Production of EPAL Euro pallets

The production of EPAL Euro pallets is only permitted with a valid EPAL licence.

On the day of the evaluation visit, you must have the following work materials and documents:

- an equipped production facility
- a site plan of the business operation
- a copy of your ISPM 15 registration document
- a drying chamber
  alternatively: purchase of pre-treated wood according to IPPC Standard ISPM 15
- various tools (saws, etc.)
- various machines, if not integrated into a production line
  - cutting machines for boards (alternatively: buy in boards)
  - cutting machines for blocks (alternatively: buy in blocks)
  - planing machine (not strictly necessary)
  - nailing machine for legs
  - nailing machine for top deck sub-assemblies of pallets
  - chamfering equipment for bottom boards
  - branding device with branding plates / EPAL-approved inkjet printing system for marking pallets
  - equipment for chamfering pallet corners

Manual production is possible as an alternative to machine production. Then the following are compulsory:

- dimensionally accurate templates for leg production
- dimensionally accurate templates for top deck sub assembly production
- a dimensionally accurate template for assembly
- dimensionally accurate templates for nail positioning
- nailing guns for the respective EPAL-approved nails

The following apply to both production types:

- dimensionally accurate materials
- approved nails in accordance with the Directory of EPAL-approved manufacturers of nails
- a copy of the EPAL Technical Regulations
- a wood moisture meter
- 100 units of EPAL Euro pallets newly produced by you (using the production type applied for) as test models
  - a 1,500 mm-long digital workshop calliper
  - a 300 mm-long digital calliper
  Or alternatively:
    - a calibrated measuring gauge (min. to max.) for the board thickness
    - a calibrated measuring gauge (min. to max.) for the board width
    - a calibrated measuring gauge (min. to max.) for the total length and total width
    - a calibrated measuring gauge (min. to max.) for the distances between the intermediate deck boards
    - a calibrated measuring gauge (min. to max.) for the inner dimensions (including central bottom leg)
    - a calibrated measuring gauge (min. to max.) for the entry height
    - a staple gun (not compulsory, but useful); if you don’t have a staple gun, EPAL will invoice you
      the additional time spent by the inspection company
THE OPEN PALLETS POOL.

The image contains diagrams of wooden pallets with dimensions and tolerances specified in millimeters.