

INTERNATIONAL STANDARD

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Glass containers — Tolerances

Réipients en verre — Tolérances

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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. 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 9058 was prepared by Technical Committee ISO/TC 63, *Glass containers*.

Glass containers — Tolerances

1 Scope

This International Standard specifies tolerances for glass containers of circular cross-section and nominal capacity from 50 ml to 5 000 ml.

NOTE 1 This International Standard is based on CETIE¹⁾ data sheet DT 2 (1987) and EC Council Directive 75/107/EEC.

2 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this International Standard. At the time of 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 7348:1992, *Glass containers — Manufacture — Vocabulary*.

ISO 9009:1991, *Glass containers — Height and non-parallelism of finish with reference to container base — Test methods*.

3 Definitions

For the purposes of this International Standard, the definitions given in ISO 7348 and ISO 9009 and the following definition apply.

3.1 leading body diameter: The greatest horizontal cross-sectional dimension of a container.

4 Tolerances

4.1 Capacity tolerance

The actual capacity error (tolerance) shall be in accordance with the values specified in table 1.

Table 1

Nominal capacity, V_n ml	Maximum permissible error of the actual capacity	
	% of V_n	ml
$50 < V_n \leq 100$	—	3
$100 < V_n \leq 200$	3	—
$200 < V_n \leq 300$	—	6
$300 < V_n \leq 500$	2	—
$500 < V_n \leq 1\,000$	—	10
$1\,000 < V_n \leq 5\,000$	1	—

NOTE — The maximum permissible error in the brimful capacity shall be the same as the maximum permissible error in the corresponding nominal capacity.

4.2 Nominal height tolerance, T_H

The nominal height tolerance, in millimetres, shall be calculated using the following formula:

$$T_H = \pm (0.6 + 0.004H)$$

where H is the nominal height, in millimetres.

1) International Technical Centre for Bottling.

4.3 Nominal leading body diameter tolerance, T_D

The nominal leading body diameter tolerance, in millimetres, shall be calculated using the following formula:

$$T_D = \pm (0,5 + 0,012D)$$

where D is the nominal leading body diameter, in millimetres.

4.4 Verticality tolerance, T_V (vertical axis deviation tolerance)

The verticality tolerance, in millimetres, shall be calculated using the following formulae:

- a) for a nominal height $H < 220$ mm

$$T_V = 1,3 + 0,005H$$

- b) for a nominal height $H \geq 220$ mm

$$T_V = 0,3 + 0,01H$$

where H is in millimetres.

4.5 Tolerance on non-parallelism of finish with reference to container base

The tolerance on non-parallelism of finish with reference to container base (or the slope of finish) shall be in accordance with the values specified in table 2.

Table 2

Dimensions in millimetres

Nominal diameter of finish	Tolerance on non-parallelism of finish with reference to container base max.
Less than or equal to 20	0,45
More than 20 up to 30	0,6
More than 30 up to 40	0,7
More than 40 up to 50	0,8
More than 50 up to 60	0,9
More than 60	1

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