AENOR N Mark Specific Rules for polyethylene (PE) bags with high reusable content for the transport of products

Note: This document is a translation of the Spanish document RP 001.89 rev. 2 approved by the Plastics Technical Certification Committee (CTC-001). Spanish version always prevails over this translation.

RP 001.89

Revision 2

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1 Object and Scope

This Particular Regulation describes, in compliance with section 3.2 of the General Regulation for the Certification of Products and Services with Mark N, hereinafter the General Regulation, the certification scheme for reusable polyethylene (PE) bags with high recycling content for the transport of products, complementing the Particular Regulation of for plastic materials - requirements common (RP 001.00).

This Regulation applies to bags according to UNE 53930 standard, that is, those bags that are intended for the transport of non-food products or previously packaged food products. In the case of food products not previously packaged, they will have to comply with current food safety legislation.

The General Regulation prevails in any case over these Particular Regulations.

The N Mark for reusable polyethylene (PE) bags with high recycling content for the transport of products, hereinafter the mark, which is a mark of conformity of these products with the UNE 53930-1:2023 and UNE 53930-2:2023.

2 Definitions and particularities

In addition to the definitions contained in the applicable regulations, the following definitions are considered applicable:

- **Material pre-consumption**: Material diverted from the waste stream during a manufacturing process.

  Note: For the calculation of the recycled content, in the case of the reincorporation of cuttings, rework materials or rejects originated within the manufacturing process, only the percentage of pre-consumer and traceable recycled material will be taken into account.

- **Material post-consumer**: Material generated in domestic, commercial, industrial or institutional facilities in their role as end users of a product, which can no longer be used for its original purpose. This excludes returns of material from the distribution chain.

  Note: For the calculation of the recycled content, in the case of the reincorporation of cuttings, rework materials or rejects originated within the manufacturing process, only the percentage of post-consumer and traceable recycled material will be taken into account.

- Reusable plastic bag: A bag that has been conceived, designed and marketed to perform multiple circuits or rotations throughout its life, being refilled or reused for the same purpose for which it was conceived.

Types of bags: Three types of bags are established in relation to their recycled material content:

- **Type I**: Plastic bag with a recycling content equal to or greater than 50% and less than 70%. Both pre-consumption and post-consumption recycling are included for the calculation of the percentage.
- **Type II**: Plastic bag with a recycling content equal to or greater than 70%. Both pre-consumption and post-consumption recycling are included for the calculation of the percentage.
- **Type III**: Plastic bag with a recycling content of more than 70%. Only post-consumer recycling is included for the calculation of the percentage.

According to the design of bags these can be:

- T-shirt bag
- Loop or rigid handle bag
- Die-cut handle bag
- Bags without handle

3 Sampling and testing for the granting and maintenance of the N Mark certificate of the product

3.1 Tests to be carried out at the factory (See RP 001.00)

During the initial or surveillance inspection visit, AENOR will carry out the tests and verifications indicated in Table 1 at the factory.

3.2 Sampling and testing to be carried out in the laboratory (See RP 001.00)

For sampling, AENOR shall reference and seal the samples necessary to carry out the tests indicated in Table 1 in the laboratory.

The manufacturer shall send the selected samples to the laboratories indicated by AENOR within 7 days since the date of the inspection visit.

TABLE 1

	TRIALS	CONCESSION/ FOLLOW-UP	RESULTS EVALUATION
TESTS TO BE CARRIED OUT IN THE LABORATORY	Thickness	5 bags per type and design maximum 10 bags, ensuring that they are of different batches	5 (1)
	Dynamic load resistance (2) Volume (3)	1 test per type / design 1 bag per type / design	1
ENVIRONMENTAL CRITERIA			
TESTS / VERIFICATIONS TO BE CARRIED OUT BY THE INSPECTOR IN THE FACTORY	Energy consumption in the manufacture of the bag	Factory checked 1 time a year	According to the manufacturer's declaration
	Carbon footprint (H.C.) (4)	Factory checked 1 time a year	1
	Use of solvents and VOC emissions	Factory checked 1 time a year AENOR, will verify the internal emissions register, and verify the last measurement made by a competent entity for it.	1
	Checking the pigment formulation	It is checked in the factory 1 time a year (both in bag and packaging)	1
	Verification percentage of recycled material used	Factory checked 1 time a year by bag types	1
	Usability and security	Factory checked 1 time a year	1

Note 1: A maximum of 10% of the measurements taken will be allowed to be out of tolerance, provided that the deviation does not exceed by default 10% of the value declared by the manufacturer.

Note 2: Except for bags without handle.

Note 3: For the dynamic load test, the determination of the volume will be carried out in accordance with point 5.1 of the UNE 53930-2 standard.

Note 4: In case of having the carbon footprint calculation with the same scope (from the extraction of raw materials until the finished product leaves the factory), it will not be necessary to use equation (1) of the UNE 53930-2 standard, as long as such calculation is certified or verified by a third party.

4 Internal controls of the manufacturer

4.1 Characteristics subject to control

The characteristics under control relate to:

- Raw materials: When the raw material does not have the certificate of the N Mark of product, the manufacturer who uses it must ensure that the mixtures and compounds involved in the manufacture of the bags have adequate characteristics and must verify that the specifications of the material received meet the established purchase requirements.
- **Controls during manufacturing**: The tests and the frequency of these tests are shown in Table 2
- **Controls on the final product**: The tests and the frequency of these tests are shown in Table 2.

TABLE 2

TESTS	FREQUENCY
Thickness	1 time per shift and machine
Resistance to dynamic load	1 weekly test per manufacturing machine
ENVIRONMENTAL CRITERIA	
Energy consumption in the production of the bags	Factory checked 1 time a year
Carbon footprint (C.) (3)	Factory checked 1 time a year
Use of solvents and VOC emissions	According to the manufacturer's internal procedure (1)
Use of dyes and pigments	Factory checked 1 time a year
Checking the pigment formulation	Factory checked 1 time a year
Verification percentage of recycled material used (2)	Factory checked 1 time a year
Usability and security	Factory checked 1 time a year

Note 1: This procedure may be checked in the corresponding visits by AENOR.

Note 2: For this review, the SDS (Safety Data Sheet) of the products involved in the manufacture of the bags will be used (see point 4.2 of this Regulation).

Note 3: Calculated using equation (1) of UNE 53930-2.

4.2 Control processes on recycled material

AENOR will evaluate that the organization ensures that the incorporated recycled material meets the requirements established by the transformer. For it, to this purpose it will be necessary to document the origin, traceability and quantities of the recycled material included in the production of the bags. To verify the quantity of raw material, the transformer will present a mass balance which will be submitted to the verification process The origin and traceability documentary control, can be evidenced by means of an AENOR product certificate for recycled plastics in accordance with the reference standard UNE EN 15343. Failing this, the documentation provided by the supplier will be reviewed, in which the origin of the recycled material, its classification, transport and the tests carried out for each specification are assured if necessary.

5 Certified system marking

Customers with valid certificates will not be able to market the certified product without the marking described below.

The marking on the bags shall include at least the following:

— Reference to the word AENOR;

— N Mark logotype ;

— AENOR Certificate number: 001/XXX;

— Production batch;

— The logo according to the type of bag I, II or III, with minimum dimensions of 24 mm x 34 mm (as indicated by Standard UNE 53930-2).

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Annex C

Questionnaire descriptive of polyethylene (PE) bags with high content in recycling for transport of products

(one application by bag type and material)

CUSTOMER:

PLACE OF MANUFACTURE:

PRODUCT:

TYPES OF BAG:

☐ TYPE I	BOLSAS T-SHIRT	☐
	LOOP HANDLE BAGS	☐
	DIE-CUT HANDLE BAGS	☐
	BAG WITHOUT HANDLE	☐
☐ TYPE II	BOLSAS T-SHIRT	☐
	LOOP HANDLE BAGS	☐
	DIE-CUT HANDLE BAGS	☐
	BAG WITHOUT HANDLE	☐
☐ TYPE III	BOLSAS T-SHIRT	☐
	LOOP HANDLE BAGS	☐
	DIE-CUT HANDLE BAGS	☐
	BAG WITHOUT HANDLE	☐

STANDARD:

TRADEMARK:

INKS AND PIGMENTS:

List of suppliers of inks and pigments and references of the pigments used:

For any modification of the manufacturing range, the customer will send this updated descriptive questionnaire in duplicate to the Committee Secretariat.

In ..... to..... of ..... of 20....

SIGNATURE AND SEAL OF THE MANUFACTURER