SLOVENSKI STANDARD
SIST EN 14847:2006

01-februar-2006

Embalaža za aerosole - Posode iz bele pločevine - Mere za 25,4-milimetrsko odprtino

Aerosol containers - Tinplate containers - Dimensions of the 25,4 mm aperture

Aerosolverpackungen - Behälter aus Weißblech - Maße der 25,4 mm weiten Öffnung

Récipients pour aérosols - Récipients en fer blanc - Dimensions des boîtiers avec ouverture de 25,4 mm

Ta slovenski standard je istoveten z: **EN 14847:2005**

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55.130 Pločevinke za aerosole Aerosol containers

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English Version

Aerosol containers - Tinplate containers - Dimensions of the 25,4 mm aperture

Récipients pour aérosols - Récipients en fer blanc - Dimensions des boîtiers avec ouverture de 25,4 mm (un pouce)

Aerosolpackungen - Behälter aus Weißblech - Maße der 25,4 mm (ein Zoll) weiten Öffnung

This European Standard was approved by CEN on 14 October 2005.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: rue de Stassart, 36 B-1050 Brussels

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Contents

Foreword

This document (EN 14847:2005) has been prepared by Technical Committee CEN/TC 261 “Packaging”, the secretariat of which is held by AFNOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by May 2006, and conflicting national standards shall be withdrawn at the latest by May 2006.

This draft European Standard is one of a series of thirteen related standards with the following titles:

EN 14847, *Aerosol containers — Tinplate containers — Dimensions of the 25,4 mm aperture*.

EN 14848, *Aerosol containers — Metal containers with 25,4 mm aperture — Dimensions of valve cups.*

EN 14849, *Aerosol containers — Glass containers — Dimensions of aerosol valve ferrules*.

EN 14850, *Aerosol containers — Metal containers with 25,4 mm aperture — Measurement of contact height*.

EN 14851, *Aerosol containers — Aerosol foam flammability test*.

EN 14852, *Aerosol containers — Determination of the ignition distance of the spray j*et.

EN 14853, *Aerosol containers — Enclosed space ignition test*.

EN 14854, *Aerosol containers — Glass containers — Dimensions of the neck finish*.

prEN 15006*, Metal aerosol containers — Aluminium containers — Dimensions of the 25,4 mm (one inch) aperture*.

prEN 15007, *Metal aerosol containers — Tinplate containers — Dimensions of three-piece cans*.

prEN 15008, *Metal aerosol containers —Dimensions of 1-piece aluminium can with 25,4 mm aperture*.

prEN 15009, *Aerosol containers — Bicompartmented aerosol containers*.

prEN 15010, *Aerosol containers — Aluminium containers — Tolerances of the fundamental dimensions in connection with the clinch.*

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

Introduction

The specific dimensions of 25,4 mm aperture tinplate aerosol containers given in this standard are recognized as critical in respect of closure efficiency. They are important to the manufacturer in process control and to the filler for incoming goods inspection and ultimately clinch setting and control.

Radii and angles in the contact area of the clinch are affected by the destructive examination of containers required to check them. Specification of these dimensions has therefore been abandoned in favour of contour definition in terms of inside and outside diameters and also contact height and shoulder height.

1 Scope

This European Standard specifies the following dimensions of tinplate metal aerosol cans with 25,4 mm aperture: contact height, outside diameter, inside diameter and shoulder height. It is intended to be used with EN 14848 for clinching with valve cups.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

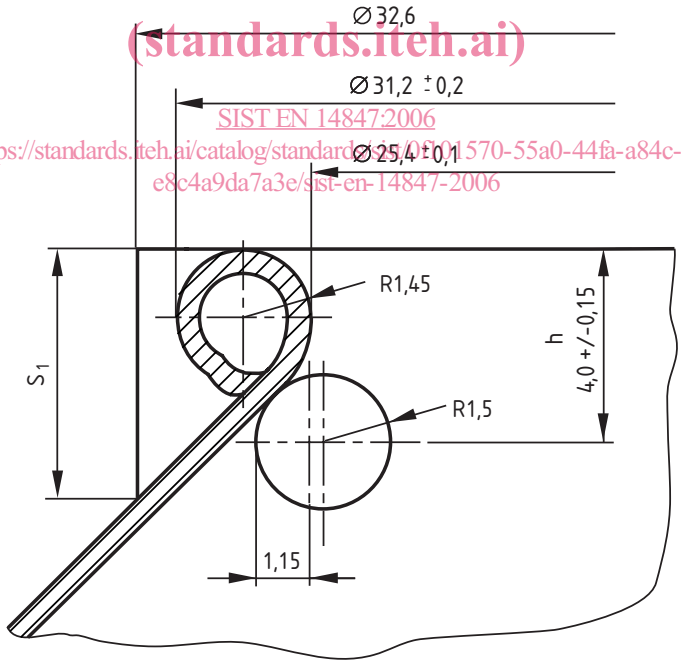
EN 14850, *Aerosol containers — Metal containers with 25,4 mm aperture — Measurement of contact height*.

3 Requirements for specifying and measuring

3.1 Dimensions of the 25,4 aperture

The dimension of the 25,4 mm aperture shall be as shown in Figure 1.

Dimensions in millimetres



Key

S_1 Shoulder height

h Contact height

Figure 1 — Dimensions of the 25,4 mm aperture

3.2 Contact height

NOTE Gauges for the measurement of contact height are commercially available.

Measure the contact height at 3 equidistant points around the aperture of each test can using the method given in EN 14850.

Record the mean value of the contact height (i.e. the arithmetic mean of the 3 values), together with maximum and minimum values.

The difference between the 3 values measured on the same can shall not be more than 0,2 mm and the mean value for the batch of cans tested shall be 4,00 mm ± 0,15 mm.

3.3 Outside diameter

Measure the outside diameter at 60 degree intervals at 3 points around the aperture of each test can.

Record the mean value of outside diameter (i.e. arithmetic mean of 3 values) together with maximum and minimum values.

NOTE The measuring instrument is commonly rotated around the can aperture for maximum and minimum values.

The outside diameter shall be as specified in Table 1.

Table 1 — Outside diameter

Dimensions in millimetres

Mean value	Maximum - Minimum	Minimum
31,2 ± 0,2[a]	≤ 0,2	≥ 31,0

[a] 0,15 for any one batch of cans.

3.4 Inside diameter

Measure the inside diameter at 60 degree intervals at 3 points around the aperture of each test can.

Record the mean value of the inside diameter (i.e. arithmetic mean of 3 values) together with maximum and minimum values. The inside diameter shall be as specified in Table 2.

Table 2 — Inside diameter

Dimensions in millimetres

Mean value	Maximum - Minimum	Minimum
25,4 ± 0,1	≤ 0,15	≥ 25,3

3.5 Measurement of shoulder height

The minimum shoulder height dimension (S_1) shall be as specified in Table 3.

NOTE This control is essential to permit the application of moulded plastic components to the skirt of the valve cup after the can has been closed.

Table 3 — Shoulder height

Dimensions in millimetres

Can diameter	Minimum S_1
45	4,00
49	4,00
52	3,00
57	3,00
65	3,00