commodities) is as follows:

|  |  |
| --- | --- |
| 4 gills | = 1 pint |
| 2 pints | = 1 quart |
| 4 quarts | = 1 gallon |
| 2 gallons | = 1 peck |
| 8 gallons (4 pecks) | = 1 bushel |
| 8 bushels | = 1 quarter |

The full table of British apothecaries measure is as follows:

|  |  |
| --- | --- |
| 20 minims | = 1 fluid scruple |
| 3 fluid scruples | = 1 fluid drachm |
|  | = 60 minims |
| 8 fluid drachms | = 1 fluid ounce |
| 20 fluid ounces | = 1 pint |
| 8 pints | = 1 gallon (160 fluid ounces) |

Section 4. Tables of Units of Measurement

Unit con-version is a multi-step process that involves multiplication or division by a numerical factor; selection of the correct number of significant digits; and rounding. Accurate unit conversions are obtained by selecting an appropriate conversion factor (a ratio which converts one unit of measure into another without changing the quantity), which are supplied in these tables.

Some unit conversions may be exact, without increasing or decreasing the precision of the original quantity. Exact unit conversion factors are underlined in these tables. It is good practice to keep all the digits, especially if other mathematical operations or conversions will follow. Rounding should be the last step of the conversion process and should be performed only once.

To convert a value from one unit of measurement to different unit of measurement follow the steps below.

* Find the table corresponding to the general category of measurement; for example, the table titled “Units of Volume” includes conversion factors for volume measurements.
* Locate the “starting unit” of measurement in the far, left column.
* Proceed horizontally to the right on the same row until you reach the column with the heading of the “ending unit” of measurement.
* The unit conversion factor is located at the intersection of the row and column.
* Multiply the quantity value of the starting unit of measurement by the conversion factor.
* The result is the equivalent quantity value in the ending unit of measurement.

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| Units of Length – International Measure[[11]](#footnote-12)  (All underlined figures are exact.) | | | | | | | | |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | | | |
| **Ending Unit →** | **Inches** | **Feet** | **Yards** | **Miles** | **Centimeters** | **Meters** |
| 1 inch = |  | 1 | 0.083 333 33 | 0.027 777 78 | 0.000 015 782 83 | 2.54 | 0.025 4 |
| 1 foot = |  | 12 | 1 | 0.333 333 3 | 0.000 189 393 9 | 30.48 | 0.304 8 |
| 1 yard = |  | 36 | 3 | 1 | 0.000 568 181 8 | 91.44 | 0.914 4 |
| 1 mile = |  | 63 360 | 5 280 | 1 760 | 1 | 160 934.4 | 1609.344 |
| 1 centimeter = |  | 0.393 700 8 | 0.032 808 40 | 0.010 936 13 | 0.000 006 213 712 | 1 | 0.01 |
| 1 meter = |  | 39.370 08 | 3.280 840 | 1.093 613 | 0.000 621 371 2 | 100 | 1 |

Units of Length – Thickness Measurement

(All underlined figures are exact.)

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | |
| **Ending Unit →** | **Inches** | **Millimeters** | **Micrometers** |
| 1 mil = |  | 0.001 | 0.0254 | 25.4 |
|  |  | **NOTE:** The unit “mil” is a unit traditionally used by industry for the measurement of thickness. | | |

Units of Length – Survey Measure**9**

(All underlined figures are exact.)

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| **Starting  Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | | | |
| **Ending Unit →** | **Links** | **Feet** | **Rods** | **Chains** | **Miles** | **Meters** |
| 1 link = |  | 1 | 0.66 | 0.04 | 0.01 | 0.000 125 | 0.201 168 4 |
| 1 foot = |  | 1.515 152 | 1 | 0.060 606 06 | 0.015 151 52 | 0.000 189 393 9 | 0.304 800 6 |
| 1 rod = |  | 25 | 16.5 | 1 | 0.25 | 0.003 125 | 5.029 210 |
| 1 chain = |  | 100 | 66 | 4 | 1 | 0.0125 | 20.116 84 |
| 1 mile = |  | 8 000 | 5 280 | 320 | 80 | 1 | 1609.347 |
| 1 meter = |  | 4.970 960 | 3.280 833 | 0.198 838 4 | 0.049 709 60 | 0.000 621 369 9 | 1 |

Units of Area – International Measure[[12]](#footnote-13)

(All underlined figures are exact.)

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | |
| **Ending Unit →** | **Square Inches** | **Square Feet** | **Square Yards** |
| 1 square inch = |  | 1 | 0.006 944 444 | 0.000 771 604 9 |
| 1 square foot = |  | 144 | 1 | 0.111 111 1 |
| 1 square yard = |  | 1 296 | 9 | 1 |
| 1 square mile = |  | 4 014 489 600 | 27 878 400 | 3 097 600 |
| 1 square centimeter = |  | 0.155 000 3 | 0.001 076 391 | 0.000 119 599 0 |
| 1 square meter = |  | 1550.003 | 10.763 91 | 1.195 990 |
|  | **Note**: 1 survey foot = 1200/3937 meter (exactly)  1 international foot = 12 × 0.0254 meter (exactly)  1 international foot = 0.0254 × 39.37 survey foot (exactly) | | | |

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | |
| **Ending Unit →** | **Square Miles** | **Square Centimeters** | **Square Meters** |
| 1 square inch = |  | 0.000 000 000 249 097 7 | 6.451 6 | 0.000 645 16 |
| 1 square foot = |  | 0.000 000 035 870 06 | 929.030 4 | 0.092 903 04 |
| 1 square yard = |  | 0.000 000 322 830 6 | 8361.273 6 | 0.836 127 36 |
| 1 square mile = |  | 1 | 25 899 881 103.36 | 2 589 988.110 336 |
| 1 square centimeter = |  | 0.000 000 000 038 610 22 | 1 | 0.0001 |
| 1 square meter = |  | 0.000 000 386 102 2 | 10 000 | 1 |

Units of Area – Survey Measure**10, 12**

(All underlined figures are exact.)

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | |
| **Ending Unit →** | **Square Feet** | **Square Rods** | **Square Chains** | **Acres** |
| 1 square foot = |  | 1 | 0.003 673 095 | 0.000 229 568 4 | 0.000 022 956 84 |
| 1 square rod = |  | 272.25 | 1 | 0.062 5 | 0.006 25 |
| 1 square chain = |  | 4 356 | 16 | 1 | 0.1 |
| 1 acre = |  | 43 560 | 160 | 10 | 1 |
| 1 square mile = |  | 27 878 400 | 102 400 | 6 400 | 640 |
| 1 square meter = |  | 10.763 87 | 0.039 536 70 | 0.002 471 044 | 0.000 247 104 4 |
| 1 hectare = |  | 107 638.7 | 395.367 0 | 24.710 44 | 2.471 044 |

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | |
| **Ending Unit →** | **Square Miles** | **Square Meters** | **Hectares** |
| 1 square foot = |  | 0.000 000 035 870 06 | 0.092 903 41 | 0.000 009 290 341 |
| 1 square rod = |  | 0.000 009 765 625 | 25.292 95 | 0.002 529 295 |
| 1 square chain = |  | 0.000 156 25 | 404.687 3 | 0.040 468 73 |
| 1 acre = |  | 0.001 562 5 | 4 046.873 | 0.404 687 3 |
| 1 square mile = |  | 1 | 2 589 998 | 258.999 8 |
| 1 square meter = |  | 0.000 000 386 100 6 | 1 | 0.000 1 |
| 1 hectare = |  | 0.003 861 006 | 10 000 | 1 |

Units of Volume

(all underlined figures are exact)

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | |
| **Ending Unit →** | **Cubic Inches** | **Cubic Feet** | **Cubic Yards** |
| 1 cubic inch = |  | 1 | 0.000 578 703 7 | 0.000 021 433 47 |
| 1 cubic foot = |  | 1 728 | 1 | 0.037 037 04 |
| 1 cubic yard = |  | 46 656 | 27 | 1 |
| 1 cubic centimeter = |  | 0.061 023 74 | 0.000 035 314 67 | 0.000 001 307 951 |
| 1 cubic decimeter = |  | 61.023 74 | 0.035 314 67 | 0.001 307 951 |
| 1 cubic meter = |  | 61 023.74 | 35.314 67 | 1.307 951 |

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | |
| **Ending Unit →** | **Milliliters**  **(Cubic Centimeters)** | **Liters**  **(Cubic Decimeters)** | **Cubic Meters** |
| 1 cubic inch = |  | 16.387 064 | 0.016 387 064 | 0.000 016 387 064 |
| 1 cubic foot = |  | 28 316.846 592 | 28.316 846 592 | 0.028 316 846 592 |
| 1 cubic yard = |  | 764 554.857 984 | 764.554 857 984 | 0.764 554 857 984 |
| 1 cubic centimeter = |  | 1 | 0.001 | 0.000 001 |
| 1 cubic decimeter = |  | 1 000 | 1 | 0.001 |
| 1 cubic meter = |  | 1 000 000 | 1000 | 1 |

Units of Capacity or Volume – Dry Volume Measure

(All underlined figures are exact.)

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | |
| **Ending Unit →** | **Dry Pints** | **Dry Quarts** | **Pecks** | **Bushels** |
| 1 dry pint = |  | 1 | 0.5 | 0.062 5 | 0.015 625 |
| 1 dry quart = |  | 2 | 1 | 0.125 | 0.031 25 |
| 1 peck = |  | 16 | 8 | 1 | 0.25 |
| 1 bushel = |  | 64 | 32 | 4 | 1 |
| 1 cubic inch = |  | 0.029 761 6 | 0.014 880 8 | 0.001 860 10 | 0.000 465 025 |
| 1 cubic foot = |  | 51.428 09 | 25.714 05 | 3.214 256 | 0.803 563 95 |
| 1 liter = |  | 1.816 166 | 0.908 083 0 | 0.113 510 4 | 0.028 377 59 |
| 1 cubic meter = |  | 1 816.166 | 908.083 0 | 113.510 4 | 28.377 59 |

| **Starting  Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | |
| --- | --- | --- | --- | --- | --- |
| **Ending Unit →** | **Cubic Inches** | **Cubic Feet** | **Liters** | **Cubic Meters** |
| 1 dry pint = |  | 1.12 | 0.019 444 63 | 0.550 610 5 | 0.000 550 610 5 |
| 1 dry quart = |  | 67.200 625 | 0.038 889 25 | 1.101 221 | 0.001 101 221 |
| 1 peck = |  | 537.605 | 0.311 114 | 8.809 768 | 0.008 809 768 |
| 1 bushel = |  | 2 150.42 | 1.244 456 | 35.239 070 166 88 | 0.035 239 070 166 88 |
| 1 cubic inch = |  | 1 | 0.000 578 703 7 | 0.016 387 064 | 0.000 016 387 064 |
| 1 cubic foot = |  | 1728 | 1 | 28.316 846 592 | 0.028 316 846 592 |
| 1 liter = |  | 61.023 74 | 0.035 314 67 | 1 | 0.001 |
| 1 cubic meter = |  | 61 023.74 | 35.314 67 | 1000 | 1 |

Units of Capacity or Volume – Liquid Volume Measure

(All underlined figures are exact.)

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | |
| **Ending Unit →** | **Minims** | **Fluid Drams** | **Fluid Ounces** | **Gills** |
| 1 minim = |  | 1 | 0.016 666 67 | 0.002 083 333 | 0.000 520 833 3 |
| 1 fluid dram = |  | 60 | 1 | 0.125 | 0.031 25 |
| 1 fluid ounce = |  | 480 | 8 | 1 | 0.25 |
| 1 gill = |  | 1 920 | 32 | 4 | 1 |
| 1 liquid pint = |  | 7 680 | 128 | 16 | 4 |
| 1 liquid quart = |  | 15 360 | 256 | 32 | 8 |
| 1 gallon = |  | 61 440 | 1024 | 128 | 32 |
| 1 cubic inch = |  | 265.974 0 | 4.432 900 | 0.554 112 6 | 0.138 528 1 |
| 1 cubic foot = |  | 459 603.1 | 7660.052 | 957.506 5 | 239.376 6 |
| 1 milliliter = |  | 16.230 73 | 0.270 512 2 | 0.033 814 02 | 0.008 453 506 |
| 1 liter = |  | 16 230.73 | 270.512 2 | 33.814 02 | 8.453 506 |

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | |
| **Ending Unit →** | **Liquid Pints** | **Liquid Quarts** | **Gallons** | **Cubic Inches** |
| 1 minim = |  | 0.000 130 208 3 | 0.000 065 104 17 | 0.000 016 276 04 | 0.003 759 766 |
| 1 fluid dram = |  | 0.007 812 5 | 0.003 906 25 | 0.000 976 562 5 | 0.225 585 94 |
| 1 fluid ounce = |  | 0.062 5 | 0.031 25 | 0.007 812 5 | 1.804 687 5 |
| 1 gill = |  | 0.25 | 0.125 | 0.031 25 | 7.218 75 |
| 1 liquid pint = |  | 1 | 0.5 | 0.125 | 28.875 |
| 1 liquid quart = |  | 2 | 1 | 0.25 | 57.75 |
| 1 gallon = |  | 8 | 4 | 1 | 231 |
| 1 cubic inch = |  | 0.034 632 03 | 0.017 316 02 | 0.004 329 004 | 1 |
| 1 cubic foot = |  | 59.844 16 | 29.922 08 | 7.480 519 | 1 728 |
| 1 milliliter = |  | 0.002 113 376 | 0.001 056 688 | 0.000 264 172 1 | 0.061 023 74 |
| 1 liter = |  | 2.113 376 | 1.056 688 | 0.264 172 1 | 61.023 74 |

`

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | |
| **Ending Unit →** | **Cubic Feet** | **Milliliters** | **Liters** |
| 1 minim = |  | 0.000 002 175 790 | 0.061 611 52 | 0.000 061 611 52 |
| 1 fluid dram = |  | 0.000 130 547 4 | 3.696 691 | 0.003 696 691 |
| 1 fluid ounce = |  | 0.001 044 379 | 29.573 53 | 0.029 573 53 |
| 1 gill = |  | 0.004 177 517 | 118.294 1 | 0.118 294 1 |
| 1 liquid pint = |  | 0.016 710 07 | 473.176 5 | 0.473 176 5 |
| 1 liquid quart = |  | 0.033 420 14 | 946.352 9 | 0.946 352 9 |
| 1 gallon = |  | 0.133 680 6 | 3785.411 784 | 3.785 411 784 |
| 1 cubic inch = |  | 0.000 578 703 7 | 16.387 06 | 0.016 387 06 |
| 1 cubic foot = |  | 1 | 28 316.85 | 28.316 85 |
| 1 milliliter = |  | 0.000 035 314 67 | 1 | 0.001 |
| 1 liter = |  | 0.035 314 67 | 1 000 | 1 |

Units of Mass Not Less Than Avoirdupois Ounces

(All underlined figures are exact.)

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | |
| **Ending Unit →** | **Avoirdupois**  **Ounces** | **Avoirdupois**  **Pounds** | **Short Hundred-weights** | **Short Tons** |
| 1 avoirdupois ounce = |  | 1 | 0.0625 | 0.000 625 | 0.000 031 25 |
| 1 avoirdupois pound = |  | 16 | 1 | 0.01 | 0.000 5 |
| 1 short  hundredweight = |  | 1 600 | 100 | 1 | 0.05 |
| 1 short ton = |  | 32 000 | 2 000 | 20 | 1 |
| 1 long ton = |  | 35 840 | 2 240 | 22.4 | 1.12 |
| 1 kilogram = |  | 35.273 96 | 2.204 623 | 0.022 046 23 | 0.001 102 311 |
| 1 metric ton = |  | 35 273.96 | 2204.623 | 22.046 23 | 1.102 311 |

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | |
| **Ending Unit →** | **Long Tons** | **Kilograms** | **Metric Tons** |
| 1 avoirdupois ounce = |  | 0.000 027 901 79 | 0.028 349 523 125 | 0.000 028 349 523 125 |
| 1 avoirdupois pound = |  | 0.000 446 428 6 | 0.453 592 37 | 0.000 453 592 37 |
| 1 short hundredweight = |  | 0.044 642 86 | 45.359 237 | 0.045 359 237 |
| 1 short ton = |  | 0.892 857 1 | 907.184 74 | 0.907 184 74 |
| 1 long ton = |  | 1 | 1016.046 908 8 | 1.016 046 908 8 |
| 1 kilogram = |  | 0.000 984 206 5 | 1 | 0.001 |
| 1 metric ton = |  | 0.984 206 5 | 1 000 | 1 |

Units of Mass Not Greater Than Pounds and Kilograms

(All underlined figures are exact.)

|  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- |
| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | |
| **Ending Unit →** | **Grains** | **Apothecaries Scruples** | **Pennyweights** | **Avoirdupois Drams** |
| 1 grain = |  | 1 | 0.05 | 0.041 666 67 | 0.036 571 43 |
| 1 apoth. scruple = |  | 20 | 1 | 0.833 333 3 | 0.731 428 6 |
| 1 pennyweight = |  | 24 | 1.2 | 1 | 0.877 714 3 |
| 1 avdp. dram = |  | 27.343 75 | 1.367 187 5 | 1.139 323 | 1 |
| 1 apoth. dram = |  | 60 | 3 | 2.5 | 2.194 286 |
| 1 avdp. ounce = |  | 437.5 | 21.875 | 18.229 17 | 16 |
| 1 apoth. or troy oz. = |  | 480 | 24 | 20 | 17.554 29 |
| 1 apoth. or troy pound = |  | 5 760 | 288 | 240 | 210.651 4 |
| 1 avdp. pound = |  | 7 000 | 350 | 291.666 7 | 256 |
| 1 milligram = |  | 0.015 432 36 | 0.000 771 617 9 | 0.000 643 014 9 | 0.000 564 383 4 |
| 1 gram = |  | 15.432 36 | 0.771 617 9 | 0.643 014 9 | 0.564 383 4 |
| 1 kilogram = |  | 15432.36 | 771.617 9 | 643.014 9 | 564.383 4 |

| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | |
| --- | --- | --- | --- | --- | --- |
| **Ending Unit →** | **Apothecaries Drams** | **Avoirdupois Ounces** | **Apothecaries or Troy Ounces** | **Apothecaries or Troy Pounds** |
| 1 grain = |  | 0.016 666 67 | 0.002 285 714 | 0.002 083 333 | 0.000 173 611 1 |
| 1 apoth. scruple = |  | 0.333 333 3 | 0.045 714 29 | 0.041 666 67 | 0.003 472 222 |
| 1 pennyweight = |  | 0.4 | 0.054 857 14 | 0.05 | 0.004 166 667 |
| 1 avdp. dram = |  | 0.455 729 2 | 0.062 5 | 0.56 966 15 | 0.004 747 179 |
| 1 apoth. dram = |  | 1 | 0.137 142 9 | 0.125 | 0.010 416 67 |
| 1 avdp. ounce = |  | 7.291 667 | 1 | 0.911 458 3 | 0.075 954 86 |
| 1 apoth. or troy ounce = |  | 8 | 1.097 143 | 1 | 0.083 333 333 |
| 1 apoth. or troy pound = |  | 96 | 13.165 71 | 12 | 1 |
| 1 avdp. pound = |  | 116.666 7 | 16 | 14.583 33 | 1.215 278 |
| 1 milligram = |  | 0.000 257 206 0 | 0.000 035 273 96 | 0.000 032 150 75 | 0.000 002 679 229 |
| 1 gram = |  | 0.257 206 0 | 0.035 273 96 | 0.032 150 75 | 0.002 679 229 |
| 1 kilogram = |  | 257.206 0 | 35.273 96 | 32.150 75 | 2.679 229 |

| **Starting Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | | |
| --- | --- | --- | --- | --- | --- | --- |
| **Ending Unit →** | **Avoirdupois Pounds** | **Milligrams** | **Grams** | **Kilograms** |
| 1 grain = |  | 0.000 142 857 1 | 64.798 91 | 0.064 798 91 | 0.000 064 798 91 |
| 1 apoth. scruple = |  | 0.002 857 143 | 1 295.978 2 | 1.295 978 2 | 0.001 295 978 2 |
| 1 pennyweight = |  | 0.003 428 571 | 1 555.173 84 | 1.555 173 84 | 0.001 555 173 84 |
| 1 avdp. dram = |  | 0.003 906 25 | 1 771.845 195 312 5 | 1.771 845 195 312 5 | 0.001 771 845 195 312 5 |
| 1 apoth. dram = |  | 0.008 571 429 | 3 887.934 6 | 3.887 934 6 | 0.003 887 934 6 |
| 1 avdp. ounce = |  | 0.062 5 | 28 349.523 125 | 28.349 523 125 | 0.028 349 523 125 |
| 1 apoth. or troy ounce = |  | 0.068 571 43 | 31 103.476 8 | 31.103 476 8 | 0.031 103 476 8 |
| 1 apoth. or troy pound = |  | 0.822 857 1 | 373 241.721 6 | 373.241 721 6 | 0.373 241 721 6 |
| 1 avdp. pound = |  | 1 | 453 592.37 | 453.592 37 | 0.453 592 37 |
| 1 milligram = |  | 0.000 002 204 623 | 1 | 0.001 | 0.000 001 |
| 1 gram = |  | 0.002 204 623 | 1 000 | 1 | 0.001 |
| 1 kilogram = |  | 2.204 623 | 1 000 000 | 1 000 | 1 |

Units of Pressure

(All underlined figures are exact.)

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| **Starting  Unit**  **←** | **Multiply by the Conversion Factor Below the Ending Unit:** | | | | | | |
| **Ending Unit →** | **Pascal  (Pa)** | **kilopascal  (kPa)** | **megapascal  (MPa)** | **pound-force per square inch (psi) (lbf/in2)** | **millimeter of mercury (mm Hg (0 °C))** | **Inch of water (in H2O (4 °C))** |
| 1 Pa = |  | 1 | 0.001 | 0.000 001 | 0.000 145 037 74 | 0.007 5006 15 | 0.004 014 742 13 |
| 1 kPa = |  | 1000.0 | 1 | 0.001 | 0.145 037 744 | 7.500 615 05 | 4.014 742 133 |
| 1 MPa = |  | 1 000 000 | 1 000 | 1 | 145.037 744 | 7 500.615 05 | 4 014.742 13 |
| 1 psi (lbf/in2) = |  | 6 894.757 | 6.894 757 | 0.006 894 757 | 1 | 51.714 918 1 | 27.680 671 4 |
| 1 mmHg (0 °C) = |  | 133.322 4 | 0.133 322 4 | 0.000 133 322 4 | 0.019 336 78 | 1 | 0.535 255 057 |
| 1 inH2O (4 °C)  = |  | 249.082 | 0.249 082 | 0.000 249 082 | 0.036 126 291 | 1.868 268 198 | 1 |

Conversion Equations for Units of Temperature

(Exact)

|  |  |  |  |
| --- | --- | --- | --- |
| **Units** | **To Fahrenheit** | **To Celsius** | **To Kelvin** |
| Fahrenheit |  |  |  |
| Celsius |  |  |  |
| Kelvin |  |  |  |

**Instructions for the Conversion Equations for Temperature:**

Start at the left column of the table until you reach the row labeled with the starting unit. Then proceed horizontally to the right along that row until you reach the column of the desired unit. The unit conversion factor is located at the intersection of the row and column.

Section 5. Tables of Equivalents

In these tables it is necessary to differentiate between the “international foot” and the “survey foot.” Therefore, the survey foot is underlined. (see notice regarding survey foot on page 221)

When the name of a unit is enclosed in brackets (thus, [1 hand] . . . ), this indicates (1) that the unit is not in general current use in the United States, or (2) that the unit is believed to be based on “custom and usage” rather than on formal authoritative definition.

Equivalents involving decimals are, in most instances, rounded off to the third decimal place except where they are exact, in which cases these exact equivalents are so designated. The equivalents of the imprecise units “tablespoon” and “teaspoon” are rounded to the nearest milliliter.

| Units of Length | |
| --- | --- |
| angstrom ()[[13]](#footnote-14) | 0.1 nanometer (exactly)  0.000 1 micrometer (exactly)  0.000 000 1 millimeter (exactly)  0.000 000 004 inch |
| 1 cable’s length | 120 fathoms (exactly)  720 feet (exactly)  219 meters |
| 1 centimeter (cm) | 0.393 7 inch |
| 1 chain (ch)  (Gunter’s or surveyors) | 66 feet (exactly)  20.116 8 meters |
| 1 decimeter (dm) | 3.937 inches |
| 1 dekameter (dam) | 32.808 feet |
| 1 fathom | 6 feet (exactly)  1.828 8 meters |
| 1 foot (ft) | 0.304 8 meter (exactly) |
| 1 furlong (fur) | 10 chains (surveyors) (exactly)  660 feet (exactly)  1/8 U.S. statute mile (exactly)  201.168 meters |
| [1 hand] | 4 inches |
| 1 inch (in) | 2.54 centimeters (exactly) |
| 1 kilometer (km) | 0.621 mile |
| 1 league (land) | 3 U.S. statute miles (exactly)  4.828 kilometers |
| 1 link (li) (Gunter’s or surveyors) | 0.66 foot (exactly)  0.201 168 meter |
| 1 meter (m) | 39.37 inches  1.094 yards |
| 1 micrometer | 0.001 millimeter (exactly)  0.000 039 37 inch |
| 1 mil | 0.001 inch (exactly)  0.025 4 millimeter (exactly)  25.4 micrometers (exactly) |
| 1 mile (mi) (U.S. statute)[[14]](#footnote-15) | 5280 feet survey (exactly)  1.609 kilometers |
| 1 mile (mi) (international) | 5280 feet international (exactly) |
| 1 mile (mi) (international nautical)[[15]](#footnote-16) | 1.852 kilometers (exactly)  1.151 survey miles |
| 1 millimeter (mm) | 0.039 37 inch  0.001 meter (exactly) |
| 1 nanometer (nm) | 0.000 000 039 37 inch |
| 1 point (typography) | 0.013 837 inch (exactly)  1/72 inch (approximately)  0.351 millimeter |
| 1 rod (rd), pole, or perch | 16½ feet (exactly)  5.029 2 meters |
| 1 yard (yd) | 0.914 4 meter (exactly) |

| Units of Area | |
| --- | --- |
| 1 acre[[16]](#footnote-17) | 43 560 square feet (exactly)  0.405 hectare |
| 1 are | 119.599 square yards  0.025 acre |
| 1 hectare | 2.471 acres |
| [1 square (building)] | 100 square feet |
| 1 square centimeter (cm2) | 0.155 square inch |
| 1 square decimeter (dm2) | 15.500 square inches |
| 1 square foot (ft2) | 929.030 square centimeters |
| 1 square inch (in2) | 6.451 6 square centimeters (exactly) |
| 1 square kilometer (km2) | 247.104 acres  0.386 square mile |
| 1 square meter (m2) | 1.196 square yards  10.764 square feet |
| 1 square mile (mi2) | 258.999 hectares |
| 1 square millimeter (mm2) | 0.002 square inch |
| 1 square rod (rd2), sq pole, or sq perch | 25.293 square meters |
| 1 square yard (yd2) | 0.836 square meter |

| Units of Capacity or Volume | |
| --- | --- |
| 1 barrel (bbl), liquid | 31 to 42 gallons[[17]](#footnote-18) |
| 1 barrel (bbl), standard for fruits,  vegetables, and other dry  commodities, except cranberries | 7056 cubic inches  105 dry quarts  3.281 bushels, struck measure |
| 1 barrel (bbl), standard, cranberry | 5826 cubic inches  8645/64 dry quarts  2.709 bushels, struck measure |
| 1 bushel (bu) (U.S.) struck measure | 2150.42 cubic inches (exactly)  35.238 liters |
| [1 bushel, heaped (U.S.)] | 2747.715 cubic inches  1.278 bushels, struck measure[[18]](#footnote-19) |
| [1 bushel (bu) (British Imperial)  (struck measure)] | 1.032 U.S. bushels, struck measure  2219.36 cubic inches |
| 1 cord (cd) (firewood) | 128 cubic feet (exactly) |
| 1 cubic centimeter (cm3) | 0.061 cubic inch |
| 1 cubic decimeter (dm3) | 61.024 cubic inches |
| 1 cubic foot (ft3) | 7.481 gallons  28.316 cubic decimeters |
| 1 cubic inch (in3) | 0.554 fluid ounce  4.433 fluid drams  16.387 cubic centimeters |
| 1 cubic meter (m3) | 1.308 cubic yards |
| 1 cubic yard (yd3) | 0.765 cubic meter |
| 1 cup, measuring | 8 fluid ounces (exactly)  237 milliliters  ½ liquid pint (exactly) |
| 1 dekaliter (daL) | 2.642 gallons  1.135 pecks |
| 1 dram, fluid (or liquid) (fl dr)  (or ƒ Ӡ) (U.S.) | 1/8 fluid ounce (exactly)  0.226 cubic inch  3.697 milliliters  1.041 British fluid drachms |
| [1 drachm, fluid (fl dr) (British)] | 0.961 U.S. fluid dram  0.217 cubic inch  3.552 milliliters |
| 1 gallon (gal) (U.S.) | 231 cubic inches (exactly)  3.785 liters  0.833 British gallon  128 U.S. fluid ounces (exactly) |
| [1 gallon (gal) (British Imperial)] | 277.42 cubic inches  1.201 U.S. gallons  4.546 liters  160 British fluid ounces (exactly) |
| 1 gill (gi) | 7.219 cubic inches  4 fluid ounces (exactly)  0.118 liter |
| 1 hectoliter (hL) | 26.418 gallons  2.838 bushels |
| 1 liter (1 cubic decimeter exactly) | 1.057 liquid quarts  0.908 dry quart  61.024 cubic inches |
| 1 milliliter (mL) | 0.271 fluid dram  16.231 minims  0.061 cubic inch |
| 1 ounce, fluid (or liquid) (fl oz)  (or ƒ ℥) (U.S.) | 1.805 cubic inches  29.573 milliliters  1.041 British fluid ounces |
| [1 ounce, fluid (fl oz) (British)] | 0.961 U.S. fluid ounce  1.734 cubic inches  28.412 milliliters |
| 1 peck (pk) | 8.810 liters |
| 1 pint (pt), dry | 33.600 cubic inches  0.551 liter |
| 1 pint (pt), liquid | 28.875 cubic inches (exactly)  0.473 liter |
| 1 quart (qt), dry (U.S.) | 67.201 cubic inches  1.101 liters  0.969 British quart |
| 1 quart (qt), liquid (U.S.) | 57.75 cubic inches (exactly)  0.946 liter  0.833 British quart |
| [1 quart (qt) (British)] | 69.354 cubic inches  1.032 U.S. dry quarts  1.201 U.S. liquid quarts |
| 1 tablespoon, measuring | 3 teaspoons (exactly)  15 milliliters  4 fluid drams  ½ fluid ounce (exactly) |
| 1 teaspoon, measuring | ⅓ tablespoon (exactly)  5 milliliters  1⅓ fluid drams[[19]](#footnote-20) |
| 1 water ton (English) | 270.91 U.S. gallons  224 British Imperial gallons (exactly) |

| Units of Mass | |
| --- | --- |
| 1 assay ton[[20]](#footnote-21) (AT) | 29.167 grams |
| 1 carat (c) | 200 milligrams (exactly)  3.086 grains |
| 1 dram apothecaries (dr ap or Ӡ) | 60 grains (exactly)  3.888 grams |
| 1 dram avoirdupois (dr avdp) | 2711/32 (= 27.344) grains  1.772 grams |
| 1 gamma (γ) | 1 microgram (exactly) |
| 1 grain | 64.798 91 milligrams (exactly) |
| 1 gram (g) | 15.432 grains  0.035 ounce, avoirdupois |
| 1 hundredweight, gross or long[[21]](#footnote-22)  (gross cwt) | 112 pounds (exactly)  50.802 kilograms |
| 1 hundredweight, gross or short  (cwt or net cwt) | 100 pounds (exactly)  45.359 kilograms |
| 1 kilogram (kg) | 2.205 pounds |
| 1 microgram (µg) [the Greek letter mu  in combination with the letter g] | 0.000 001 gram (exactly) |
| 1 milligram (mg) | 0.015 grain |
| 1 ounce, avoirdupois (oz avdp) | 437.5 grains (exactly)  0.911 troy or apothecaries ounce  28.350 grams |
| 1 ounce, troy or apothecaries  (oz t or oz ap or ℥) | 480 grains (exactly)  1.097 avoirdupois ounces  31.103 grams |
| 1 pennyweight (dwt) | 1.555 grams |
| 1 point | 0.01 carat  2 milligrams |
| 1 pound, avoirdupois (lb avdp) | 7000 grains (exactly)  1.215 troy or apothecaries pounds  453.592 37 grams (exactly) |
| 1 pound, troy or apothecaries  (lb t or lb ap) | 5760 grains (exactly)  0.823 avoirdupois pound  373.242 grams |
| 1 scruple (s ap or ℈) | 20 grains (exactly)  1.296 grams |
| 1 ton, gross or long[[22]](#footnote-23) | 2240 pounds (exactly)  1.12 net tons (exactly)  1.016 metric tons |
| 1 ton, metric (t) | 2204.623 pounds  0.984 gross ton  1.102 net tons |
| 1 ton, net or short (tn)[[23]](#footnote-24) | 2000 pounds (exactly)  0.893 gross ton  0.907 metric ton |

# Appendix F. Glossary

**A**

**allowable difference.** The amount, by which the actual quantity in the package may differ from the declared quantity. Pressed and blown tumblers and stemware labeled by count and capacity are assigned an allowable difference in capacity. This is also called a tolerance.

**audit testing.** Preliminary tests designed to quickly identify potential noncompliance units.

**average.** The sum of a number of individual measurement values divided by the number of values. For example, the sum of the individual weights of 12 packages divided by 12 would be the average weight of those packages.

**average error.** The sum of the individual “package errors” (defined) (considering their arithmetic sign) divided by the number of packages comprising the sample.

**average requirement.** A requirement that the average net quantity of contents of packages in a “lot” equals the net quantity of contents printed on the label.

**average tare.** The sum of the weights of individual package containers (or wrappers, etc.) divided by the number of containers or wrappers weighed.

**B**

**berry baskets and boxes.** Disposable containers in capacities of 1 dry quart or less for berries and small fruits. See Section 4.46. in NIST Handbook 44.

**C**

**Category A (Category B).** A set of sampling plans provided in this handbook to use in checking packages that must (except when exempted) meet the “average requirement” (defined).

**chamois.**  A natural leather made from skins of sheep and lambs that have been oil-tanned.

**combination quantity declarations.** A package label that contains the count of items in the package as well as one or more of the following: weight, measure, or size.

**compliance testing.** Determining package conformance using specified legal requirements.

**D**

**decision criteria.** The rules for deciding whether or not a lot conforms to package requirements based on the results of checking the packages in the sample.

**delivery.** A quantity of identically labeled product received at one time by a buyer.

**dimensionless units.** The integers in terms of which the official records package errors. The dimensionless units must be multiplied by the “unit of measure” to obtain package errors in terms of weight, length, etc.

**division, value of (d).** The value of the scale division, expressed in units of mass, is the smallest subdivision of the scale for analog indication or the difference between two consecutively indicated or printed values for digital indication or printing. See NIST Handbook 44.

**drained weight.** The weight of solid or semisolid product representing the contents of a package obtained after a prescribed method for removal of the liquid has been employed.

**dry measure.** Rigid containers designed for general and repeated use in the volume measurement of particulate solids. See Section 4.45. Dry Measures in NIST Handbook 44.

**dry pet food.** All extruded dog and cat foods and baked treats packaged in Kraft paper bags and cardboard boxes that have a moisture content of 13 % or less at the time of packaging.

**dry tare.** See UNUSED DRY TARE.

**E**

**error.** See PACKAGE ERROR.

**G**

**gravimetric test procedure.** An analytical procedure that involves measurement by mass or weight.

**gross weight.** The weight of the package including contents, packing material, labels.

**H**

**headspace.** The container volume not occupied by product.

**I**

**initial tare sample.** The first packages (either two or five) selected from the sample to be opened for tare determination in the tare procedure. Depending upon the variability of these individual tare weights as compared with the variability of the net contents, this initial tare sample may be sufficient or more packages may be needed to determine the tare.

**inspection lot.** The collection of identically labeled (random packages, in some cases, are exempt from identity and labeled quantity when determining the inspection lot) packages available for inspection at one time. This collection will pass or fail as a whole based on the results of tests on a sample drawn from this collection.

**L**

**label.** Any written, printed, or graphic matter affixed to, applied to, attached to, blown into, formed, molded into, embossed on, or appearing upon or adjacent to a consumer commodity or a package containing any consumer commodity, for purposes of branding, identifying, or giving any information with respect to the commodity or to the contents of the package, except that an inspector’s tag or other non-promotional matter affixed to or appearing upon a consumer commodity is not a label. See Section 2.5 in the Uniform Packaging and Labeling Regulation in NIST Handbook 130.

**linear measures.** Rulers and Tape Measures.

**location of test.** The place where the package will be examined. This is broadly defined as one of three general locations: (1) where the commodity was packaged, (2) a warehouse or storage location, or (3) a retail outlet.

**lot.** See INSPECTION LOT.

**lot code.** A series of identifying numbers and/or letters on the outside of a package designed to provide information such as the date and location of packaging or the expiration date.

**lot size.** The number of packages in the “inspection lot”.

**M**

**MAV.** See MAXIMUM ALLOWABLE VARIATION

**maximum allowable variation (MAV).** A deficiency in the weight, measure, or count of an individual package beyond which the deficiency is considered to be an “unreasonable error”. The number of packages with deficiencies that are greater than the MAV is controlled by the sampling procedure.

**measure containers.** Containers whose capacities are used to determine quantity. They are of two basic types: (a) retail and (b) prepackaged. Retail containers are packaged at the time of retail sale, and prepackaged containers are packaged in advance of sale. An example of a prepackaged measure container is an ice cream package.

**metric or SI units.** Units of the International System of Units as established in 1960 by the General Conference on Weights and Measures and interpreted or modified for the United States by the Secretary of Commerce. (see NIST Special Publication (SP) 811, “Guide for the Use of the International System of Units (SI)” [[**www.nist.gov/physical-measurement-laboratory/special-publication-811**](https://www.nist.gov/physical-measurement-laboratory/special-publication-811)] and  SP 330, The International System of Units (SI)” [[**www.nist.gov/pml/special-publication-330**](https://www.nist.gov/pml/special-publication-330)].)

**minus or plus errors.** Negative or positive deviations from the labeled quantity of the actual package quantities as measured. See PACKAGE ERROR.

**moisture allowance.** That variation in weight of a packaged product permitted in order to account for loss of weight due to loss of moisture during good package distribution practices. For packaged goods subject to moisture loss, when the average net weight of a sample is found between the labeled weight and the boundary of the moisture allowance, the lot is said to be in a no-decision area. Further information is required to determine lot compliance or noncompliance.

**mulch.** Any product or material other than peat or peat moss for sale, or sold for primary use as a horticultural, above-ground dressing for decoration, moisture control, weed control, erosion control, temperature control, or other similar purposes.

**N**

**net quantity or net contents.** That quantity of packaged product remaining after all necessary deductions for tare (defined) have been made.

**nominal.** A designated or theoretical size that may vary from the actual.

**nominal gross weight.** The sum of the nominal tare weight (defined) plus the declared or labeled weight (or other labeled quantity converted to a weight basis).

**P**

**package error.** The difference between the actual net contents of an individual package as measured and the declared net contents on the package label; minus (−) for less than the label and plus (+) for more than the label.

**packaged goods.** Product or commodity put up in any manner in advance of sale suitable for either wholesale or retail sale.

**petroleum products.** Gasoline, diesel fuel, kerosene, or any product (whether or not such a product is actually derived from naturally occurring hydro-carbon mixtures known as “petroleum”) commonly used in powering, lubricating, or idling engines or other devices, or labeled as fuel to power camping stoves or lights. Sewing machine lubricant, camping fuels, and synthetic motor oil are “petroleum products” for the purposes of this regulation. The following products are not “petroleum products”: brake fluid, copier machine dispersant, antifreeze, cleaning solvents, and alcohol.

**plus errors.** See MINUS OR PLUS ERRORS

**principal display panel or panels.** Part(s) of a label that are designed to be displayed, presented, shown, or examined under normal and customary conditions of display and purchase. Wherever a principal display panel appears more than once on a package, all requirements pertaining to the “principal display panel” shall pertain to all such “principal display panels.” See Section 2.7 in the Uniform Packaging and Labeling Regulation in NIST Handbook 130.

**production lot.** The total collection of packages defined by the packager, usually consisting of those packages produced within a given unit of time and coded identically.

**pycnometer** (pik·nämˊ ət ər)**.** A container of known volume used to contain material for weighing so that the weight of a known volume may be determined for the material. If it is constructed, it is called a density cup.

**R**

**random pack.** The term “random package” shall be construed to mean a package that is one of a lot, shipment, or delivery of packages of the same consumer commodity with varying weights which means, packages of the same consumer commodity with no fixed pattern of weight.

**random sampling.** The process of selecting sample packages such that all packages under consideration have the same probability of being selected. An acceptable method of random selection is to use a table of random numbers.

**range.** The difference between the largest and the smallest of a set of measured values.

**reasonable variation.** An amount by which individual package net contents are allowed to vary from the labeled net contents. This term is found in most federal and state laws and regulations governing packaged goods. Reasonable variations from the labeled declaration are recognized for (1) unavoidable deviations in good manufacturing practice, and (2) loss or gain of moisture in good distribution practice.

**rounding.** The process of omitting some of the end digits of a numerical value and adjusting the last retained digit so that the resulting number is as near as possible to the original number.

**S**

**sample.** A group of packages taken from a larger collection of packages and providing information that can be used to make a decision concerning the larger collection of packages or of the package production process. A sample provides a valid basis for decision only when it is a random sample (defined).

**sample correction factor.** The factor as computed is the ratio of the 95th quantile of the student’s t‑distribution (one-sided) with (n‑1) degrees of freedom and the square root of n where n is the sample size.

**sample error limit (SEL).** A statistical value computed by multiplying the sample standard deviation times the sample correction factor from Column 3 of Table 2‑1. Category A – Sampling Plans for the appropriate sample size. The SEL value allows for the uncertainty between the average error of the sample and the average error of the inspection lot with an approximately 95 % level of confidence.

**sample size** **(n).** The number of packages in a sample.

**sampling plan.** A specific plan that states the number of packages to be checked and the associated decision criteria.

**scale tolerance.** The official value fixing the limit of allowable error for weighing equipment as defined in NIST Handbook 44.

**seat.** (as in “seat diameter” or “seated capacity”). The projection or shoulder near the upper rim of a cup or container that is designed to serve as the support for a lid or cover.

**seated capacity.** The capacity of a cup, container, or bottle, as defined by the volume contained by them when the lid or a flat disc is inserted into the lid groove that is located inside and near the upper rim of the cup, container, or bottle.

**SEL.** See SAMPLE ERROR LIMIT.

**shipment.** A quantity of identically labeled product (except for lot code) sent at one time to a single location.

**slicker plate.** A flat plate, usually of glass or clear plastic composition, used to determine the “level full” condition of a capacity (volumetric) measure.

**standard deviation.** A measure to describe the scatter of the individual package contents around the mean contents.

**standard pack.** That type of package in which a commodity is put up with identical labels and only in certain specific quantity sizes. Examples of goods so packed are canned, boxed, bottled and bagged foods, and over-the-counter drugs.

**supplementary quantity declarations.** The required quantity declaration may be supplemented by one or more declarations of weight, measure, or count, such declaration appearing other than on a principal display panel. Such supplemental statement of quantity of contents shall not include any terms qualifying a unit of weight, measure, or count that tends to exaggerate the amount of commodity contained in the package (e.g., “giant” quart, “full” gallon, “when packed,” “minimum,” or words of similar import). See Section 6.12 in the Uniform Packaging and Labeling Regulation in NIST Handbook 130.

**T**

**tare sample.** The packages or packaging material used to determine the average tare weight.

**tare sample size.** The number of packages or packaging material units used to determine the average tare weight.

**tare weight.** The weight of a container, wrapper, or other material that is deducted from the gross weight to obtain the net weight.

**tolerance.** A value fixing the limit of allowed departure from the labeled contents; usually presented as a plus (+) and minus (−) value.

**U**

**unit of measure.** An increment of weight, length, or volume so that an inspector may record package errors in terms of small integers. (The package errors are actually the integers multiplied by the unit of measure.)

**U.S. customary units.** Units based upon the yard, gallon, and the pound commonly used in the United States of America. Some of these units have the same name as similar units in the United Kingdom (British, English, or Imperial units), but they are not necessarily equal to them.

**unreasonable errors.** Minus package errors that exceed the MAV (defined). The number of unreasonable errors permitted in a sample is specified by the sampling plan.

**unused dry tare.** All unused packaging materials (including glue, labels, ties, etc.) that contain or enclose a product. It includes prizes, gifts, coupons, or decorations that are not part of the product.

**used dry tare.** Used tare material that has been air dried, or dried in some manner to simulate the unused tare weight. It includes all packaging materials that can be separated from the packaged product, either readily (e.g., by shaking) or by washing, scraping, ambient air drying, or other techniques involving more than “normal” household recovery procedures, but not including laboratory procedures like oven drying. Labels, wire closures, staples, prizes, decorations, and such are considered tare. It is not the same as “wet tare.” See also “wet tare.”

**V**

**volumetric measures.** Standard measuring flasks, graduates, cylinders, for use in measuring volumes of liquids.

**W**

**wet tare.** Used packaging materials when no effort is made to reconstruct unused tare weight by drying out the absorbent portion (if any) of the tare.

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1. Notice: The mention of trade or brand name does not imply endorsement or recommendation by the U.S. Department of Commerce over similar products available from other manufacturers. [↑](#footnote-ref-2)
2. **Notice:** The mention of trade or brand names does not imply endorsement or recommendation by the U.S. Department of Commerce over similar products available from other manufacturers. [↑](#footnote-ref-3)
3. By action of the 12th General Conference on Weights and Measures (1964), the liter is a special name for the cubic decimeter. [↑](#footnote-ref-4)
4. This section lists units of measurement that have traditionally been used in the United States. In keeping with the Omnibus Trade and Competitiveness Act of 1988, the ultimate objective is to make the International System of Units the primary measurement system used in the United States. [↑](#footnote-ref-5)
5. Squares and cubes of customary but not of metric units are sometimes expressed by the use of abbreviations rather than symbols. For example, sq ft means square foot, and cu ft means cubic foot. [↑](#footnote-ref-6)
6. 3 Squares and cubes of customary but not of metric units are sometimes expressed by the use of abbreviations rather than symbols. For example, sq ft means square foot, and cu ft means cubic foot.

    When necessary to distinguish the liquid pint or quart from the dry pint or quart, the word “liquid” or the abbreviation “liq” should be used in combination with the name or abbreviation of the liquid unit. [↑](#footnote-ref-7)
7. When necessary to distinguish dry pint or quart from the liquid pint or quart, the word “dry” should be used in combination with the name or abbreviation of the dry unit. [↑](#footnote-ref-8)
8. 6 When necessary to distinguish the avoirdupois dram from the apothecaries dram, or to distinguish the avoirdupois dram or ounce from the fluid dram or ounce, or to distinguish the avoirdupois ounce or pound from the troy or apothecaries ounce or pound, the word “avoirdupois” or the abbreviation “avdp” should be used in combination with the name or abbreviation of the avoirdupois unit. [↑](#footnote-ref-9)
9. When the terms “hundredweight” and “ton” are used unmodified, they are commonly understood to mean the 100‑pound hundredweight and the 2000-pound ton, respectively; these units may be designated “net” or “short” when necessary to distinguish them from the corresponding units in gross or long measure. [↑](#footnote-ref-10)
10. As of January 1, 2014, “tn” is the required abbreviation for short ton. Devices manufactured between January 1, 2008, and December 31, 2013, may use an abbreviation other than “tn” to specify short ton. This provision is a NIST Handbook 44, “Specifications, Tolerances, and Other Technical Requirements for Weighing and Measuring Devices” in Appendix C. General Table of Units of Measurement.

    7 When the terms “hundredweight” and “ton” are used unmodified, they are commonly understood to mean the 100‑pound hundredweight and the 2000-pound ton, respectively; these units may be designated “net” or “short” when necessary to distinguish them from the corresponding units in gross or long measure.

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11. One international foot =  0.999 998 survey foot (exactly)

    One international mile =  0.999 998 survey mile (exactly)

    **NOTICE:** The National Institute of Standards and Technology (NIST) has announced a decision through the Federal Register to “deprecate” the use of the “U.S. survey foot” effective December 31, 2022.  This means that, after that date, use of the “U.S. survey foot” is to be avoided.   The “U.S. survey foot” will be superseded by “foot” (formerly called the “international foot”), which is already in use throughout the United States.  Additionally, the “U.S. survey mile” will be superseded by the “mile.”  After December 31, 2022, all data derived or published as a result of surveying, mapping, or any other activity within the U.S. that is expressed in terms of feet shall be based on the “foot” equal to 0.304 8 meter (exactly).  For more information see Federal Register (Vol. 84, No. 201, October 17, 2019, page 55562) at [**https://www.govinfo.gov/content/pkg/FR-2019-10-17/pdf/2019-22414.pdf**](https://www.govinfo.gov/content/pkg/FR-2019-10-17/pdf/2019-22414.pdf) [↑](#footnote-ref-12)
12. One square survey foot = 1.000 004 square international feet

    One square survey mile = 1.000 004 square international miles

    **NOTICE:** The National Institute of Standards and Technology (NIST) has announced a decision through the Federal Register to “deprecate” the use of the “U.S. survey foot” effective December 31, 2022.  This means that, after that date, use of the “U.S. survey foot” is to be avoided.   The “U.S. survey foot” will be superseded by “foot” (formerly called the “international foot”), which is already in use throughout the United States.  Additionally, the “U.S. survey mile” will be superseded by the “mile.”  After December 31, 2022, all data derived or published as a result of surveying, mapping, or any other activity within the U.S. that is expressed in terms of feet shall be based on the “foot” equal to 0.304 8 meter (exactly).  For more information see Federal Register (Vol. 84, No. 201, October 17, 2019, page 55562) at [**https://www.govinfo.gov/content/pkg/FR-2019-10-17/pdf/2019-22414.pdf**](https://www.govinfo.gov/content/pkg/FR-2019-10-17/pdf/2019-22414.pdf) [↑](#footnote-ref-13)
13. The angstrom is basically defined as 10−10 meter. [↑](#footnote-ref-14)
14. The term “statute mile” originated with Queen Elizabeth I who changed the definition of the mile from the Roman mile of 5000 feet to the statute mile of 5280 feet. The international mile and the U.S. statute mile differ by about three millimeters although both are defined as being equal to 5280 feet. The international mile is based on the international foot (0.3048 meter) whereas the U.S. statute mile is based on the survey foot (1200/3937 meter). [↑](#footnote-ref-15)
15. The international nautical mile of 1852 meters (6076.115 49 feet) was adopted effective July 1, 1954, for use in the United States. The value formerly used in the United States was 6080.20 feet = 1 nautical (geographical or sea) mile. [↑](#footnote-ref-16)
16. The question is often asked as to the length of a side of an acre of ground. An acre is a unit of area containing 43 560 square feet. It is not necessarily square, or even rectangular. But, if it is square, then the length of a side is equal to (not exact). [↑](#footnote-ref-17)
17. There are a variety of “barrels” established by law or usage. For example, federal taxes on fermented liquors are based on a barrel of 31 gallons; many state laws fix the “barrel for liquids” as 31½ gallons; one state fixes a 36‑gallon barrel for cistern measurement; federal law recognizes a 40‑gallon barrel for “proof spirits;” by custom, 42 gallons comprise a barrel of crude oil or petroleum products for statistical purposes, and this equivalent is recognized “for liquids” by four states. [↑](#footnote-ref-18)
18. Frequently recognized as 1¼ bushels, struck measure. [↑](#footnote-ref-19)
19. The equivalent “1 teaspoon = 1⅓ fluid drams” has been found by the Bureau to correspond more closely with the actual capacities of “measuring” and silver teaspoons than the equivalent “1 teaspoon = 1 fluid dram,” which is given by a number of dictionaries. [↑](#footnote-ref-20)
20. Used in assaying. The assay ton bears the same relation to the milligram that a ton of 2000 pounds avoirdupois bears to the ounce troy; hence the mass in milligrams of precious metal obtained from one assay ton of ore gives directly the number of troy ounces to the net ton. [↑](#footnote-ref-21)
21. The gross or long ton and hundredweight are used commercially in the United States to only a very limited extent, usually in restricted industrial fields. The units are the same as the British “ton” and “hundredweight.” [↑](#footnote-ref-22)
22. The gross or long ton and hundredweight are used commercially in the United States to a limited extent only, usually in restricted industrial fields. These units are the same as the British “ton” and “hundredweight.” [↑](#footnote-ref-23)
23. As of January 1, 2014, “tn” is the required abbreviation for a short ton. Devices manufactured between January 1, 2008, and December 31, 2013, may use an abbreviation other than “tn” to specify short ton. This provision is a NIST Handbook 44, “Specifications, Tolerances, and Other Technical Requirements for Weighing and Measuring Devices” in Appendix C. General Table of Units of Measurement. [↑](#footnote-ref-24)