

INTERNATIONAL STANDARD

**ISO
1361**

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Light-gauge metal containers — Round open-top cans — Internal diameters

*Réipients métalliques légers — Boîtes rondes serties — Diamètres
intérieurs*



Reference number
ISO 1361:1997(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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 1361 was prepared by Technical Committee ISO/TC 52, *Light gauge metal containers*, Subcommittee 4, *Open-top containers*.

This fourth edition cancels and replaces the third edition (ISO 1361:1983), in which the following technical changes have been made:

- nearly all dimensions and tolerances of the actual internal body diameters have been slightly changed to reflect the most current practice;
- nominal necked-in diameters are included which, associated with the internal body diameters, allow the stacking of three-piece cans;
- the following diameters, which were considered acceptable until the end of 1987, are deleted :

56; 57; 61; 70; 71; 72; 93; 100; 109; 113; 126; 135; 138; 154 ;
- a new list of diameters which are acceptable for a five-year period has been drawn up.

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Light-gauge metal containers — Round open-top cans — Internal diameters

1 Scope

This International Standard establishes a list of recommended diameters for round two-piece and three-piece cans in tinplate or aluminium seamed after filling and defined by their nominal gross lidded capacity.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of the publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 90-1: 1997, *Light gauge metal containers — Definitions and determination of dimensions and capacities — Part 1: Open-top cans.*

ISO 10653:1993, *Light-gauge metal containers — Round open-top cans — Cans defined by their nominal gross lidded capacity.*

3 Recommended diameters

Table 1 gives the range :

- of the nominal diameters of two- and three-piece cans ;
- of the corresponding actual internal body diameters for three-piece cans ;
- of the nominal necked-in diameters associated with the internal body diameters to allow stacking of three-piece cans ;
- of the opening diameters for two-piece cans.

All specified can dimensions given are in accordance with the provisions of ISO 90-1.

Table 1

Nominal diameter ³⁾ D mm	Three-piece cans			Two-piece cans	
	Actual internal body diameter mm	Tolerance ²⁾ $\pm$ mm	Necked-in diameter Nominal diameter D_N ⁶⁾ mm	Opening diameter mm	Tolerance ^{2) 4)} $\pm$ mm
52	52,27	0,10	49	52,40 ^{5) 1)}	0,20
63	62,41	0,12	60	63,00	"
65	65,28	0,12	62	65,45	"
73	72,80	0,15	70	72,99	"
83	83,33	0,15	80	83,55 ¹⁾	0,30
99	98,99	0,16	96	99,25	"
105	105,16	0,18	102	105,43	"
127	126,45	0,22	123	126,78	"
153	153,35	0,22	149	153,77	0,40
189	188,90	0,22			"
230	229,67	0,22	225	230,09	"

1) In these cases, for step-sided cans, the internal body diameter may conform to the value in the "Opening diameter" column.
2) These tolerances define the limits of acceptable deviations resulting from variations in can design.
3) In some cases, the method of rounding the internal body diameter or the opening diameter to determine the nominal diameter is not in accordance with the method described in ISO 90-1.
4) Tolerances given in this column take into account cans made of steel plate or aluminium.
5) Some existing two-piece cans may not conform.
6) The nominal necked-in diameter D_N applies to cross-sections at the top end D_{N1} as well as at the bottom end D_{N2} .

The nominal necked-in diameter D_N in table 1 shall only be used in conjunction with the corresponding internal nominal diameter in table 1; the nominal necked-in diameter D_N shown shall not be used as the nominal diameter in connection with ISO 10653.

4 Provisional additional diameters

The following currently used diameters are acceptable for a five-year period. After five years, these diameters will be reconsidered and either deleted or incorporated into this International Standard:

55; 60; 71,5; 74; 86; 155; 163; 171

As this list is only valid for a limited period, the internal body diameters and opening diameters are not specified.