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## **DRAFT EAST AFRICAN STANDARD**

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**Facial tissue paper — Specification**

**EAST AFRICAN COMMUNITY**

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## Foreword

Development of the East African Standards has been necessitated by the need for harmonizing requirements governing quality of products and services in the East African Community. It is envisaged that through harmonized standardization, trade barriers that are encountered when goods and services are exchanged within the Community will be removed.

The Community has established an East African Standards Committee (EASC) mandated to develop and issue East African Standards (EAS). The Committee is composed of representatives of the National Standards Bodies in Partner States, together with the representatives from the public and private sector organizations in the community.

East African Standards are developed through Technical Committees that are representative of key stakeholders including government, academia, consumer groups, private sector and other interested parties. Draft East African Standards are circulated to stakeholders through the National Standards Bodies in the Partner States. The comments received are discussed and incorporated before finalization of standards, in accordance with the Principles and procedures for development of East African Standards.

East African Standards are subject to review, to keep pace with technological advances. Users of the East African Standards are therefore expected to ensure that they always have the latest versions of the standards they are implementing.

The committee responsible for this document is Technical Committee EASC/TC 065, Paper and paper Products.

Attention is drawn to the possibility that some of the elements of this document may be subject of patent rights. EAC shall not be held responsible for identifying any or all such patent rights.

This second edition cancels and replaces the first edition (EAS 862:2017), which has been technically revised. The main changes compared to the previous edition are as follows:

Under Table 1, the following changes have been made:

- the grammages for virgin, blended and recycled facial tissues have been differentiated
- the units of Tensile strength have been changed to N/m
- the parameter “Water absorptiveness, g/m<sup>2</sup>” has been changed to “Water absorption rate, mm/min.”
- In Table 2, more dimensions and number of sheets were included

## Facial tissue paper — Specification

### 1 Scope

This Draft East African Standard specifies requirements, sampling and test methods for facial tissue paper in sheet form for facial hygiene.

### 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 187, *Paper board and pulps — Standard atmosphere for conditioning and testing and procedure for monitoring the atmosphere and conditioning of samples*

ISO 287, *Paper and board — Determination of moisture content of a lot — Oven-drying method*

ISO 6588-1, *Paper, board and pulps — Determination of pH of aqueous extracts — Part 1: Cold extraction*

ISO 11093-4, *Paper and board — Testing of cores — Part 4: Measurement of dimensions*

ISO 12625-1, *Tissue paper and tissue products — Part 1: General guidance on terms*

ISO 12625-4, *Tissue paper and tissue products — Part 4: Determination of tensile strength, stretch at break and tensile energy absorption*

ISO 12625-5, *Tissue paper and tissue products — Part 5: Determination of wet tensile strength*

ISO 12625-6, *Tissue paper and tissue products — Part 6: Determination of grammage*

ISO 12625-7, *Tissue paper and tissue products — Part 7: Determination of optical properties — Measurement of brightness and colour with D65/10 ° (outdoor daylight)*

ISO 12625-8, *Tissue paper and tissue products — Part 8: Water-absorption time and water-capacity, basket immersion test method.*

### 3 Terms and definitions

For the purposes of this document, the following terms and definitions and those in ISO 12625-1 shall apply.

#### 3.1

##### **cross-direction (CD)**

direction in the plane of a paper perpendicular to the machine direction

#### 3.2

##### **machine direction (MD)**

direction in a paper or a board parallel to the direction of travel of the web on the paper or board machine

- 3.3 holder**  
package of facial tissue paper of the same dimensions and colour
- 3.4 lot**  
aggregate of facial tissue paper of a single kind and size and having same or different colours. A lot comprises of one or more similar cartons, each of which contains one, or more packages or boxes packed with facial tissue of the same kind
- 3.5 sheet**  
two or more plies of facial tissue paper in rectangular form
- 3.6 hole**  
area in the sheet void of fibres and having a specified diameter

## **4 Requirements**

### **4.1 General requirements**

#### **4.1.1 Material**

- 4.1.1.1** Facial tissue paper shall be made from processed virgin pulp, blended or recycled pulp.
- 4.1.1.2** All ingredients including dyes and other additives used in the manufacture and packaging of facial tissue paper shall not cause irritation of the skin.
- 4.1.1.3** Facial tissue paper shall be:
- a) white or coloured;
  - b) creped and highly absorbent; and
  - c) free from defects such as abrasive particles, lint, fibre bundles, holes and specks.
- 4.1.1.4** It may be perfumed.
- 4.1.1.5** Facial tissue paper shall not at any time during manufacture and packing be exposed to conditions that do not conform to good hygienic practice.

### **4.2 Specific requirements**

The facial tissue paper shall comply with the requirements given in Table 1 when tested in accordance with the methods specified therein.

**Table 1 — Specific requirements for facial tissue paper**

| S/No.   | Property   | Requirement | Test method <sup>a</sup> |             |
|---|--|-------------|--------------------------|-------------|
| i.  | Grammage per ply, g/m <sup>2</sup> , Min.          | Virgin      | 12                       | ISO 12625-6 |
|   |  | Blended     | 13                       |             |
|   |  | Recycled    | 14                       |             |
| ii.   | Tensile strength for single ply ,dry, N/m, Min.    | C.D         | 96                       | ISO 12625-4 |
|   |  | M.D         | 188                      |             |
|   | Tensile strength for single ply, wet, N/m, Min.    | M.D         | 45                       | ISO 12625-5 |
| iv.   | Average brightness, %, Min. (white facial tissues) |             | 78                       | ISO 12625-7 |
| v.  | pH value   |             | 5.5 - 8.5                | ISO 6588-1  |
| vi.   | Moisture content, %                                |             | 4.0 - 7.0                | ISO 287     |
| vii.  | Water absorption rate, mm/min. Min.                |             | 20                       | ISO 12625-8 |
| <sup>a</sup> Conditioning shall be done in accordance with ISO 187. |  |             |                          |             |

### 4.3 Dimensional requirements

4.3.1 The size of the facial tissues shall be as given in Table 2 when tested in accordance with ISO 11093-4.

**Table 2 — Requirements for sheet dimensions and number of sheets**

| S/No. | Sizes, $\pm 3$ , mm | Minimum number of sheets per pack |
|-------|---------------------|-----------------------------------|
| i.    | 200 by 215          | 70                                |
| ii.   | 200 by 200          | 10                                |
| iii.  | 140 by 200          | 40                                |
| iv.   | 100 by 200          | 50                                |
| v     | 150 by 200          | 50                                |
| vi    | 180 by 200          | 70                                |
| vii   | 300 by 200          | 20                                |

4.3.2 Tolerance on the declared number of sheets specified in Table 2 shall be  $\pm 1$  sheet.

4.3.3 The average number of holes less than 2 mm in diameter in sheets shall not exceed 10 per sheet.



4.3.4 Each facial tissue shall comply with microbial requirements on Table 4 when tested in accordance with the method specified therein.

**Table 4 — Microbiological limits for facial tissues**

| S/No | Characteristic                        | Limit                                | Test method |
|------|---------------------------------------|--------------------------------------|-------------|
| i    | Total plate count, cfu/g Max.         | 300                                  | ISO 8784-1  |
| ii   | <i>Pseudomonas aeruginosa</i> , cfu/g | Not detectable in 1 g of the product |             |
| iii  | <i>Staphylococcus aureus</i> , cfu/g  |                                      |             |
| iv   | <i>Candida albicans</i> , cfu/g       |                                      |             |
| v    | <i>Escherichia coli</i> , cfu/g       |                                      |             |

## 5 Packaging and labelling

### 5.1 Packaging

Sheets shall be packed in holders. The number of sheets for each type is given in Table 4, Column 4 and shall not be less than the nominal quantity marked on the holder. Sheets of the same size and colour shall be packed together in a holder.

### 5.2 Labelling

#### 5.2.1 Holders

The following information shall be marked legibly and indelibly on the outside of each holder:

- a) name of the product as “Facial tissue paper”;
- b) manufacturer’s name and physical address;
- c) registered trade mark;
- d) number of plies;
- e) description of fibre composition (virgin, blended or recycled);
- f) number of sheets, size and colour (s). If more than one colour then the term multi-colour may be used in lieu;
- g) country of origin/manufacture; and
- h) perfumed, if applicable.

#### 5.2.2 Bulk packages

The following information shall be legibly and indelibly marked on the outside of each bulk packages:

- a) information required in 5.2.1 a) to h);
- b) number of holders in the bulk package; and

c) batch number/code

## 6 Sampling

### 6.1 General

The sampling shall be done in accordance with Table 4 to determine whether a lot complies with the relevant requirements of the specification. The samples so taken shall be deemed to represent the lot for the respective properties.

### 6.2 Sampling for facial tissue paper

Samples shall be drawn at random as indicated in Table 4 and tested for compliance with the requirements of this standard

**Table 4 — Sampling of bulk containers/ packages**

| S/No. | Lot size, holders | Sample for visual inspection |         | Sample for test, holders |
|-------|-------------------|------------------------------|---------|--------------------------|
|       |                   | Bulk packages                | Holders |                          |
| i.    | 10 – 100          | 1                            | 4       | 4                        |
| ii.   | 101 – 300         | 2                            | 6       | 5                        |
| iii.  | 301 – 1000        | 4                            | 8       | 6                        |
| iv.   | 1001 – 4000       | 6                            | 12      | 7                        |
| v.    | 4001 – 10000      | 8                            | 16      | 8                        |
| vi.   | More than 10000   | 11                           | 22      | 9                        |

## Bibliography

KS 1999:2007, *Facial tissue paper — Specification*

Public Review Draft

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