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DRAFT ZANZIBAR NATIONAL STANDARD

Toothpicks and skewers — Specification

ZANZIBAR BUREAU OF STANDARDS

 First Edition

Foreword

This draft Zanzibar standard has been developed by Packaging and Polymer Standard Technical Committee (TCC8). In accordance with Zanzibar Bureau of Standards (ZBS) general procedures, this draft standard is presented to the public in order to receive any technical comment concerns.

Technical Committee Representatives

This Draft Zanzibar National Standard was prepared by the Packaging and Polymer Standards

Technical Committee which consists of representatives from the following organizations:

Chief Government Chemist Laboratory Agency (CGCLA)

University of Dar es salaam - CoET

Zanzibar Environmental Management Authority (ZEMA)

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Toothpicks and skewers — specification

1 Scope

This draft Zanzibar Standard specifies the product types, technical requirements, inspection methods, inspection rules, identification, packaging, transportation and storage of bamboo toothpicks and skewers.

This standard applies to toothpicks and skewers made from bamboo and other plant varieties used for tooth picking, food and beauty industry.

This standard does not apply to coated toothpicks and skewers.

2 Normative references

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

ISO 780, Packaging — Distribution packaging — Graphical symbols for handling and storage of packages

ISO 10725, Acceptance sampling plans and procedures for the inspection of bulk materials

ISO 13061-1, Physical and mechanical properties of wood — Test methods for small clear wood specimens — Part 1: Determination of moisture content for physical and mechanical tests

3 Terms and definitions

For the purposes of this draft Standard the following terms and definitions apply.

3.1
toothpicks
short, pointed thin piece of bamboo or other plant varieties with either one or sometimes twopointed ends used for removing bits of food lodged between the teeth after a meal

3.2
Skewers
long piece of wood or metal used for holding pieces of food, typically meat, together during cooking

3.2
little tip
slender tip of the toothpick tip

3.3
barbed tip
barb-shaped tip of the toothpick tip

3.4
split tip
stubble at the tip of a toothpick

3.5
arris tip
longitudinal prismatic point at the tip of the toothpick

3.6
decay
decomposition of material due to the invasion of decaying bacteria and/or fungi resulting to reduced strength and structure

3.7
split
bamboo or other plant varieties fibres separated along the grain direction

3.8
wane
cylinder edge defects caused by planing, sanding, bumping, or undersized bamboo stick wool

3.9
stains
local discoloration on the surface caused by microorganisms, metals or chemicals

3.10
mildew
thin white coating caused by fungal hyphae growing on a damp wood or surface

3.11
glitch
bamboo fibre bundles that may cause splinter and scratches on the finished bamboo toothpick

3.12
tip diameter
smallest diameter of the toothpick tip/skewer

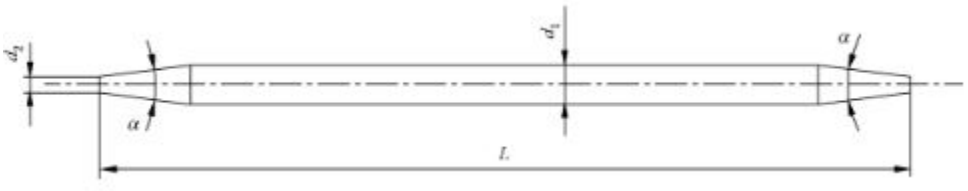
3.13
heat treatment
exposing the material to 56 ˚C temperatures for 30 min to sterilize and eliminate pests

4 Product type

4.1 Classification

According to the shape, it can be divided into round double-end pointed toothpicks/skewers and round single-end pointed toothpicks/skewers.

4.1.1 Round double-ended toothpicks/skewers



Key:

L is the length;

d_1 is the diameter of cylinder;

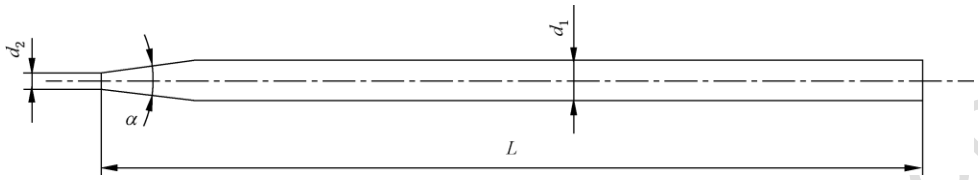
d_2 is the diameter of the tip plane;

α is the end taper angle.

Figure 1 — Round double-ended toothpicks/skewers

4.1.2 Round single-ended toothpicks/skewers

The round single-ended toothpicks/skewer are as shown in Figure 2.



Key:

L is the length;

d_1 is the diameter of cylinder;

d_2 is the diameter of the tip plane;

α is the end taper angle.

Figure 2 — Round single-ended toothpicks/skewers

5 Requirements

5.1 Raw material requirements

5.2 Sensory requirements

5.2.1 Odour

The material shall be free from odour

5.2.2 Appearance quality

The appearance quality shall be as per the requirements given in Table 1.

Table 1 — Appearance quality requirements

S/N	Defects	Limit
i.	Blunt tip, hook tip, split tip, edge tip	Slightly
ii.	Decay, mildew	Not allowed
iii.	Glitch	Slightly
iv.	Stains	Not allowed
v.	Wane	Slightly
vi.	Crack	Not more than 15% of the length
NOTE Slightly means defects cannot be easily seen if the toothpick is placed 200 mm away from the naked eye under natural light.		

5.2.3 Specifications and deviations for toothpicks and skewers

5.2.3.1 Toothpicks shall comply with the sizes and allowable deviations given in Table 2.

Table 2 — Toothpick sizes and allowable deviations

S/N	Dimension	Unit	Standard size	Allowable deviation
i.	Length (L)	mm	50.0≤ L ≤ 70.0	±1.0
ii.	Cylinder diameter (i1)	mm	1.4 ≤ i1 ≤ 1.8	±0.2
			1.8 < i1 ≤ 2.2	±0.3
iii.	Tip plane Diameter (i2)	mm	0.40	±0.10
iv.	End taper angle (α)	(°)	11	±3

5.2.3.2 Skewers shall comply with the sizes and allowable deviations given in Table 3

Table 3 — Skewers sizes and allowable deviations

S/N	Dimension	Unit	Standard size	Allowable deviation
i.	Length (L)	mm	112.0 ≤ L ≤ 250.0	±1.0
ii.	Cylinder diameter (d1)	mm	2.5≤d1≤4.0	±0.5
iii.	Tip plane diameter (d2)	mm	0.60	±0.10
iv.	End taper angle (α)	(°)	7	±3

5.2.4 Moisture content

The moisture content shall be 8 % - 13 %.

Preservation of raw material

Only non-chemical preservation is recommended, however, heat treatment is preferred.

6 Inspection method

6.1 Sensory test

6.1.1 Odour

Take a group (50) of bamboo toothpicks/skewers, 50 mm away from them, and sniff.

6.1.2 Appearance

Visual inspection of the samples taken is carried out as required. When using visual inspection, the viewing distance should be 100 mm to 200 mm under natural light or approximate natural light in the range of 300 lx to 600 lx of illumination (such as 40 W fluorescent lamp).

6.2 Size deviation inspection

6.2.1 Measuring tools

6.2.1.1 Vernier caliper graduated at 1.0 mm and precision of 0.02 mm.

6.2.1.2 Steel ruler graduated at 0.5 mm and precision of 0.5 mm.

6.2.1.3 Universal angle ruler with an accuracy of 0.02'.

6.2.2 Length

Length (L) inspection is measured with a steel ruler (refer to 6.2.1.2).

6.2.3 Diameter

The diameter of the cylinder (d1) is checked at one-half of the full length, and the plane diameter of the tip (d2) is checked at the smallest point of the tip, measured with a Vernier caliper (refer to 6.2.1.1).

6.2.4 End taper angle

The taper angle (α) inspection shall be measured at the end with a universal angle ruler (refer 6.2.1.3).

6.3 Determination of moisture content

Take samples with complete packaging and carry out in accordance with the provisions of ISO 13061-1.

7 Inspection rules

7.1 Inspection classification

Product inspection is divided into factory inspection and type inspection.

7.2 Factory inspection

Each batch of products shall be subjected to factory inspection. The factory inspection includes the following items:

a) sensory testing;

b) Specification size and deviation inspection; and

c) Moisture content test.

7.3 Type inspection

7.3.1 Check all items

7.3.2 After one year of normal production, type inspection shall be carried out in any of the following situations:

a) trial-type identification of new products or products transferred to factories;

b) during formal production, such as when there are major changes in structure, raw materials, and processes;

c) when the product has been discontinued for more than six months, when the production is resumed;

d) when there is a big difference between the factory inspection results and the last type inspection results; and

e) When the national quality supervision agency puts forward the requirements for type inspection.

7.4 Group batching principles

Products with the same variety of raw materials, production conditions, specifications and types are considered as one inspection batch.

7.5 Sampling plan

Samples with complete packaging from the same inspection lot are randomly selected in the finished product warehouse. Sampling is in accordance with ISO 10725 normal inspection one-time sampling plan, the inspection level is S-4, and the acceptance quality limit (AQL) is 6.5 (see Table 4).

Table 4 — Inspection sampling plan

S/N	Batch range	Number of samples	Acceptable number (Ac)	Rejection number (Re)
i.	≤ 35 000	50	7	8
ii.	35 001 - 500 000	80	10	11
iii.	≥ 500 001	125	14	15

7.6 Judgment of results

All indicators meet the corresponding technical requirements, and the batch of products is determined to

be qualified; if a single indicator is unqualified, the single-item inspection shall be doubled, and if the inspection is still unqualified, the batch of products shall be determined to be unqualified products.

8 Identification, packaging, storage and transportation

8.1 Identification

8.1.1 Signs

The packaging, storage and transportation diagrams are in accordance with the provisions of ISO 780.

8.2 Packaging and Marking

8.2.1 Packaging

The packaging should be firm, clean and moisture-proof.

The packaging materials should be dry, clean and free of peculiar smell, which will not affect the product quality.

8.3 Marking

The following information shall be marked legibly and indelibly on each pack, and in case of the small pieces, writing shall be on the container.

a) The product name;

b) The manufacturer's name and the brand or any them;

c) The country of origin;

d) Quantity;

e) Grade;

f) Date of manufacture and expiry; and

g) Safety warning signs

8.4 Storage and transportation

During storage and transportation, the product should be protected from moisture, fire and pollution.