



# SLOVENSKI STANDARD

## SIST EN 13025-2:2006

01-februar-2006

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SIST EN 13025:2001

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Packaging - Light gauge metal containers - Part 2: Non-removable head (tight head) round steel and tinplate containers with a nominal capacity of 20 000 ml, 25 000 ml and 30 000 ml

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Verpackungen - Feinstblechverpackungen - Teil 2: Spundfässer mit einem Nennvolumen von 20 000 ml, 25 000 ml und 30 000 ml

Emballage - Emballages métalliques légers - Partie 2: Tonnelets a ouverture partielle d'une capacité nominale de 20 000 ml, 25 000 ml et 30 000 ml

Ta slovenski standard je istoveten z: EN 13025-2:2005

### ICS:

55.120 Ú|l ^çã \^ÉV` à^ Cans. Tins. Tubes

SIST EN 13025-2:2006

en,fr,de

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 13025-2**

November 2005

ICS 55.140

Supersedes EN 13025:2000

English Version

**Packaging - Light gauge metal containers - Part 2: Non-removable head (tight head) round steel and tinplate containers with a nominal capacity of 20 000 ml, 25 000 ml and 30 000 ml**

Emballage - Emballages métalliques légers - Partie 2:  
Tonnelets à ouverture partielle d'une capacité nominale de  
20 000 ml, 25 000 ml et 30 000 ml

Verpackungen - Feinstblechverpackungen - Teil 2:  
Spundfässer mit einem Nennvolumen von 20 000 ml, 25  
000 ml und 30 000 ml

This European Standard was approved by CEN on 12 September 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.

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

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## Foreword

This European Standard (EN 13025-2:2005) 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 European Standard supersedes EN 13025:2000.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, 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.

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**EN 13025-2:2005 (E)****1 Scope**

Part 2 of EN 13025 specifies 20 l, 25 l and 30 l nominal capacity round cylindrical and tapered non-removable head containers with steel and tinplate thickness not exceeding 0,49 mm.

Recommended dimensions related to this range of nominal filling volumes are shown in Table 1 of this European Standard.

**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 applies (including any amendments).

EN 10130, *Cold rolled low carbon steel flat products for cold forming - Technical delivery conditions*

EN 10131, *Cold rolled uncoated low carbon and high yield strength steel flat products for cold forming - Tolerances on dimensions and shape*

EN 10202, *Cold reduced tinmill products - Electrolytic tinplate and electrolytic chromium/chromium oxide coated steel*

EN 13029, *Packaging – Light-gauge metal packaging – Apertures for plug-in plastic closures*

**3 Terms and definitions**

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

**3.1**

**non-removable head (tight head) container**

**TH**

cylindrical packaging made of steel or tinplate, the ends of which are permanently fixed to the body, with openings for filling, emptying and venting in the head

**3.3**

**overall height**

**$h_o$**

height of the finished container from the base to the highest point (see Figure 1)

**3.3**

**stacking height**

**$h_s$**

effective height of the container in a stack, i.e. the height from the base of a container to the base of a similar container above it in a stack (see Figure 1)

**3.4**

**external diameter**

**$d_e$**

maximum dimension of a container diameter (see Figure 1)

**3.5**

**internal diameter**

**$d_i$**

internal diameter of the container body shell (see Figure 1)

**3.6****total capacity (gross lidded capacity)**

volume of water held by the container when filled completely, i.e. following the removal of any air trapped in the container (for the method of measuring see EN ISO 90-2)

**3.7****nominal filling volume (nominal capacity)**

volume of product which the container is required to hold

**4 Dimensions**

The dimensions of non-removable head (tight head) containers with a nominal capacity of 20 l, 25 l and 30 l shall be as given in Table 1. In addition the steel and tinplate thickness shall not exceed 0,49 mm, with tolerances as specified in EN 10131 (normal tolerances) for steel and EN 10202 for tinplate.

**5 Material**

The body and ends of the containers shall as a minimum be made of steel FePo1, in accordance with EN 10130 or tinplate in accordance with EN 10202.

**6 Construction**

**6.1** The longitudinal seam of the body shall be mechanically seamed or welded. The body and fixed end shall be combined by seaming or other joining methods.

NOTE The container body can be straight-sided or tapered and in addition have bead(s) or corrugations and can be necked-in or step-sided.

**6.2** Closures shall be positioned in the top end of the container. Plastic plug-in closures may be inserted after filling. The aperture dimensions of such plug-in closures shall conform to EN 13029.

**6.3** Other types of closures may be fitted. (e.g. tinplate screw closures, or inserted flange closures in accordance with EN 12928).

NOTE The insertion of the closure should be such that its centre line is as close as possible to the vertical.

**6.4** Metal or plastics plugs shall be fitted with washers (where relevant) of suitable material compatible with the contents of the container.

**7 Finish**

The nature of the internal and external finish 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 manufacturer.

**8 Draining**

If required, the draining test method is identified in Annex B of EN 13025-1:2005.

## EN 13025-2:2005 (E)

Table 1 — Dimensions

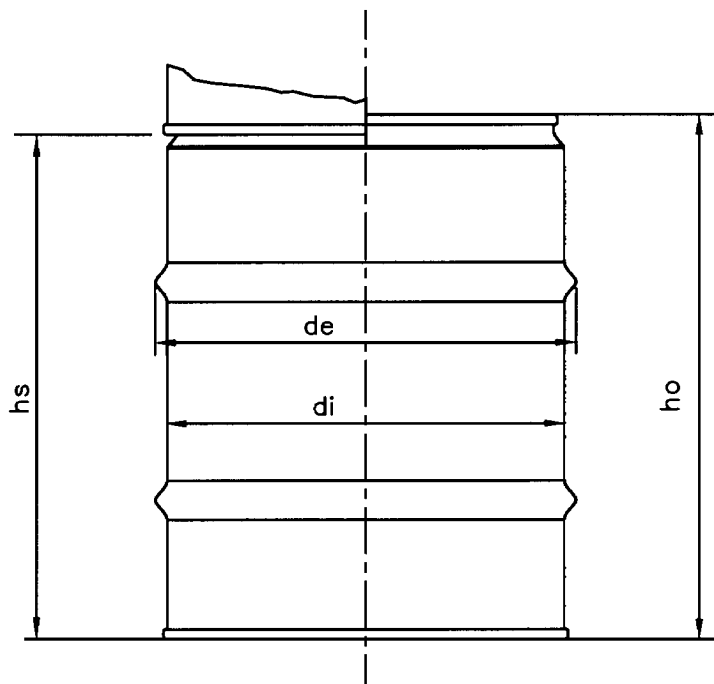
Nominal filling volume	Minimum total capacity	Internal Diameter ( $d_i$ )	Maximum external diameter ( $d_e$ ) <sup>a</sup>	Maximum overall height ( $h_o$ )	Maximum stacking height ( $h_s$ )
litre	litre	± 2 mm	mm	mm	mm
20	21,2	280	290	387 <sup>b</sup>	377 <sup>b</sup>
		286	294	372	362
		292	303	369	359
		300	305	335	325
		305	321	335	325
25	26,2	280	290	467 <sup>b</sup>	457 <sup>b</sup>
		286	294	453	443
		292	303	450	440
		300	305	425	415
		305	321	417	407
30	32,0	280	290	560	550
		286	294	538	528
		292	303	530	523
		300	305	495	485
		305	321	496	486
30	32,0	328	338	425	413

<sup>a</sup> Without handles

<sup>b</sup> For interrupted chimb containers with self-draining tops for agricultural use, heights  $h_o$  and  $h_s$  can be increased by 10 mm.

NOTE The dimensions quoted above are only concerning the preferred volumes 20 l, 25 l and 30 l but it is clear that other volumes are available.





**Figure 1 — Dimensions  $d_e$ ,  $d_i$ ,  $h_o$  and  $h_s$**   
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