
International Standard



3004/6

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**Light gauge metal containers — Capacities and related cross-sections —
Part 6: Open-top cans for milk**

Réipients métalliques légers — Capacités et sections transversales associées — Partie 3: Boîtes serties pour le lait

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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.

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. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 3004/6 was prepared by Technical Committee ISO/TC 52, *Light gauge metal containers*.

This first edition of ISO 3004/6 together with ISO/TR 8610-1984 cancel and replace ISO 2735-1973, of which they constitute a technical revision.

Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

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Light gauge metal containers — Capacities and related cross-sections — Part 3: Open-top cans for milk

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0 Introduction

Light gauge metal open-top containers for food and drinks, covered by ISO 3004, are grouped as follows:

- Part 1: Open-top cans for general food.
- Part 2: Open-top cans for meat and products containing meat for human consumption.
- Part 3: Open-top cans for drinks.
- Part 4: Open-top cans for edible oil.
- Part 5: Open-top cans for fish and other fishery products.¹⁾
- Part 6: Open-top cans for milk.

Vent-hole cans for milk are covered in ISO/TR 8610, *Light gauge metal containers — Round vent-hole cans with soldered ends for milk and milk products — Capacities and related diameters*.

1 Scope and field of application

This part of ISO 3004 lays down a recommended range of capacities with related diameters for round open-top cans for milk.

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

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

NOTE — Cans for the following products are not covered by this part of ISO 3004:

- milk products with added flavours;
- malted milk;
- other formulated milk products.

All can measurements in this part of ISO 3004 are given in accordance with the requirements laid down in ISO 90/1.

2 References

ISO 90/1, *Light gauge metal containers — Definitions and determination methods for dimensions and capacities — Part 1: Open-top cans*.

ISO 1361, *Light gauge metal containers — Open-top cans — Round cans — Internal diameters*.

1) At present at the stage of draft. (Revision of ISO/TR 7423-1982 and ISO/TR 7670-1982.)

3 Gross lidded capacities and related cross-sections

Table 1 — Gross lidded capacities and related diameters of round cans

Nominal gross lidded capacity ml	Tolerance limits on capacity ¹⁾ ml	Nominal diameter ²⁾ mm
60	57 – 63	42 ³⁾
85	81 – 89	52
115	110 – 120	58 ³⁾
170	164 – 176	58 ³⁾ 63 73
182	176 – 188	73
228	221 – 235	73
236	229 – 243	65
257	249 – 265	60
275	267 – 283	65
283	275 – 291	73
296	288 – 304	73
314	306 – 322	73
340	331 – 349	73
403	393 – 413	73

1) In conformity with ISO 90/1, these tolerances define the limits of acceptable deviation resulting from variations in can design and manufacture.

2) For related internal body diameters, see ISO 1361.

3) For related internal body diameters, see table 3.

4 Diameters of cans for milk powder

NOTE — Capacities for milk powder cans are not given, due to the fact that the density of milk powder varies to a great extent.

Table 2 — Nominal diameters of cans for milk powder

Nominal diameter ¹⁾ mm
73
83
99
127
153
165 ²⁾
189

1) For related internal body diameters, see ISO 1361.

2) For related internal body diameter, see table 3.

5 Internal body diameters of cans, not given in ISO 1361, only used for cans for milk

Table 3 — Internal body diameters of cans not given in ISO 1361

Nominal diameter mm	Internal body diameter mm
42	41,7 ± 0,1
58	57,7 ± 0,1
165	165,0 ± 0,2