

## Chapter Ag 119

## CHEESE BOXES AND HOOPS

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**Ag 119.01 Definitions.** As used herein:

- (1) "Department" means the State Department of Agriculture.
- (2) "Cheese" means cheddar, granular, colby and washed curd cheese with rind development.
- (3) "Boxes" means wood boxes used as receptacles for cheese.
- (4) "Diameter" means, with respect to cheese, the diameter of the larger round end.

**History:** Cr. Register, June, 1958, No. 30, eff. 7-1-58.

**Ag 119.02 Cheese styles.** The cylindrical box and hoop standards prescribed in this chapter are for cheese of traditional styles, described as follows:

(1) **CHEDDAR.** Cheddar style cheese shall be 14½ inches in diameter, and should weigh 70 to 78 pounds each, but shall not exceed 78 pounds.

(2) **TWIN.** Single twin cheese shall be 14½ inches in diameter, and should weigh 32 to 37 pounds, but in no case shall weigh 38 pounds or over. A pair of cheese in a box should be practically uniform in size, and should weigh from 64 to 74 pounds.

(3) **DAISY.** Daisy style cheese shall be 13½ inches in diameter, and should weigh 20 to 22 pounds, but in no case shall weigh 23 pounds or over.

(4) **LONGHORN.** Longhorn style cheese shall be 6 inches in diameter, and each cheese in a box of 4 longhorn cheese shall be practically uniform in size. In no case shall the total weight exceed 53 pounds.

(5) **YOUNG AMERICAN.** Young American style cheese shall be 7 inches in diameter, and each cheese in a box of 4 young American cheese shall be practically uniform in size. In no case shall the total weight exceed 48 pounds.

(6) **COMMODORE, MIDGET, JUNIOR TWIN.** Each cheese shall be 9¼ inches in diameter. Each cheese should weigh 11 to 12 pounds, and in no event shall exceed 12½ pounds. A pair of cheese in a box should be practically uniform in size and should weigh 22 to 24 pounds, but in no case shall exceed 25 pounds.

**History:** Cr. Register, June, 1958, No. 30, eff. 7-1-58.

**Ag 119.03 Cheese hoops.** Cheese hoops shall be of such size and shape that the cheese molded therein will conform to a cheese style described in section Ag 119.02.

**History:** Cr. Register, June, 1958, No. 30, eff. 7-1-58.

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**Ag 119.04 Cylindrical boxes.** (1) The inside measurements of commercially dry boxes for cheese shall be as follows:

(a) Cheddar and twin boxes shall be 15 inches in diameter; height of said boxes shall be 12 inches, with a permitted tolerance of  $\frac{1}{4}$  inch from this measurement.

(b) Single daisy boxes shall be 14 inches in diameter; height of said boxes shall be  $4\frac{1}{4}$  inches, with a permitted tolerance of  $\frac{1}{8}$  inch from this measurement.

(c) Double daisy boxes shall be 14 inches in diameter; height of said boxes shall be  $8\frac{1}{2}$  inches, with a permitted tolerance of  $\frac{1}{4}$  inch from this measurement.

(d) Longhorn boxes (4 in a box) shall be  $14\frac{1}{2}$  inches in diameter; height of said boxes shall be  $13\frac{1}{4}$  inches, with a permitted tolerance of  $\frac{1}{4}$  inch from this measurement.

(e) Young American boxes (4 in a box) shall be 17 inches in diameter; height of said boxes shall be  $8\frac{3}{4}$  inches, with a permitted tolerance of  $\frac{1}{8}$  inch from this measurement.

(f) Flat boxes (single) shall be 15 inches in diameter; height of said boxes shall be  $6\frac{1}{8}$  inches, with a permitted tolerance of  $\frac{1}{8}$  inch from this measurement.

(g) Commodore, midget and junior twin boxes shall be  $10\frac{1}{4}$  inches in diameter; height of said boxes shall be  $4\frac{1}{2}$  inches, with a permitted tolerance of  $\frac{1}{8}$  inch from this measurement. Boxes for 2 cheese of this type placed in a box shall be  $10\frac{1}{4}$  inches in diameter; height of said boxes shall be 9 inches, with a permitted tolerance of  $\frac{1}{8}$  inch from this measurement; provided, that boxes of this type manufactured for colby cheese may be of a height of  $9\frac{1}{2}$  inches, with a permitted tolerance of  $\frac{1}{8}$  inch.

(2) Cylindrical boxes for cheese shall also conform to the following specifications:

(a) Boxes shall be made of sound material, free from defects that materially lessen their strength.

(b) Workmanship and placing of fasteners shall be such that will make all parts of the box sufficiently strong.

(c) Heading shall be not less than  $\frac{1}{16}$  inch thick, dressed on one side at least, and shall be commercially dry, having not more than 18 per cent of moisture when cut into circular form and when assembled. Such assembled boxes shall not be sold, delivered or used until all parts are commercially dry.

(d) Heading shall be matched with tongue and groove well fitted. Said tongue and groove shall be not less than  $\frac{5}{16}$  inch and not more than  $\frac{3}{8}$  inch in depth and length, respectively.

(e) Bottom heading shall be made of not more than 4 pieces, not counting outside pieces less than  $1\frac{1}{4}$  inches wide.

(f) Cover heading shall be made of not more than 5 pieces, not counting the outside pieces less than  $1\frac{1}{4}$  inches wide.

(g) The veneer used in boxes throughout shall be single ply, at least  $\frac{1}{6}$  inch thick, or 2-ply each at least  $\frac{1}{12}$  inch thick.

(h) Boxes of height similar to twin, cheddar and longhorn shall, when 2-ply veneer is used, be reinforced with 5 strips to each box, such strips to be at least 5 inches wide and at least  $\frac{1}{12}$  inch thick and equally spaced, or the equivalent of 5 such strips. Such strips shall be placed flush with the bottom edge of the outer plies of veneer and shall extend 12 inches above the bottom edge of the bottom

heading and shall be fastened to the other plies with tacks or staples to hold them in place. The lap in the veneer forming the body of the box shall apply as a sixth reinforcement strip.

(i) Body veneer shall overlap not less than 3 inches and shall be fastened with either tacks or staples spaced not more than 1 inch apart, such fasteners to be well clinched in the inside of the box.

(j) All cover bands, except for daisy boxes, shall be  $2\frac{1}{4}$  inches wide, with a permitted tolerance of  $\frac{1}{8}$  inch from this measurement.

(k) Cover bands for daisy boxes shall be 2 inches wide, with a permitted tolerance of  $\frac{1}{8}$  inch from this measurement.

(m) Nails required by this section shall be the common wire type. Tacks shall be small, short, sharp pointed nails having broad flat heads. Staples required by this section are U-shaped, having two points.

(n) Nails shall be spaced not more than 4 inches apart when fastening cover bands to cover heading or bottom band and box sides to bottom heading, not counting nails entering lumber joints or cracks. Twin, cheddar, flat, longhorn and double daisy boxes shall have at least 14 nails to fasten cover bands to cover heading, and at least 14 nails to fasten bottom band and box sides to bottom heading. Boxes larger than 15 inches in diameter up to and including boxes of the size to hold 4 young American cheese shall have at least 16 nails to fasten cover band to cover heading and at least 16 nails to fasten bottom band and box sides to bottom heading.

(o) Nails not shorter than 1 inch and not lighter than 15 gauge or staples not lighter than 18 gauge nor with less than 1 inch long prongs, shall be used to fasten bands to cover heading.

(p) Bottom bands shall be at least 1 inch wide and not more than  $1\frac{1}{2}$  inches wide, except in the case of single daisy boxes where the bottom band shall not be over  $1\frac{1}{8}$  inches wide.

(q) Nails not shorter than  $1\frac{1}{8}$  inch and not lighter than 15 gauge shall be used to fasten bottom bands, box sides, and reinforcement strips to bottom heading.

(r) All boxes shall be securely nailed or bound together to properly carry the load intended for them. Workmanship and placing of fasteners must be such as will make all parts of the box sufficiently strong.

(s) Name and address of the manufacturer shall be plainly stamped or impressed on the body of all boxes covered by these standards in type at least  $\frac{1}{4}$  inch high.

(t) In cases where boxes are manufactured in Wisconsin for export to foreign countries, such boxes shall be manufactured in accordance with the federal regulations if the specifications therein are different than the Wisconsin specifications which would otherwise be applicable.

**History:** Cr. Register, June, 1958, No. 30, eff. 7-1-58.

**Ag 119.05 Rectangular boxes.** (1) Boxes for two 10-pound square prints, or four 5-pound loaves, or eight  $2\frac{1}{2}$ -pound loaves, shall be  $14\frac{1}{4}$  inches by  $11\frac{1}{2}$  inches by  $3\frac{3}{4}$  inches, inside measurement.

(2) Rectangular boxes for cheese shall also conform to the following specifications:

(a) Boxes shall be made of sound material free from defects that materially lessen their strength.

(b) Boxes covered in this section shall be made of sawed stock. Veneer covers which will not seriously warp or buckle may be used.

(c) Each end and each side shall be made of one piece, which end and side shall be at least  $\frac{1}{8}$  inch thick, dressed on at least one side.

(d) Covers of sawed stock and bottoms shall be not less than  $\frac{1}{2}$  inch thick and shall be made of not more than three pieces each.

(e) Covers shall be so prepared by the manufacturers as to reach the user with each unit assembled.

(f) Each box shall be nailed with not less than 44 wire nails not lighter than 15 gauge, which shall be applied as follows:

1. Not less than 3 nails to each joint shall be used in fastening sides to ends, which nails shall be not less than  $1\frac{1}{8}$  inch long.

2. Not less than 6 nails at least 1 inch long shall be used to fasten each end of each cover and each end of each bottom to the sides of the box.

3. Not less than 2 nails at least 1 inch long shall be used to fasten each side of each cover and each side of each bottom to the box.

(g) The use of cleats shall be optional with the user.

(h) Name and address of the manufacturer shall be plainly stamped or impressed on the end of square print boxes in type at least  $\frac{1}{4}$  inch high.

**History:** Cr. Register, June, 1958, No. 30, eff. 7-1-58.

**Ag 119.06 New type boxes.** To permit progress in the boxing of cheese, types of boxes other than those prescribed in this chapter may be used for a limited time as an experiment to determine whether the box is practical, provided it is done after complete specifications have been given to the department and the department has given its consent to such experimentation. If at any time the department feels that the box being used in the experiment is not satisfactory, it may withdraw its consent and further use of the box shall be discontinued forthwith. If the box is found to be satisfactory, the department may authorize its general use.

**History:** Cr. Register, June, 1958, No. 30, eff. 7-1-58.

**Ag 119.07 Used boxes.** (1) All boxes that have been used as containers for cheese, before being used again in the marketing or transporting of cheese, shall be reconditioned so as to be clean and sanitary and free from adhering material, objectionable odors and mold, and shall be marked by the reconditioner on the lower band, in case of cylindrical boxes; and on the end piece, in case of rectangular shaped boxes; and on the side where other markings are usually applied, with the used box stamp as herein provided.

(2) Before such used boxes are again used in the marketing or transporting of cheese, all markings on such boxes shall be removed, except the marking used to designate the original manufacturer of each box, and except that all marks for used boxes herein provided for shall be left thereon.

(3) Any person desiring to recondition used boxes shall make application to the department for a used box marking stamp. Each such stamp shall remain the property of the department and shall include the words "Used Box" and letters or figures, or both, identifying such reconditioner.

(4) Every person who uses a used box as a container for marketing or transporting cheese shall cancel it with a heavy indelible pencil mark in the form of an X through the last reconditioner's

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identifying letters and figures in the used box marking thereon as soon as he has placed cheese in the same.

(5) Every person who buys or receives any used boxes shall keep available for inspection by the department all invoices of all used boxes bought or received by him.

(6) No person shall buy, receive, use or have in possession with intent to use for marketing or transporting cheese, and no person shall sell, offer for sale, or deliver, or have in possession with intent to sell, or to offer for sale, or deliver, for use in marketing or transporting cheese, any used box which does not conform to these standards or which does not bear the used box markings identifying all the reconditioners thereof as herein required, one of which markings shall be uncanceled; provided, that such boxes coming from outside the state of Wisconsin may be so used or possessed if each such box is plainly and conspicuously marked with the name and address of the manufacturer on the body of the box in type at least  $\frac{1}{4}$  inch high, and if each such box which does not conform to these standards is plainly and conspicuously marked on the body of the box in type at least  $\frac{1}{4}$  inch high with the words: "Used box not up to Wisconsin standards".

**History:** Cr. Register, June, 1958, No. 30, eff. 7-1-58.

**Note:** The rules adopted herein to constitute a separate chapter of the Wisconsin administrative code are substantially the same as the rules relating to cheese boxes and hoops contained heretofore in sections Ag 81.09 to Ag 81.14, inc.

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