



# SLOVENSKI STANDARD

## SIST EN 15006:2007

01-april-2007

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### Kovinska embalaža za aerosole – Posode iz aluminija – Mere za 25,4-milimetrsko (1 cola) odprtino

Metal aerosol containers - Aluminium containers - Dimensions of the 25,4 mm aperture

Aerosolpackungen - Aluminiumbehälter - Maße der 25,4 mm weiten Öffnung

Réipients métalliques pour aérosols - Réipients en aluminium - Dimensions des boîtiers avec ouverture de 25,4 mm

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Ta slovenski standard je istoveten z: **EN 15006:2006**

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#### **ICS:**

55.130	Pločevinke za aerosole	Aerosol containers
77.150.10	Aluminijski izdelki	Aluminium products

**SIST EN 15006:2007**

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EUROPEAN STANDARD

EN 15006

NORME EUROPÉENNE

EUROPÄISCHE NORM

October 2006

ICS 55.130

English Version

## Metal aerosol containers - Aluminium containers - Dimensions of the 25,4 mm aperture

Réipients métalliques pour aérosols - Réipients en aluminium - Dimensions des boîtiers avec ouverture de 25,4 mm

Aerosolpackungen - Aluminiumbehälter - Maße der 25,4 mm weiten Öffnung

This European Standard was approved by CEN on 6 August 2006.

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, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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## Foreword

This document (EN 15006:2006) 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 April 2007, and conflicting national standards shall be withdrawn at the latest by April 2007.

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 jet*
- EN 14853, *Aerosol containers — Enclosed space ignition test*
- EN 14854, *Aerosol containers — Glass containers — Dimensions of the neck finish*
- EN 15006, *Metal aerosol containers — Aluminium containers — Dimensions of the 25,4 mm aperture*
- EN 15007, *Metal aerosol containers — Tinplate containers — Dimensions of two and three-piece cans*
- EN 15008, *Aerosol containers — Aluminium containers — Dimensions of one-piece cans with 25,4 mm aperture*
- EN 15009, *Aerosol containers — Compartmented aerosol containers*
- EN 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, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

## Introduction

The specific dimensions of 25,4 mm aperture aluminium aerosol containers given in this standard are recognized as being 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, contact height, and shoulder height.

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## 1 Scope

This European Standard specifies the following dimensions of aluminium 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

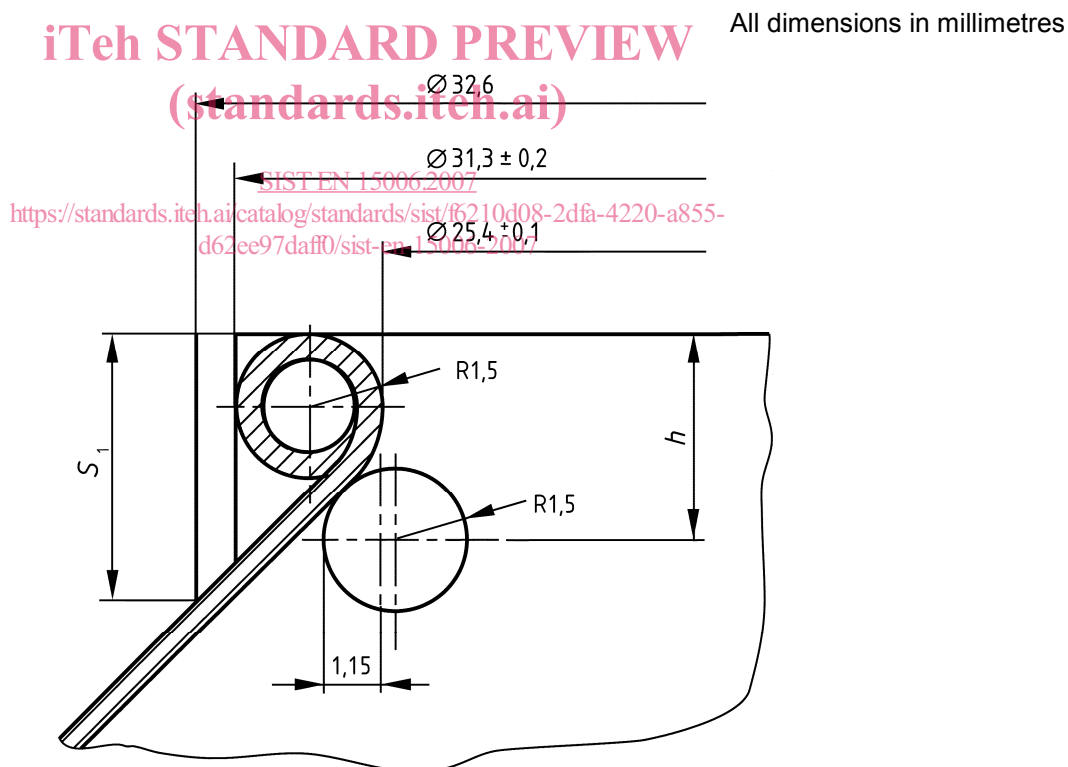
The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

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 mm aperture

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



#### Key

$S_1$  Shoulder height

$h$  Contact height

Figure 1 — Dimensions of the 25,4 mm aperture

**EN 15006:2006 (E)**

NOTE For one piece aluminium containers with a diameter greater than 50 mm, a machined can curl is recommended.

**3.2 Contact height**

NOTE 1 Gauges for the measuring 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 3 values), together with maximum and minimum values.

NOTE 2 The measuring instrument is commonly rotated around the can aperture for maximum and minimum values.

The difference between the 3 values measured on the same can shall not be more than 0,50 mm and the mean value for the batch of cans tested shall be  $(4,25 \pm 0,20)$  mm.

**3.3 Outside diameter**

Measure the outside diameter at 60° intervals at 3 points around the aperture of each test can. The interval between the 3 values for this can shall not exceed 0,4 mm.

The mean value shall be equal to  $(31,3 \pm 0,2)$  mm.

**3.4 Inside diameter**

Measure the inside diameter at 60° intervals at 3 points around the aperture of each test can. The mean value shall be  $(25,4 \pm 0,1)$  mm.

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**3.5 Shoulder height**

The control of the shoulder height dimension ( $S_1$ ) shall be as specified in Table 1.

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

**Table 1 — Shoulder height**

Dimensions in millimetres

Target $S_1$	Minimum $S_1$
5,9 (*)	4
(*) Taking into account the future harmonisation of the values at European level.	