



# SLOVENSKI STANDARD

## SIST EN 17177:2019

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**Steklena embalaža - Kronski pokrovčki - Kronski pokrovčki s premerom 26 mm in višino 6 mm**

Glass packaging - Crown cap - 26 mm diameter, 6 mm height crown cap

Verpackungen aus Glas - Kronenverschluss - Kronenverschluss mit einem Durchmesser von 26 mm und einer Höhe von 6 mm

Emballage en verre - Capsule couronne - Capsule couronne de 26 mm de diamètre et de 6 mm de hauteur

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SIST EN 17177:2019

Ta slovenski standard je istoveten z: EN 17177:2019

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**ICS:**

55.100      Steklenice. Lonci. Kozarci      Bottles. Pots. Jars

**SIST EN 17177:2019**

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EUROPEAN STANDARD

EN 17177

NORME EUROPÉENNE

EUROPÄISCHE NORM

January 2019

ICS 55.100

English Version

## Glass packaging - Crown cap - 26 mm diameter, 6 mm height crown cap

Emballage en verre - Capsule couronne - Capsule couronne de 26 mm de diamètre et de 6 mm de hauteur

Verpackungen aus Glas - Kronenverschluss - Kronenverschluss mit einem Durchmesser von 26 mm und einer Höhe von 6 mm

This European Standard was approved by CEN on 2 December 2018.

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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 CEN-CENELEC Management Centre has the same status as the official versions.

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



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

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<b>Contents</b>		Page
<b>European foreword</b> .....		<b>3</b>
<b>Introduction</b> .....		<b>4</b>
<b>1</b>	<b>Scope</b> .....	<b>5</b>
<b>2</b>	<b>Normative references</b> .....	<b>5</b>
<b>3</b>	<b>Term and definition</b> .....	<b>5</b>
<b>4</b>	<b>Dimensions</b> .....	<b>5</b>
<b>5</b>	<b>Material</b> .....	<b>7</b>
<b>6</b>	<b>Requirements and recommendations for cap application</b> .....	<b>7</b>
<b>Bibliography</b> .....		<b>9</b>

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SIST EN 17177:2019

<https://standards.iteh.ai/catalog/standards/sist/9ffb84fb-a1d9-4bbb-9298-a5ae7fad70a/sist-en-17177-2019>

## European foreword

This document (EN 17177:2019) 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 2019, and conflicting national standards shall be withdrawn at the latest by July 2019.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

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

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**EN 17177:2019 (E)**

## **Introduction**

This document is based on Cetié (International technical Center for Bottling and related Packaging) data sheet EC 1.02 - 2016.

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## 1 Scope

This document specifies the dimensional requirements for the 26 mm diameter, 6 mm height crown cap, lined with a plastic gasket and designed to seal bottles with neck finishes foreseen for pry-off or twist-crown applications.

It specifies the dimensional requirements that are of direct importance to the customer/bottler and recommendations for cap application.

The gasket material and profile are not specified as a number of different profiles are available depending on the end use and supplier specific technology. The requirement placed on the gasket profile design is that it needs to be fit for purpose used in conjunction with glass finishes in reference.

## 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 10202, *Cold reduced tinmill products — Electrolytic tinplate and electrolytic chromium/chromium oxide coated steel*

## 3 Term and definition

For the purposes of this document, the following term and definition applies.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

— IEC Electropedia, available at <http://www.electropedia.org/>

— ISO Online browsing platform, available at <http://www.iso.org/obp>

### 3.1

#### 6 mm height crown cap

crown cap with an overall height of 6 mm before application

## 4 Dimensions

The cap dimensions are specified in Table 1 and Figure 1.

Table 1 — Characteristic dimensions of 26 mm crown cap

$h^a$ <i>Height of the cap</i>	$D^a$ <i>External diameter</i>	$d^a$ <i>Internal diameter</i>	$e^b$ <i>Metal thickness</i>	Number of flutes <sup>c</sup>
$6 \pm 0,15$	$32,1 \pm 0,2$	$26,75^{+0,15}_0$	0,22 0,21 0,20 0,18	21

<sup>a</sup> Controlled during production.

<sup>b</sup> Metal thickness to be agreed between the cap supplier and the filler. Other metal thickness can be proposed for such an agreement. Metal characteristics are according to EN 10202 (see Clause 5) with a thickness tolerance from -8 % to +5 %.

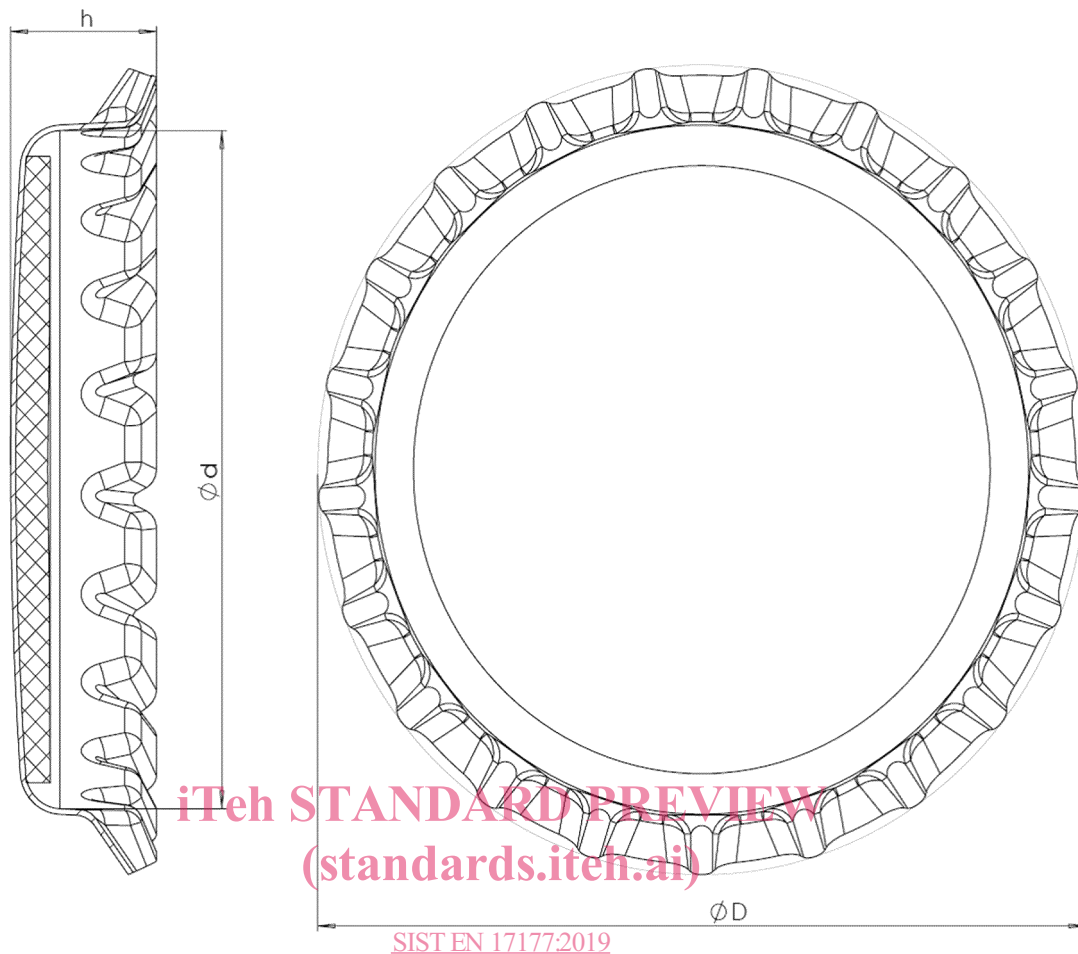
<sup>c</sup> 21 is the standard number of flutes but other numbers may be used in agreement between the cap supplier and the filler for specific applications.

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**Key**

- D external diameter
- d internal diameter
- h height of the cap

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**Figure 1 — Characteristic dimensions of the 26 mm crown cap**

## 5 Material

The shell is normally made from TP (Tinplate) or ECCS (Electrolytic Coated Chromium Steel) as specified by EN 10202, with mechanical properties TS/TH 230 up to 620. Further classes of steel in terms of mechanical properties may be considered in agreement between the cap manufacturer and the filler, in particular if lower steel thickness is considered.

## 6 Requirements and recommendations for cap application

**6.1** Due to the wide range of performance requirements associated with this type of closure it is strongly recommended that fillers carry out appropriate qualification tests of the closure for a given application before commercial production.

**6.2** Crowns made from steel with metal thicknesses below 0,22 mm require specific liner profiles and/or liner materials as well as specific filling/closing control parameters (e.g. crowner settings). Steel thickness down-gauging shall be agreed between fillers and suppliers of caps and bottles.