



## 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

