

# ISO 18613:2014-11 (E)

## Pallets for materials handling - Repair of flat wooden pallets

---

<b>Contents</b>		<b>Page</b>
Foreword .....		iv
Introduction .....		v
<b>1</b>	<b>Scope .....</b>	<b>1</b>
<b>2</b>	<b>Normative references .....</b>	<b>1</b>
<b>3</b>	<b>Terms and definitions .....</b>	<b>1</b>
<b>4</b>	<b>Defects and damage criteria .....</b>	<b>2</b>
<b>4.1</b>	<b>Overriding criterion .....</b>	<b>2</b>
<b>4.2</b>	<b>Nail joint strength .....</b>	<b>2</b>
<b>4.3</b>	<b>Inspection .....</b>	<b>2</b>
<b>4.4</b>	<b>General conditions identifying an unacceptable pallet .....</b>	<b>2</b>
<b>5</b>	<b>Repair .....</b>	<b>2</b>
<b>5.1</b>	<b>General .....</b>	<b>2</b>
<b>5.2</b>	<b>Repair of pallets of known specification .....</b>	<b>3</b>
<b>5.3</b>	<b>Repair of pallets of unknown specification .....</b>	<b>3</b>
<b>5.4</b>	<b>Marking .....</b>	<b>5</b>
<b>5.5</b>	<b>Final inspection of repaired pallets .....</b>	<b>5</b>
<b>6</b>	<b>Recycling - disposal .....</b>	<b>5</b>
	<b>Annex A (informative) Defects and damage which make a 4-way block pallet unacceptable for use ...</b>	<b>6</b>
	<b>Annex B (informative) Defects and damage which make a perimeter base pallet unacceptable for use .....</b>	<b>8</b>
	<b>Annex C (informative) Defects and damage which make a 2-way stringer (bearer) pallet unacceptable for use .....</b>	<b>10</b>
	<b>Annex D (informative) Defects or damage which make a partial 4-way pallet unacceptable for use ...</b>	<b>11</b>
	<b>Annex E (normative) Metal plates for repairing of notched stringers (bearers) .....</b>	<b>13</b>
	<b>Annex F (informative) Action needed for the repair of pallets of unknown specification .....</b>	<b>15</b>
	<b>Annex G (informative) Special accuracy and tolerance for repaired pallets (e.g. for use in certain automatic handling systems) .....</b>	<b>16</b>
	<b>Bibliography .....</b>	<b>17</b>