



**SLOVENSKI STANDARD**  
**SIST EN 12708:2001**  
**01-februar-2001**

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Plug/bung closure systems for plastics containers with a nominal capacity of 20 l to 225 l

Verschlusssysteme für Kunststoff-Spundbehälter mit einem Nennvolumen von 20 l bis 225 l

**iTeh STANDARD PREVIEW**

Systemes de fermeture pour récipients en matières plastiques a bondes d'une capacité nominale de 20 l a 225 l

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Ta slovenski standard je istoveten z: **EN 12708:2000**

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**ICS:**

55.140      Ú[ åãS[ çã • \ Á[ åãÜ[ \ ^      Barrels. Drums. Canisters

**SIST EN 12708:2001**

**en**

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

EN 12708

January 2000

ICS 55.140

English version

## Plug/bung closure systems for plastics containers with a nominal capacity of 20 l to 225 l

Systèmes de fermeture pour récipients en matières plastiques à boudes d'une capacité nominale de 20 l à 225 l

Verschlusssysteme für Kunststoff-Spundbehälter mit einem Nennvolumen von 20 l bis 225 l

This European Standard was approved by CEN on 6 November 1999.

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, Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

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

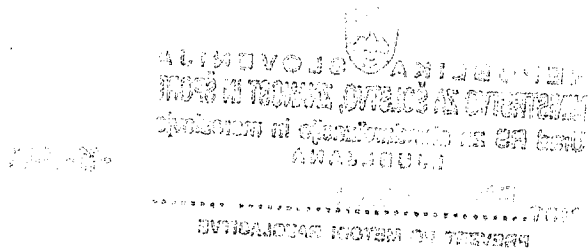
Central Secretariat: rue de Stassart, 36 B-1050 Brussels

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## Foreword

This European Standard 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 July 2000, and conflicting national standards shall be withdrawn at the latest by July 2000.

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

This standard is one of a series of standards on plastics drums of 20 l to 225 l and closures.

Efficient packaging is of great importance for the distribution and the protection of goods. Insufficient or inappropriate packaging can lead to damage or wastage of the contents of the package.

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It is recommended that where containers are to be exported to the USA, the bung closure systems should follow those generally adopted by American drum manufacturers.

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## 1. Scope

This European Standard specifies the characteristics and dimensions of plug/bung closure systems, i.e. for internally threaded plastics containers with a nominal capacity of 20 l to 225 l.

## 2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

ISO 228-1, Pipe threads where pressure-tight joints are not made on the threads — Part 1: Dimensions, tolerances and designation.

## 3. Terms and definitions

For the purposes of this standard, the following terms and definitions apply.

### 3.1

#### **plug/bung closure system (BCS)**

system of one or more components which enables an internally threaded container to be filled or emptied and then secured to provide a leakproof seal for subsequent transport or storage (see Figures 1 and 2)

### 3.2

#### **plug/bung**

device, provided with an external thread, which closes an opening in a container

### 3.3

#### **plug/bung housing or neck**

that part of the container designed to receive the plug/bung

### 3.4

#### **gasket (washer)**

component which, under compression, facilitates a leakproof seal between the plug/bung and plug/bung housing.

### 3.5

#### **gasket sealing faces**

those areas of the plug/bung or plug/bung housing designed to contact the gasket and make the seal

### 3.6

#### **cap seals/overseals**

cap or fitting attached to the plug/bung housing which incorporates a facility for providing tamper evidence and provides protection against the ingress of foreign matter into the closure

## 4. Requirements

### 4.1 Dimensions

The dimensions and tolerances of the closure systems shall be as shown in Figures 3 to 9.

Measurements shall be conducted at ambient conditions but shall not be made within 48 h of manufacture.

For plug/bung housings, diameter measurements shall be the mean of at least two readings orientated at 90° to each other.

### 4.2 Gaskets

Where used, gaskets shall be positioned correctly prior to the plug/bung being fitted to the container.

### 4.3 Closure torque

The filled container shall be closed, using the appropriate tooling, to the manufacturer's recommended closure torque. The plug/bung and neck shall be dry before closing the drum.

NOTE The manufacturer should provide information on the recommended closure torque for each type of gasket supplied.

### 4.4 Material identification symbol

All the plastics components, excluding gaskets, of the closure systems shall be permanently marked with the relevant material identification symbol, i.e. the symbol identifying the material from which the component is made.

### 4.5 Materials

The plug/bung and gasket, where used, shall be manufactured from materials appropriate to the physical and chemical requirements of their intended use.

### 4.6 Thread

All threads shall be buttress-type as shown in Figures 3 to 9.

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#### 4.7 Plug/bungs

The plug/bung shall be designed so that they can be inserted or removed by means of a simple tool.

#### 4.8 Finish

The nature of the internal and external finish of the plug/bung and gasket shall be appropriate to the physical and chemical requirements of their intended use.

NOTE The nature of the internal and external finish should be agreed between the purchaser and the supplier.

### 5. Designation

Plug/bung closure systems (BCS) manufactured in accordance with this Standard shall be designated:

Plug/bung EN 12708 BCS 70 x 6

Plug/bung EN 12708 BCS 56 x 4

Plug/bung EN 12708 BCS 38 x 6

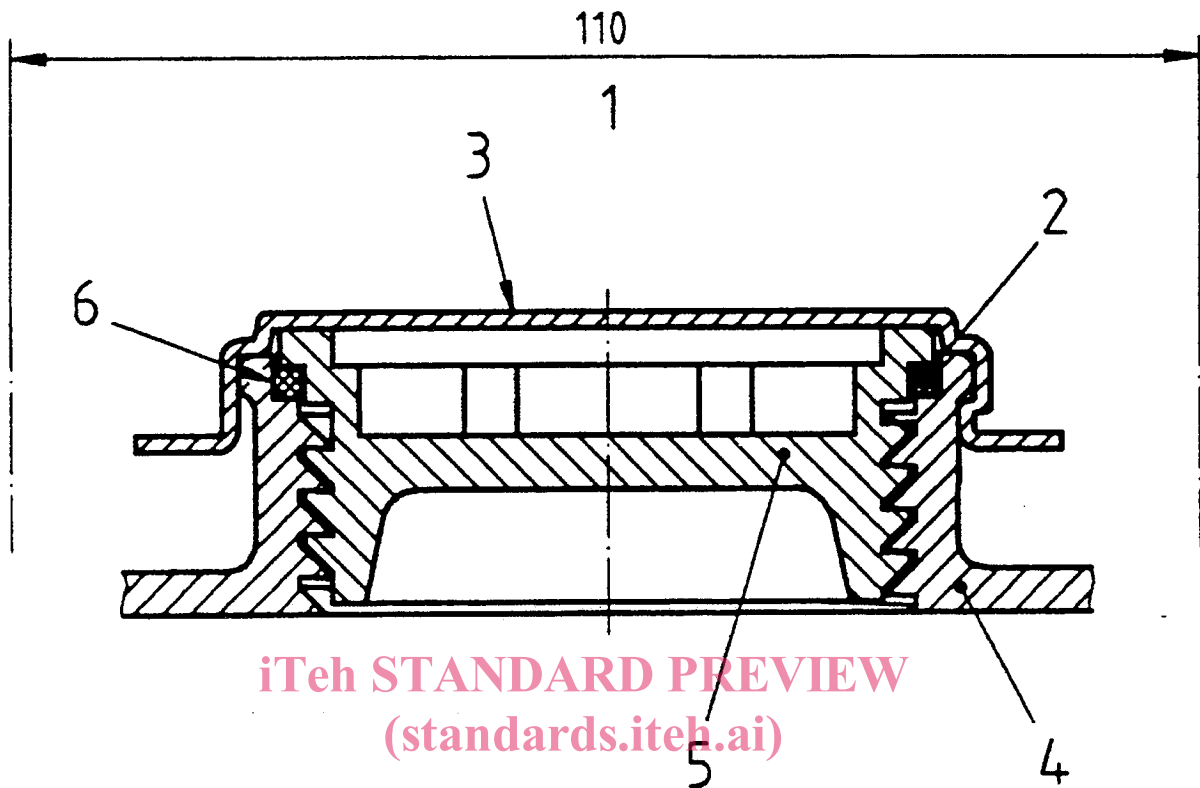
Plug/bung EN 12708 BCS 24 x 4

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key

- 1. min. clearance for crimping tool
- 2. gasket
- 3. cap seal
- 4. bung housing
- 5. bung
- 6. gasket sealing face

**FIGURE 1 — Plug/bung closure system BCS 56 × 4**