

# CHAMBRE SYNDICALE DES VERRERIES MECANIQUES DE FRANCE

## **SPECIFICATIONS**

### **REUSABLE 1,000 X 1,200 PALLETS - WITH FOUR-WAY ENTRY AND FRAMED BOTTOM DECKBOARDS**

#### **This document includes:**

- Specifications: 5 pages
- Appendix I: wood defects 1 page
- Appendix II: identification of glassmakers 1 page
- Appendix III: technical sheet no. 901 "VMF pallet" 4 pages
- Appendix IV: mandatory information sheet 1 page

**Compliant with Standard EN 13382**

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**CHAMBRE SYNDICALE DES VERRERIES MECANIQUES DE FRANCE**  
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# CHAMBRE SYNDICALE DES VERRERIES MECANIQUES DE FRANCE

## I – DESCRIPTION

- The VMF pallet is a wood pallet with four-way entry and framed bottom deckboards;
- It is reusable and returnable;
- It is exclusively designed for packing empty glass bottles and jars;
- It has payload is 1,000 kg;
- Its technical characteristics are defined exclusively by CSVMF, which establishes its specifications.

Definitions:

- The “top deckboard” is the top part of the pallet;
- The “bottom deckboard” is the bottom part.

## II - CHOICE OF MATERIALS

### 2.1 Variety of wood

All wood varieties can be used, except for qualities that are known to split very easily during assembly or drying.

Wooden elements made of composite, pressed wood or laminate, or chipboard blocks, are not allowed.

### 2.2 Quality

The appearance of the materials is defined in [Appendix I](#).

The wood chosen must be sound (rot-free, no incipient decay) and allow the production of pallets that are free of visible or hidden defects that could jeopardize their solidity.

The wood must not be planed, but cut and edged to fixed widths in accordance with the indications on the drawing.

Each board must consist of a single piece.

The origin of the wood must be indicated. The wood must be certified FSC.

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## 2.3 Wood treatment

- The wood must be treated according to regulations in force in France.
- All fungicides used must be approved by the Agence Française de Sécurité Sanitaire des Aliments (French food safety agency).

Depending on legal obligations in the countries of destination concerned, conformity of the wood pallets to Standard ISPM 15 may be required.

## III - MANUFACTURE

Pallets must comply with the drawing described in Technical Sheet no. 901, in [Appendix II](#) of these specifications.

### 3.1 Structural elements (length x width x height)

- |                   |                              |
|-------------------|------------------------------|
| - Top deck:       | 7 boards 1,200 x 100 x 18 mm |
| - Stringers:      | 3 boards 1,000 x 100 x 18 mm |
| - Bottom deck:    | 5 boards 1,000 x 100 x 18 mm |
| - Central blocks: | 3 boards 100 x 100 x 100 mm  |
| - End blocks:     | 6 boards 150 x 100 x 100 mm  |

### 3.2 Dimensional tolerances of elements

The tolerances are designed to take into account basic manufacturing standard deviations. Systematic use of the tolerances is prohibited. The target must be the nominal dimension.

Length:	$\pm 3$ mm
Width:	+ 3 / - 0 mm
Height:	+ 3 / - 0 mm

The width and thickness tolerances are however increased + 3 / - 2 mm over a length that shall not exceed 100 mm at the ends of the elements making up the deck. The tolerance of + 3 / - 2 mm only concerns the end (100 mm max) of the pallet bottom deckboards (top part).

This tolerance does not contradict the general tolerance of +3/-0.

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This tolerance only applies to the width for the ends of the elements making up the bottom deckboard.

All elements shall be sawn strictly squarely.

Pallet total volume: 41.52 dm<sup>3</sup>.

## 3.3 Humidity

Wood is sensitive to humidity and subject to more or less shrinkage depending on the variety of wood and its nature. We recommend not exceeding a humidity of 28%.

An average correction factor of 0.25% per % of humidity is applied when monitoring palette element thickness in order to correct the values measured to the 28% humidity.

To evaluate pallet humidity content, see French standard "NF B 53 - 664, Palettes en Bois, Teneur en Humidité."

## 3.4 Assembly/squaring

A tolerance of 3 mm is accepted for positioning the elements with respect to the dimensions indicated on the drawing.

A difference of 3 cm maximum is accepted between the lengths of the 2 diagonals.

All elements making up the pallet, and especially the bottom deckboards, must be ABUTTED.

## 3.5 Nailing

All elements must be assembled with round head nail according to the indications on the drawing.

The position of each nail is shown on the drawing with a cross.

All nails must be positioned vertically at least 25 mm from the edges. The nail heads must not protrude.

**The following must be used:**

- |  |                         |             |
|--|-------------------------|-------------|
| • to fasten stringer boards to blocks        | 6 non smooth nails      | 80 x 3.4 mm |
| • to fasten top deck boards to blocks        | 21 non smooth nails     | 80 x 3.4 mm |
| • to fasten bottom deck boards to blocks     | 30 non smooth nails     | 70 x 3 mm   |
| • to nail top deck boards to stringer boards | 42 riveted smooth nails | 40 x 2.2 mm |

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No change in the type of nails, and no additional tolerance on nail dimensions will be accepted.

The nail heads must be embedded in the wood.

**It is accepted to staple with notched wire of  $\varnothing$  20/10<sup>th</sup> mm to assemble the top deck and notched wire of  $\varnothing$  25/10<sup>th</sup> to assemble top deck on the blocks. Preformed staples are prohibited.**

## 3.6 Finish (see Appendix I)

Any elements split following assembly must be replaced if the split or crack is outside the tolerance.

If the split or crack is within the tolerance, the nail that caused it must be doubled with an additional nail.

## 3.7 Marking

On each pallet, on two diagonally opposite end blocks on the 1,200 mm side, the following shall be affixed:

- The VMF brand,
- The number of the glassmaker that placed the order (see Appendix II),
- The month/year of manufacture,
- The supplier's brand.

All these markings must be made exclusively with a hot iron.

## IV - QUALITATIVE AND QUANTITATIVE ACCEPTANCE

The pallets being manufactured or finished on producer premises, may undergo qualitative or quantitative inspections by the purchasing company or its representatives.

If the pallets are not compliant with the drawing and the specifications, they will be rejected.

The acceptance departments can scrap any pallets deemed non-compliant. In this case, the factories will return the lorry or rail car (return costs are at the expense of the manufacturer), accompanied by a sheet indicating the reason for the rejection.

**ON PALLETS REJECTED BY A GLASSMAKING COMPANY, THE VMF MARK MUST BE REMOVED.**

**SPECIFICATIONS**  
**REUSABLE 1,000 X 1,200 PALLETS - WITH FOUR-WAY ENTRY AND FRAMED BOTTOM DECKBOARDS**  
**APPENDIX I: WOOD DEFECTS**

**THE ACCEPTABLE MAXIMUMS MAY NOT BE GREATER THAN THOSE SPECIFIED BELOW**

TYPE OF DEFECT	TOP DECK	BOTTOM DECKBOARDS AND STRINGERBOARDS	
INGROWN KNOTS (isolated)	Diameter 40 mm	Diameter 30 mm	Diameter 30 mm
LOOSE KNOTS (isolated)	Diameter 25 mm	Excluded	Excluded
Min distance between 2 acceptable consecutive knots of $\varnothing$ greater than 15 mm that interrupts the same fibres	200 mm	300 mm	100 mm (visible on each side)
GUM POCKETS	Excluded on top side length at the most equal to 50 mm for bottom side	Excluded on bottom side of bottom deckboards Length at the most equal to 50 mm for top side of bottom deckboards Excluded for stringerboards	Excluded
Splits at end, outside nailing points	100 mm	50 mm	50 mm
Splits at end, on nailing points	100 mm - use two nails	50 mm - use two nails	50 mm - use two nails
Seasoning checks (length) Heart shakes (depth)	300 mm --	150 mm --	-- 50 mm - only one per block
Slope of grain of wood	5 %	5 %	10 %
Wane	Excluded on edge boards tolerated for 1 element per top deck over a thickness and width of less than 10 mm	Excluded	Excluded

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## SPECIFICATIONS REUSABLE 1,000 X 1,200 PALLETS - WITH FOUR-WAY ENTRY AND FRAMED BOTTOM DECKBOARDS APPENDIX II: IDENTIFICATION NO. OF GLASSMAKERS ON VMF PALLETS

No.	1	V. O. A. Verrerie d'Albi
No.	2	Verrerie du LANGUEDOC
No.	3	O-I (ex. BSN)
<del>No.</del>	<del>4</del>	<del>VERDOME</del>
No.	5	VERALLIA (ex. S. G. E.)
No.	6	TOURRES & Cie
<del>No.</del>	<del>7</del>	<del>V. M. C.</del>
No.	8	VERLIPACK
No.	9	ARC
No.	10	BARBOSA & ALMEIDA
No.	11	RICARDO GALLO
No.	12	VETROPACK
No.	13	VERRERIE DE MASNIERES-BORMIOLI
No.	14	SEVAM
No.	15	SGD
N°	16	VERESCENCE
N°	17	CAN-PACK GLASS
N°	18	SISECAM
N°	19	STEKLARNA HRASTNIK

Other : (specify)

Example of marking on a pallet purchased by V.O.A:

**V M F 1**

**06/08 XXX**

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## SPECIFICATIONS

### REUSABLE 1,000 X 1,200 PALLETS - WITH FOUR-WAY ENTRY AND FRAMED BOTTOM DECKBOARDS

#### APPENDIX III - PACKAGING OF GLASSWORKS DELIVERIES VMF PALLET - CHARACTERISTICS

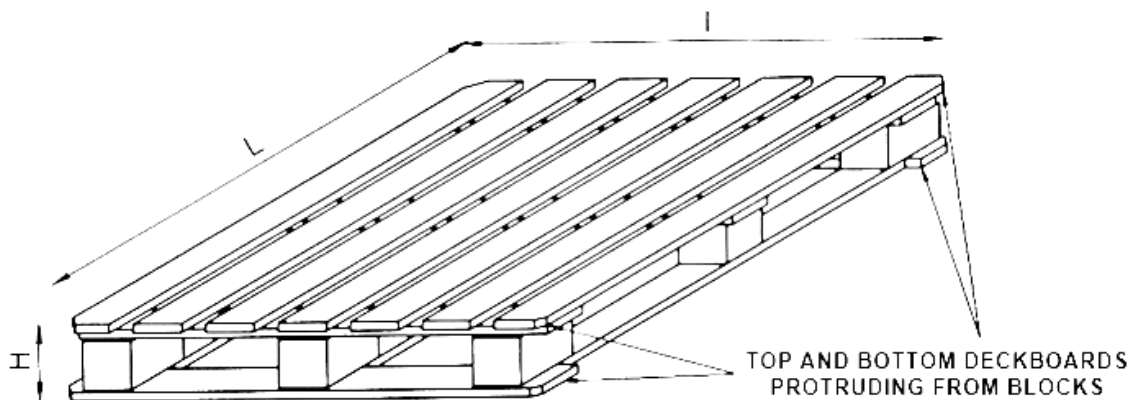
#### TECHNICAL SHEET No. 901

#### □ A VMF pallet is:

- a returnable pallet with four-way entry and framed bottom deckboards
- compliant with CSVMF drawing described on pages 2 and 3 of this document
- compliant with VMF specifications in force

#### □ Dimensions

« L » =	Length	1200 mm ± 3 mm
« l » =	Length	1000 mm ± 3 mm
« H » =	Height	154 mm + 6 mm - 0 mm





## CHAMBRE SYNDICALE DES VERRERIES MECANIQUES DE FRANCE

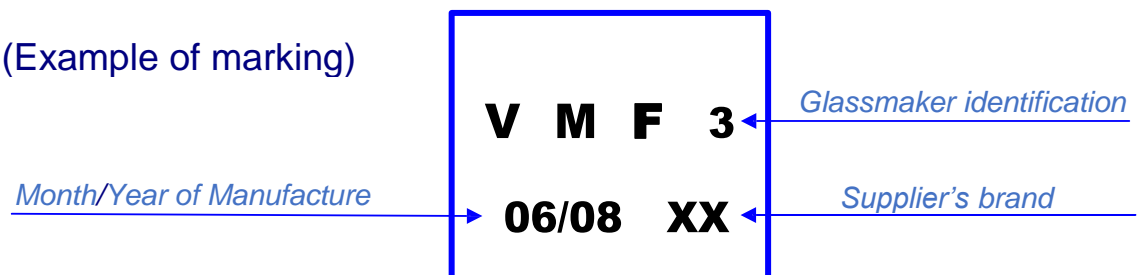
A tolerance of 3 mm is accepted for positioning the other elements relative to the dimensions indicated on the drawing.

This pallet is designed for a payload of 1,000 kg.

### ☐ Each VMF pallet must be identified

- By marking with a hot iron on 2 outer blocks diagonally opposite on the 1,200 mm side with the following information (marking on 2 or 3 lines).

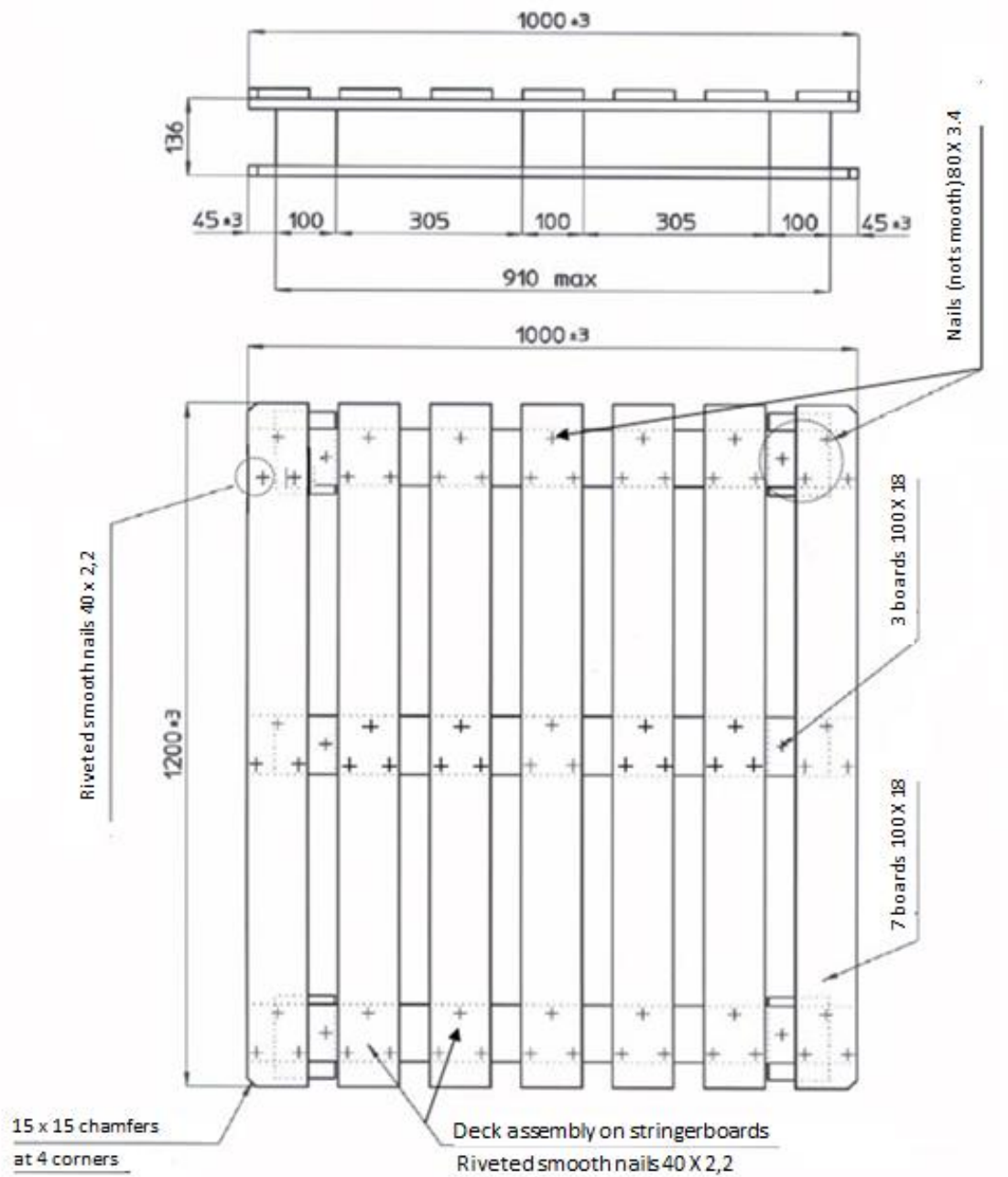
(Example of marking)





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## PACKAGING OF GLASSWORKS DELIVERIES VMF PALLET - CHARACTERISTICS - DRAWING 2



Wood volume 4152 dm<sup>3</sup>

All values in mm

**REUSABLE PALLET**  
1,000 x 1,200 – 4-way entry  
with framed bottom deckboards

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## PACKAGING OF GLASSWORKS DELIVERIES VMF PALLET - USE

**The manufacture of new pallets is ensured by manufacturers/suppliers certified by CSVMF**

- under their supervision
- for its own uses

compliant with VMF specifications in force

**Only glassmakers are authorized to take back these VMF pallets**

- from customers who use glass products
- regardless of their origin

**All pallets returned by a customer must**

- be in good condition
- not have been damaged due to parallel use or prolonged storage

**Treatment of woods / fungicides**

See specifications

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## SPECIFICATIONS

REUSABLE 1,000 X 1,200 PALLETS - WITH FOUR-WAY ENTRY AND FRAMED  
BOTTOM DECKBOARDS

APPENDIX IV - MANDATORY INFORMATION SHEET

Company name:

Address:

Addresses of production sites:

Name of manager:

Telephone:

E-mail:

Identification no.:

*(Trade registry, etc.)*

Brand:

Company seal:

Glassmakers delivered:

- VOA     Verrerie du Languedoc     O-I     Verallia     Saverglass/Tourres
- Verlipack     Arc     Barbosa & Almeida     Ricardo Gallo/Vidrala     Vetropack
- Verreries de Masnières-Bormioli     SEVAM     SGD Pharma     Verescence
- Can Pack Glass     Sisecam     Steklarna Hrastnik
- Other (specify).....