



ISTA, Your Alliance in Transport Packaging, is the world leader in Performance Tests for Packaged-Products.

ISTA 1 Series are the most basic category of performance tests.

- They challenge the capability of the package and product to withstand transport hazards, **but**
- They are not simulations of actual transport hazards, **and**
- Do not necessarily comply with carrier packaging regulations.

When properly applied, ISTA procedures will provide tangible benefits of:

- Shortened packaged development time and confidence in product launch
- Protection of products and profits with reduced damage and product loss
- Economically balanced distribution costs
- Customer satisfaction and continued business.

There are three sections: Overview, Testing and Report

- **Overview** provides the general knowledge required before going into the testing laboratory **and**
- **Testing** presents the specific instructions to do the testing in the laboratory **and**
- **Report** indicates what data shall be recorded to submit a test report to ISTA.

Two systems of weights and measures are presented in ISTA test procedures. They are the English system (Inch-Pound) and the international system SI (Metric). Inch-Pound units are shown first with Metric units in brackets, except in some tables where they are shown separately.

- Either system may be used as the unit of measure (standard units), **but**
- The standard units chosen shall be used consistently throughout the procedure.
- Units are converted to two significant figures **and**
- Not exact equivalents.

VERY IMPORTANT:

The entire document shall be read and understood before proceeding with a test.

OVERVIEW OF PROCEDURE 1B

Test Procedure 1B is an integrity test for individual packaged-products.

- It can be used to evaluate the performance of a packaged-product.
- It can be used to compare relative performance of package and product design alternatives.
- The package and product are considered together and not separately.
- Some conditions of transit, such as moisture, pressure or unusual handling, may not be covered.

Other ISTA Procedures may be appropriate for different conditions or to meet different objectives.

Specific suggestions:

- To use random vibration instead of fixed displacement vibration, use ISTA Test Procedure 1H and not 1B.
- For packaged-products where a minimum compression value should be tested, use ISTA Test Procedure 1D.
- For unitized loads conduct ISTA 1E and not 1B. A unitized load is defined as one or more products or packaged-products usually on a skid or pallet, but always secured together or restrained for distribution as a single load.
- For packaged-products intended for international distribution consider ISTA Partial-Simulation Performance Test Procedure 2B.
- Refer to *Guidelines for Selecting and Using ISTA Procedures and Projects* for additional information.

Scope

Test Procedure 1B covers testing of individual packaged-products weighing more than 150 lb (68 kg) when prepared for shipment.

Product Damage
Tolerance and
Degradation
Allowance

The shipper shall determine the following prior to testing:

- what constitutes damage to the product **and**
- what damage tolerance level is allowable, if any, **and**
- the correct methodology to determine product condition at the conclusion of the test **and**
- the acceptable package condition at the conclusion of the test.

For additional information on this determination process refer to *Guidelines for Selecting and Using ISTA Procedures and Projects*.

Samples

Samples should be the untested actual package and product, but if one or both are not available, the substitutes shall be as identical as possible to actual items.

Number of samples required:

One sample is required for the tests in this procedure.

Replicate Testing Recommended:

To permit an adequate determination of representative performance of the packaged-product, ISTA:

- Requires the procedure to be performed one time, **but**
- Recommends performing the procedure five or more times using new samples with each test.

NOTE:

Packages that have already been subjected to the rigors of transportation cannot be assumed to represent standard conditions. In order to insure testing in perfect condition, products and packages shipped to certified laboratories for testing must be:

- over-packaged for shipment to the laboratory **or**
- repackaged in new packaging at the laboratory.

Test Sequence

The tests shall be performed on each test sample in the sequence indicated in the following table:

Sequence #	Test Category	Test Type	Test Level	For ISTA Certification
1	Vibration	Fixed Displacement	1 in (25mm) peak to peak at a frequency to be determined	Required
2	Shock (Alternative methods allowed – select one test type)	Drop	6 in (150 mm)	Required
		Incline Impact (Conbur)	69 in (1.7 m) per second impact velocity	
		Horizontal Impact	69 in (1.7 m) per second velocity change	
3	Shock	Rotational Edge Drop	8 in (200 mm)	Required when not testing face 1

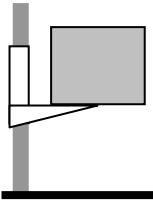
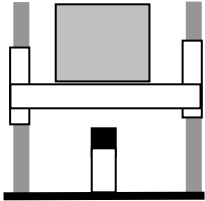
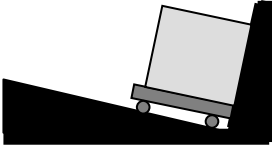
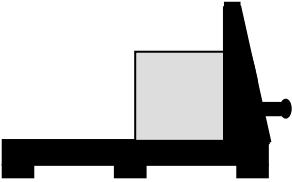
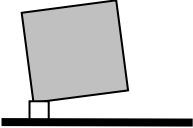
Equipment
Required
Vibration

Fixed Displacement Vibration Test:

- Vibration Test System with a 1 in (25 mm) fixed or controlled displacement complying with Method A1 or A2 of the apparatus section of ASTM D 999-01. Rotary or vertical linear motion of the platform is acceptable.
- Metal shim 0.06 in (1.5 mm), thick approximately 2 in (50 mm) wide and at a convenient length.
- Tachometer or suitable indicator for determining vibration frequency in cycles per second (Hz) or cycles per minute (CPM).
- Automatic timer or stopwatch.

Equipment
Required
Shock

The following alternatives are acceptable for the equipment required for the Shock Test:

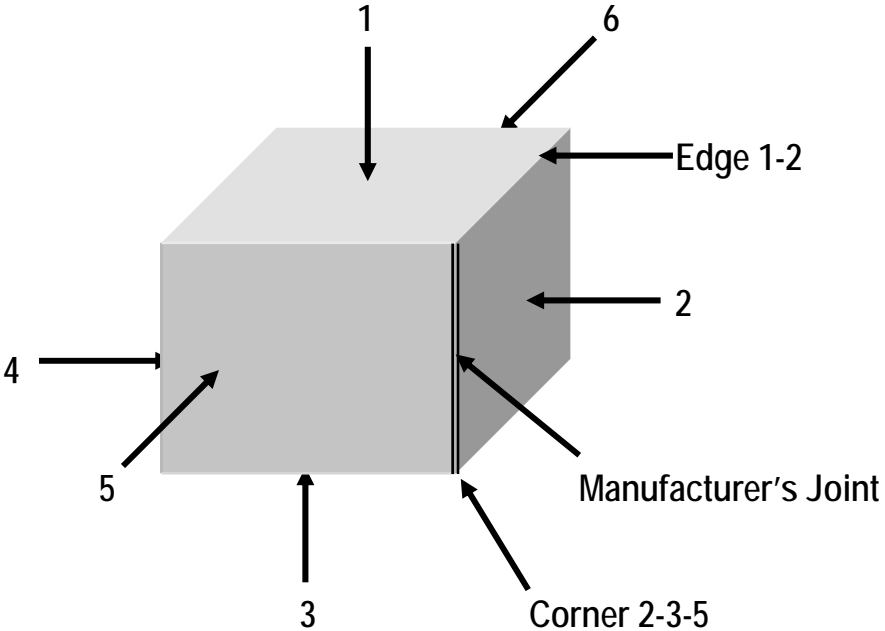
Type of Shock Test	Equipment	In compliance with the apparatus section of ...
Drop Test	Free fall drop tester 	ASTM D 5276-98
Vertical Shock Test	Shock test machine 	ASTM D 5487-98(02)
Incline Test	Incline impact tester (conbur) 	ASTM D 880-92(02)
Horizontal Test	Horizontal impact test system 	ASTM D 4003-98
Rotational Test	Rotational drop 	ASTM D 6179-97

1B

Identification of Faces, Edges and Corners

BEFORE YOU BEGIN PROCEDURE 1B

Prior to beginning the tests identify the faces, edges and corners according to the procedure below.

Step	Action
1	Place the packaged-product in its intended shipping position as determined by shipper. If the shipping position can be variable, place the packaged-product so that the primary shipping label position is on the top face.
2	Does the packaged-product have only six faces (2 sides, 2 ends, top and bottom)? <ul style="list-style-type: none"> • If Yes, then go to Step 5. • If No, continue to next Step.
3	Develop a method to identify each face, edge and corner and document with a diagram.
4	Go to the next Block.
5	Is the package a corrugated container? <ul style="list-style-type: none"> • If Yes, continue to next step. • If No, then go to Step 8.
6	Does the package have a manufacturer's joint connecting a side and an end face? <ul style="list-style-type: none"> • If Yes, continue to next step. • If No, then go to Step 8.
7	Turn the packaged-product so that you are looking directly at a face with the manufacturer's joint on the observer's right and go to Step 9.
8	Position one of the smallest width faces of the packaged-product directly in front of you.
9	<p>Identify faces according to the diagram below.</p>  <p>The diagram shows a 3D perspective of a rectangular prism. The top face is labeled '1'. The right face is labeled '2'. The front face is labeled '5'. The left face is labeled '4'. The bottom face is labeled '3'. The top-right edge is labeled '6'. The edge between the front and right faces is labeled 'Edge 1-2'. A vertical crease on the right face is labeled 'Manufacturer's Joint'. The corner where faces 2, 3, and 5 meet is labeled 'Corner 2-3-5'.</p>
10	Identify edges using the numbers of the two faces forming that edge. Example: Edge 1-2 is the edge formed by face 1 and face 2 of the packaged-product.
11	Identify corners using the numbers of the three faces that meet to form that corner. Example: Corner 2-3-5 is the corner formed by face 2, face 3, and face 5 of the packaged-product.
12	Go to next Block.

You shall know the packaged-product's:

- gross weight in pounds (kg), **and**
- outside dimensions of Length, Width and Height (L x W x H) in inches (mm or m)

A restraining device or devices shall be used with the vibration test system to:

- Prevent the test specimen from moving off the platform **and**
- Maintain test orientation of the packaged-product, **but**
- The device or devices shall not restrict the vertical motion of the test specimen during the test.

Familiarity with the following formula is required to calculate the test duration after the frequency required to bounce the packaged-product is determined in the Vibration Test Block:

$$\text{Test Duration in Minutes} = \frac{11,800 \text{ Vibratory Impacts}}{\text{Cycles Per Minute (CPM) or [Cycles Per Second (Hz) x 60]}}$$

The chart below shows example Test Duration's calculated for several frequencies:

CPM	Hz	Test Duration in Minutes
150	2.5	79
180	3.0	66
210	3.5	57
240	4.0	50
270	4.5	44
300	5.0	40

Select Drop, Incline or Horizontal as a test method.

For Drop Test Method the drop height shall be 6 in (150 mm) for Free Fall Drop, Shock Machine Equivalent Free Fall Drop, or Sling Drops.

For Incline Test Method the minimum impact velocity is 69 in per second (1.7 m per second).

For Horizontal Test Method the minimum velocity change is 69 in per second (1.7 m per second).

NOTE:

69 in per second is equal to 5.75 ft per second.

When using impact velocity or velocity change, if any velocity in a Test Sequence is below the required minimum level, that sequence event must be repeated until the test velocity meets the minimum.

EXCEPTION:

You do not have to conduct a shock test on face 1 (top) if:

- the packaged-product has a visible skid or pallet, **or**
- positioning or testing the packaged-product in this orientation would be unsafe.

CAUTION:

If the test item is large and:

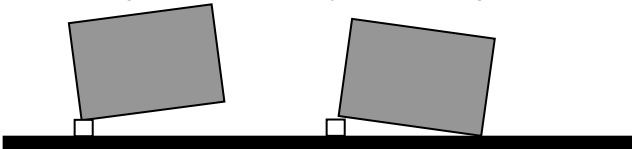
- has a length equal to or greater than twice the width **and**
- has a center of gravity above the midpoint of the height.
- there is the possibility that it could tip over when testing one of the longest edges, **therefore**
- you may conduct the Rotational Edge Drop test on both of the shortest edges.

The test blocks that follow contain tables that indicate the required steps for each test in the procedure.

FIXED DISPLACEMENT							
Step	Action						
1	Put the packaged-product on the vibration table so that face 3 rests on the platform.						
2	Start the vibration system to vibrate at 1 in (25 mm) total displacement at the machine's lowest frequency.						
3	Maintain a fixed displacement at 1 in (25 mm) and slowly increase the frequency (speed) of the vibration table until the packaged-product begins to momentarily leave the surface of the platform.						
4	Hold the vibration frequency to that determined in Step 3.						
5	Can a metal shim be intermittently moved between the bottom of the longest dimension of the packaged-product and the surface of the platform? <ul style="list-style-type: none"> • If Yes, hold that frequency and then continue to next step. • If No, then increase the frequency until the requirement of Step 5 is met and hold that vibration frequency. 						
6	Determine the test duration in minutes using the formula indicated in the Before You Begin Block and the CPM or Hz frequency identified in Step 5.						
7	Begin the vibration duration.						
8	Are you using a vertical linear motion on the vibration system? <ul style="list-style-type: none"> • If Yes, then go to Step 12. • If No, then continue with the next step. 						
9	Stop the vibration test half way through the vibration duration perform the appropriate action as indicated in the table below: <table border="1" data-bbox="495 1150 1523 1352"> <thead> <tr> <th>IF a single 90° horizontal rotation is...</th> <th>THEN perform a horizontal rotation of ...</th> </tr> </thead> <tbody> <tr> <td>Possible</td> <td>90° as the specimen rests on the platform.</td> </tr> <tr> <td>Not practical because of the size of the packaged-product or the stability of the packaged-product.</td> <td>180° as the specimen rests on the platform.</td> </tr> </tbody> </table>	IF a single 90° horizontal rotation is...	THEN perform a horizontal rotation of ...	Possible	90° as the specimen rests on the platform.	Not practical because of the size of the packaged-product or the stability of the packaged-product.	180° as the specimen rests on the platform.
IF a single 90° horizontal rotation is...	THEN perform a horizontal rotation of ...						
Possible	90° as the specimen rests on the platform.						
Not practical because of the size of the packaged-product or the stability of the packaged-product.	180° as the specimen rests on the platform.						
10	Start the vibration system and continue the vibration test at the frequency used in Step 7.						
11	Can a metal shim be intermittently moved between the bottom of the longest dimension of the packaged-product and the surface of the platform? <ul style="list-style-type: none"> • If Yes, then continue to next step. • If No, then slowly increase the frequency until the requirement of Step 11 is met. 						
12	Complete the vibration duration.						
13	Inspection of the package-product for visible damage is allowed, provided inspection does not alter, in any way, the current condition of the package or the condition or position of the product(s).						
14	Vibration testing is now complete. Go to the Shock Test Block.						

TEST SEQUENCE FOR PROCEDURE 1B

DROP OR IMPACT			
Step	Action		
1	Did you determine in the Before You Begin Shock Testing not to shock test face 1 (top)? <ul style="list-style-type: none"> • If Yes, then go to next Shock Test Block. • If No, go to the next Step. 		
2	Determine the drop height, impact velocity or velocity change using the Before You Begin Block.		
3	Test the packaged-product according to the level in Step 2. Follow the sequence in the table below.		
	Sequence #	Orientation	Specific face
	1	Face	one of the smallest faces
	2	Face	opposite small face
	3	Face	one of the medium faces
	4	Face	opposite medium face
	5	Face	one of the largest faces
6	Face	opposite large face	
4	All testing is now complete. Go to the Test Report Block.		

IMPACT AND ROTATIONAL DROP			
Step	Action		
1	Determine the impact velocity or velocity change using the Before You Begin Block.		
2	Test the packaged-product according to the level in Step 1. Follow the sequence in the table below.		
	Sequence #	Orientation	Specific face
	1	Face	one of the smallest vertical faces
	2	Face	opposite small vertical face
	3	Face	one of the largest vertical faces
4	Face	opposite large vertical face	
3	Perform a rotational edge drop. Follow the sequence in the table below.		
	Sequence #	Action	
	1	Place the unitized load onto a flat, rigid surface such as steel or concrete.	
	2	Support any face-3 edge with a timber or support 3.5 to 4.0 in (90 to 100 mm) in height and width.	
	3	Lift the opposite face-3 edge to 8 in (200 mm) off the surface.	
4	Release the edge so that it falls freely on to a flat, rigid surface.		
			
4	Repeat Step 3 on one of the bottom edges radiating 90° from the edge tested in Step 3 Sequence 3.		
5	All testing is now complete. Go to the Test Report Block.		

TEST REPORT FOR PROCEDURE 1B

The packaged-product has satisfactorily passed the test if, upon examination, it meets the Product Damage Tolerance and Package Degradation Allowance.

ISTA Certified Testing Laboratories:

- Should file a test report on all ISTA Test Procedures or Projects conducted.
- Shall file a test report on all ISTA Test Procedures or Projects conducted to obtain Transit Tested Package Certification or Acknowledgement.

For additional information, refer to *Guidelines for Selecting and Using ISTA Test Procedures and Projects*.

ISTA Transit Tested Program

The ISTA Transit Tested Certification Mark as shown is a:

- registered certification mark **and**
- can only be printed on certified packages **and**
- can only be used by license agreement **and**
- by a member of the International Safe Transit Association.

When a member prints this certification mark on a packaged-product, with their license number, they are showing their customer and the carrier that it has passed the requirements of ISTA preshipment testing.



In order to maintain its certified status and eligibility for identification with the TRANSIT TESTED Certification Mark, each packaged-product must be re-tested whenever a change is made in the:

- Product or
- Process or
- Package.

Changes in the product can include changes in:

- Design (configuration, components, accessories, etc.) **or**
- Size / weight (dimensions, shape, mass, center of gravity, etc.) **or**
- Materials (type, construction, fabrication, gage, etc.)

Changes in the process can include changes in:

- Manufacturing / assembly (vendor, location, automation, etc.) **or**
- Filling (equipment, speed, automation, etc.) **or**
- Distribution system (parcel delivery, LTL, intermodal, etc.)

Changes in the package can include changes in:

- Configuration (individual package or unit load, container type and sub-type, style, design, interior packaging, etc.) **or**
- Size / weight (dimensions, shape, mass, caliper, gage etc.) **or**
- Materials (corrugated, plastic, metal, glass, etc.) **or**
- Components (closures, labels, straps, pallets, skids, wraps, etc.)

If corrugated packaging is used, it is recommended that the basis weights of the constituent papers/paperboards be determined after testing and documented to provide the best indicator of equivalence or change.

As a quality control procedure, packaged-products should be re-tested frequently, for example, yearly.

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