



Designation: D6535/D6535M – 18

Standard Practice for Determining the Dip Tube Length of a Mechanical Pump Dispenser¹

This standard is issued under the fixed designation D6535/D6535M; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This practice covers the determination technique for a dip tube of a mechanical pump dispenser.

1.2 The values stated in either SI units or inch-pound units are to be regarded separately as standard. The values stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Significance and Use

2.1 This practice is to be used to determine the length of a dip tube of a mechanical pump dispenser that extends to the bottom-corner of a container.

2.2 This practice is to be used to determine the length of a dip tube of a mechanical pump dispenser that extends to the bottom-center of a container.

3. Apparatus

3.1 *Thin Metal Ruler*, with minimum gradients of one millimeter and/or $\frac{1}{16}$ in. along with a zero index at the end of the ruler.

3.2 *Calipers*.

¹ This practice is under the jurisdiction of ASTM Committee F02 on Primary Barrier Packaging and is the direct responsibility of Subcommittee F02.30 on Mechanical Dispensers.

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4. Procedure

PRACTICE “A”—DIP TUBE LENGTH DETERMINATION TO THE BOTTOM-CORNER OF THE CONTAINER

NOTE 1—This practice is used when the dip tube of a mechanical pump dispenser must extend to the bottom-corner of a container.

4.1 Place the zero-index end of the ruler into the container as shown in Fig. 1.

4.2 Turn the ruler so that the side of the ruler reaches as far into the bottom-corner of the container as possible.

NOTE 2—If the cross-sectional area of the container is not round, position the ruler into the farthest bottom-corner of the container.

4.3 Adjust the ruler so that it is positioned through the center axis of the container opening.

4.4 Measure the dip tube length to within 1 mm or $\frac{1}{16}$ in. If the measurement value is between the whole millimetre or $\frac{1}{16}$ in. gradient, use the larger value (that is, if measurement is 118.5 mm, use 119 mm; or if measurement is $4\frac{21}{32}$ in., use $4\frac{11}{16}$ in.).

4.5 If the dip tube measurement is in millimetres, subtract 1 mm from the measured value. If the dip tube measurement is in inches, subtract $\frac{1}{16}$ in. from the measured value.

4.6 Record the net value (original value minus 1 mm or $\frac{1}{16}$ in.).

4.7 To verify the new dip tube specification, prepare a sample mechanical pump dispenser with the newly-specified dip tube length.

4.8 Secure the mechanical pump dispenser to the container.

4.9 Verify that the end of the dip tube is not closed-off by the bottom or side of the container.

4.10 To specify the exposed dip tube length, measure the length of the exposed body as per dimension “Y” of Fig. 2 and subtract from the overall length as specified in 4.6.

NOTE 3—If the container is not transparent, a section of the bottom of the container may need to be removed so that the position of the end of the dip tube may be viewed.