
INTERNATIONAL STANDARD 2735

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Hermetically sealed metal food containers — Capacities and diameters of round open-top and vent hole cans for milk

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FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up 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.

Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 2735 was drawn up by Technical Committee ISO/TC 52, *Hermetically sealed metal food containers*, and circulated to the Member Bodies in March 1972.

It has been approved by the Member Bodies of the following countries :

ISO 2735:1973

Austria	Italy	Switzerland
Belgium	Netherlands	Thailand
Chile	New Zealand	Turkey
Egypt, Arab Rep. of	Romania	United Kingdom
France	South Africa, Rep. of	U.S.A.
India	Spain	
Israel	Sweden	

The Member Body of the following country expressed disapproval of the document on technical grounds

Germany

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0 INTRODUCTION

All can measurements in this International Standard are given in accordance with the provisions of ISO 90.

Cans for any milk products with added flavours, malted milk or other formulated milk are not covered by this International Standard.

Milk powder cans are not covered by this International Standard because the density of milk powder shows such variations that it is not possible always to use the same can for a given mass of milk powder.

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies a recommended range of capacities with related diameters, in accordance with ISO 1361, for round cans for milk :

- a) open-top cans;
- b) vent hole cans.

For the purposes of this International Standard the term "milk can" is limited to cans for the following products :

- sweetened condensed milk;
- evaporated milk (sometimes called unsweetened condensed milk);
- sterilized milk (not condensed);
- sterilized cream (not condensed).

2 REFERENCES

- ISO 90, *Hermetically sealed metal food containers – Specifications*¹⁾
- ISO 1361, *Hermetically sealed metal food containers – Internal diameter of round cans.*

1) At present at the stage of draft : Revision of ISO/R 90.

3 CAPACITIES AND DIAMETERS OF ROUND CANS FOR MILK

TABLE 1 – Open-top cans

Capacity	Tolerance on capacity	Nominal internal diameter	Punch plug diameter	Deviation on punch plug diameter ¹⁾
ml	± %	mm	mm	mm
60	5	42	41,35	± 0,05 (for all diameters)
82	4	52	51,99	
90		58	57,30	
125			66	
158	3	58	57,30	
		66	65,05	
		73	72,57	
170		58	57,30	
		63	62,13	
		66	65,05	
	73	72,57		
184	73	72,57		
275 (285) ²⁾	2,5	73	72,57	
310				
340				
405 (450) ²⁾				

- 1) These deviations must not be confused with manufacturing tolerances.
- 2) The figures in parentheses are non-preferred, being sizes with reduced volume of production.

TABLE 2 – Vent hole cans

Capacity	Tolerance on capacity	Nominal diameter	Die plug diameter	Deviation on die plug diameter ¹⁾
ml	± %	mm	mm	mm
175	3	64	63,25	± 0,25 (for all diameters)
350	2,5	76	75,25	
415 (460) ²⁾				

- 1) These deviations must not be confused with manufacturing tolerances.
- 2) The figure in parentheses is non-preferred, being a size with reduced volume of production.