TECHNICAL REPORT

ISO TR 11776

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Light gauge metal containers — Non-round open-top cans — Cans defined by their nominal capacities

Emballages métalliques légers — Boîtes serties non rondes — Boîtes définies par leur capacité nominale

Reference number
ISO/TR 11776:1992(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The main task of technical committees is to prepare International Standards, but in exceptional circumstances a technical committee may propose the publication of a Technical Report of one of the following types:

- type 1, when the required support cannot be obtained for the publication of an International Standard, despite repeated efforts;

- type 2, when the subject is still under technical development or where for any other reason there is the future but not immediate possibility of an agreement on an International Standard;

- type 3, when a technical committee has collected data of a different kind from that which is normally published as an International Standard ("state of the art", for example).

Technical Reports of types 1 and 2 are subject to review within three years of publication, to decide whether they can be transformed into International Standards. Technical Reports of type 3 do not necessarily have to be reviewed until the data they provide are considered to be no longer valid or useful.

ISO/TR 11776, which is a Technical Report of type 2, was prepared by Technical Committee ISO/TC 52, *Light gauge metal containers*, Sub-Committee SC 4, *Open top containers*.

This Technical Report constitutes an important step in standardization in the field of non-round cans. It will be established as an International Standard if work leads to a sufficient reduction in the number of can sizes to establish an International Standard.

This document is being issued in the type 2 Technical Report series of publications (according to subclause G.4.2.2 of part 1 of the IEC/ISO Di-

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rectives) as a "prospective standard for provisional application" in the field of non-round open-top cans because there is an urgent need for guidance on how standards in this field should be used to meet an identified need.

This document is not to be regarded as an "International Standard". It is proposed for provisional application so that information and experience if its use in practice may be gathered. Comments on the content of this document should be sent to the ISO Central Secretariat.

A review of this type 2 Technical Report will be carried out not later than two years after its publication with the options of: extension for another two years; conversion into an International Standard; or withdrawal.

Together with ISO 10653, ISO 10654, ISO/TR 11761 and ISO/TR 11762, this first edition of ISO/TR 11776 cancels and replaces ISO 3004-1:1986, ISO 3004-2:1989, ISO 3004-3:1986, ISO 3004-4:1986, ISO 3004-5:1988 and ISO 3004-6:1986.

Annexes A and B of this Technical Report are for information only.

Introduction

This Technical Report presents a list of nominal capacities for non-round open-top cans, previously standardized in ISO 3004-2, in ISO 3004-4 and in ISO 3004-5.

The criterion for can size inclusion in this Technical Report is:

the can size shall be supported by at least two member bodies of TC 52.

If a can size previously included in the above-mentioned parts of ISO 3004 is supported by only one member body, its inclusion will be studied case per case.

Light gauge metal containers — Non-round open-top cans — Cans defined by their nominal capacities

1 Scope

This Technical Report gives a list of nominal capacities up to 2 000 ml for non-round open-top cans.

It is applicable to the following cans:

— rectangular cans;

— oval cans;

— obround cans;

— trapezoidal cans.

Annex A gives a classification of can sizes by shapes with related nominal sections.

Annex B lists can sizes previously standardized in ISO 3004-2, in ISO 3004-4 and in ISO 3004-5 but which do not meet the required criterion to be part of this Technical Report.

NOTE 1 The definitions and designations of these types of containers are given in ISO 90-1:1986, *Light gauge metal containers — Definitions and determination methods for dimensions and capacities — Part 1: Open-top cans.*

2 Nominal capacities

The nominal capacities of non-round open-top cans are given in table 1.

Table 1

Nominal capacity ml
50
57
75
85
92
100
112
120
125
142
155
170
187
198
207
212
246
270
283
300
314
330
335
375
400
425
460
492
560
750
850
935
1 062
1 100
1 310
1 380
1 455
1 555
1 600
1 800
1 960

Annex A
(informative)

Classification of can sizes by their shapes

A.1 Rectangular cans

Table A.1 gives the nominal cross-sections of rectangular cans whose nominal gross-lidded capacity complies with the present Technical Report.

A.2 Oval cans

Table A.2 gives the nominal cross-sections of oval cans whose nominal gross-lidded capacity complies with the present Technical Report.

A.3 Obround cans

Table A.3 gives the nominal cross-sections of obround cans whose nominal gross-lidded capacity complies with the present Technical Report.

A.4 Trapezoidal cans

Table A.4 gives the nominal cross-sections of trapezoidal cans whose nominal gross-lidded capacity complies with the present Technical Report.

Table A.1 — Rectangular cans

Nominal gross-lidded capacity ml	Nominal cross-sections mm × mm					
50	99 × 46	82 × 57	104 × 60			
57	99 × 46					
75	99 × 46	104 × 60	105 × 73			
85	105 × 76					
92	104 × 60					
100	104 × 60	105 × 73	105 × 76			
112	105 × 76	155 × 61				
120	104 × 60	105 × 73				
125	104 × 60	105 × 73	105 × 76			
142	105 × 76	126 × 75				
155	104 × 60	105 × 76				
170	63 × 54	93 × 47				
187	99 × 46	105 × 76	155 × 55			
198	99 × 46	148 × 96				
207	99 × 46	93 × 47				

Nominal gross-lidded capacity ml	Nominal cross-sections mm × mm					
212	93 × 47	104 × 60				
246	99 × 46	104 × 60	117 × 95			
270	148 × 96					
283	60 × 44	67 × 42	70 × 35	76 × 49		
300	93 × 47	117 × 95				
314	74 × 56	99 × 46				
330	148 × 96	160 × 101				
335	99 × 46	93 × 47	117 × 95			
375	99 × 46	160 × 101	196 × 55			
400	148 × 96	160 × 108				
425	99 × 46	105 × 76	148 × 96	155 × 81	160 × 101	175 × 81
460	144 × 98	148 × 96				
492	220 × 160					
560	96 × 42					
750	76 × 49	94 × 68	103 × 77	117 × 95	155 × 105	
850	155 × 81	175 × 81				
1 062	117 × 95					
1 100	67 × 99	103 × 77	114 × 58	120 × 65	188 × 96	
1 380	102 × 90	110 × 84				
1 455	110 × 84	120 × 90				
1 555	99 × 99	117 × 95				
1 600	120 × 90					
1800	99 × 99	102 × 90	233 × 147			
1 960	100 × 99					

Table A.2 — Oval cans

Nominal gross-lidded capacity ml	Nominal cross-sections mm × mm		
50	85 × 53		
85	83 × 51		
120	105 × 65		
125	125 × 65		
212	105 × 65		
246	120 × 85	126 × 78	148 × 81
375	160 × 108		
400	160 × 108		
425	125 × 75		
460	120 × 85	144 × 98	
1 062	175 × 115		

Table A.3 — Obround cans

Nominal gross-lidded capacity ml	Nominal cross-sections mm × mm	
125	150 × 54	
155	148 × 81	
170	148 × 81	165 × 59
198	148 × 81	
375	160 × 98	210 × 80
560	210 × 80	

Table A.4 — Trapezoidal cans

Nominal gross-lidded capacity ml	Nominal cross-sections mm × mm	
125	75 × 73	
246	120 × 85	123 × 88
335	144 × 99	
425	75 × 73	88 × 86
460	120 × 85	144 × 99
935	162 × 116	
1 062	88 × 86	190 × 144
1 310	190 × 144	