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# GB

NATIONAL STANDARD OF THE  
PEOPLE'S REPUBLIC OF CHINA

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## GB/T 13042-2008

Replacing GB/T 13042-1998

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### Packaging containers - Tinplate aerosol can

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## Foreword

**Article 6.4 in this Standard is mandatory; the rest are recommended.**

This Standard replaces GB 13042-1998 "Packaging Containers – Aerosol Can".

Compared with GB 13042-1998 "Packaging Containers – Aerosol Can", the main differences of this Standard are as follows:

- Specify that the volume of aerosol can shall not be greater than 1000 mL;
- Delete the classification method by materials (Z and Y); and change the classification methods to be by structure, shape and pressure resistance properties;
- Printing quality shall conform to QB/T 1877;
- Delete the requirements on the average contact height of can mouth;
- Delete the requirements on heat resistance test;
- The requirements on the deformation pressure and bursting pressure are divided into two grades: one for normal can and the other for high pressure can;
- Add compatibility requirements;
- Add sanitary requirements.

This Standard adopts the relevant provisions of ISO 90-3:2000(E) "Light gauge metal containers - Definitions and determination of dimensions and capacities - Part 3: Aerosol cans".

This Standard was proposed by China Packaging Federation.

This Standard shall be under the jurisdiction of China National Technical Committee for Packaging Standardization.

Drafting organizations of this Standard: Zhongshan Kaida Fine Chemical Engineering Co., Ltd., National Packaging Product Quality Supervision And Inspection Center (Guangzhou), Hangzhou COFCO-MC Packaging Co., Ltd., Guangdong Laya Chemical Co., Ltd., Hebei Jiamei Iron-Printing and Can-making Co., Ltd. AND China Packaging Federation.

Main drafters of this Standard: Luming, Cui Ruping, Feng Hui, Zhu Liping, Zhan Yan, Fan Zhilong and Ruan Shen.

The previous versions replaced by this Standard are as follows:

- GB 13042-1991, GB 13042-1998.

## Packaging Containers – Tinplate Aerosol Can

### 1 Scope

This Standard specifies the terms, definitions, classification, materials, requirements, test methods, inspection rules, marking, packaging, transportation and storage of tinplate aerosol can (hereinafter referred as “aerosol can”).

This Standard is applicable to the aerosol can made of thin tinplate steel sheet with the mouth diameter of 25.4 mm and the volume no less than 1000 ml.

### 2 Normative references

The articles contained in the following documents have become part of this document when they are quoted herein. For the dated documents so quoted, all subsequent modifications (including all corrections) or revisions made thereafter do not apply to this Standard. However, the parties who reach an agreement according to this Standard are encouraged to study whether the latest versions of these documents may be used. For the undated documents so quoted, the latest versions (including all modification sheets) apply to this document.

GB/T 1720 Method of test for adhesion of paint films

GB/T 2520 Cold-reduced electrolytic tinplate (GB/T 2520-2000, eqv ISO 11949:1995)

GB/T 2828.1 Sampling procedures for inspection by attributes - Part 1: Sampling schemes indexed by acceptance quality limit (AQL) for lot-by-lot inspection (GB/T 2828.1-2003, ISO 2859-1:1999, IDT)

GB/T 6739 Paints and varnishes - Determination of film hardness by pencil test (GB/T 6739-2006, ISO 15184:1998, IDT)

QB/T 1877 Tinplate prints for the packing and decoration

QB/T 2763 Coated tinplate (or ECCS)

### 3 Terms and definitions

The following terms and definitions apply to this Standard.

#### 3.1

##### **aerosol can**

Disposable metal container that is used to contain aerosol products. Aerosol products will be released in the controlled form through valve under pre-pressing function during use.

#### 3.2

##### **tinplate aerosol can**

Aerosol can that is made of thin tinplate (chrome plate) steel sheet.

#### 3.3

## 7.7 Determination of deformation pressure and bursting pressure

### 7.7.1 Instrument

Aerosol can bursting pressure tester: pressure range: 0 MPa ~ 4.0 MPa.

### 7.7.2 Test method

Inject clean water in the sample can; plug in seal head; then screw tightly. Fill the can with water to pressurize to the specified deformation pressure value; keep for 10s. Observe whether the can body is deformed. Continue to pressurize to the specified bursting pressure value; keep for 10s. Observe whether the can body is cracked.

## 8 Inspection rules

8.1 The products delivered at one-time are deemed as a batch; one aerosol can is a unit product.

8.2 The product inspection includes exit-factory inspection and type inspection. Exit-factory inspection must be conducted before the products are delivered out of factory. The test items for exit-factory inspection include 6.1, 6.2, 6.3.1 and air tightness test in 6.4. The test items for type inspection include 6.1~6.4.

8.3 In case of one of the following situations, type inspection shall be conducted.

- a) When the raw material or process is changed;
- b) For normal production, at least once for half a year;
- c) When resuming production from the shutdown;
- d) When the test results differ significantly from the results of last type inspection;
- e) When the national quality and technical supervision agency requires conducting type inspection.

### 8.4 Sampling scheme

For 6.1 and 6.2 in this Standard, double sampling scheme for normal inspection as specified in GB/T 2828.1 shall be adopted. For 6.3 and 6.4, single sampling scheme for normal inspection shall be adopted.

8.5 Judging rules and defect classification are shown in Table 4.

**Table 4 Judging Rules and Defect Classification**

| SN | Item                                                      | Classification of non-conformance | Inspection level | Acceptance quality limit (AQL) |
|----|-----------------------------------------------------------|-----------------------------------|------------------|--------------------------------|
| 1  | Appearance (6.1)                                          | Class C non-conformance           | S-4              | 4.0                            |
| 2  | Dimension (6.2)                                           | Class B non-conformance           | S-3              | 1.5                            |
| 3  | Integrity of supplemental coating of welding-seam (6.3.1) | Class B non-conformance           | S-2              | 1.5                            |
| 4  | Adhesive force of inner-outer coatings (6.3.2)            | Class B non-conformance           | S-2              | 1.5                            |
| 5  | Hardness of outer coating (6.3.3)                         | Class B non-conformance           | S-2              | 1.5                            |

|   |                            |                         |     |     |
|---|----------------------------|-------------------------|-----|-----|
| 6 | Airtightness (6.4)         | Class A non-conformance | S-2 | 1.0 |
| 7 | Deformation pressure (6.4) | Class A non-conformance | S-2 | 1.0 |
| 8 | Bursting pressure (6.4)    | Class A non-conformance | S-2 | 1.0 |

## 8.6 Judge number-group

8.6.1 The judge numbers of secondary sampling scheme for normal inspection, at the inspection level of S-4, are shown in Table 5.

**Table 5 Inspection Level S-4 and Second Sampling Scheme for Normal Inspection**

| Batch /piece     | Sample | Quantity of sample | Accumulative quantity of sample | Class C non-conformance |    |
|------------------|--------|--------------------|---------------------------------|-------------------------|----|
|                  |        |                    |                                 | Ac                      | Re |
| Less than 10 000 | First  | 20                 | 20                              | 1                       | 3  |
|                  | Second | 20                 | 40                              | 4                       | 5  |
| 10 001~35 000    | First  | 32                 | 32                              | 2                       | 5  |
|                  | Second | 32                 | 64                              | 6                       | 7  |
| More than 35 001 | First  | 50                 | 50                              | 3                       | 6  |
|                  | Second | 50                 | 100                             | 9                       | 10 |

8.6.2 The judge numbers for secondary sampling scheme for normal inspection, at the inspection level of S-3, are shown in Table 6.

**Table 6 Inspection Level S-3 and Second Sampling Scheme for Normal Inspection**

| Batch | Sample | Quantity of sample | Accumulative quantity of sample | Class B non-conformance |    |
|-------|--------|--------------------|---------------------------------|-------------------------|----|
|       |        |                    |                                 | Ac                      | Re |
| All   | First  | 20                 | 20                              | 0                       | 2  |
|       | Second | 20                 | 40                              | 1                       | 2  |

8.6.3 The judge numbers for single sampling scheme for normal inspection, at the inspection level of S-2, are shown in Table 7.

**Table 7 Inspection Level S-2 and Single Sampling Scheme for Normal Inspection**

| Batch | Quantity of sample |         | Class A non-conformance |    | Class B non-conformance |    |
|-------|--------------------|---------|-------------------------|----|-------------------------|----|
|       | Class A            | Class B | Ac                      | Re | Ac                      | Re |
| All   | 13                 | 8       | 0                       | 1  | 0                       | 1  |

## 9 Marking, packaging, transportation and storage

### 9.1 Marking

The products delivered out of factory shall be provided with quality certificate and signs that indicate product name, specification, quantity, production date and producer, etc.

### 9.2 Packaging

Generally, corrugated carton case is used to pack the products. Products shall be arranged in straight line. The products shall be separated by cross-shaped paperboard or upon the requirements of user.

### **9.3 Transportation**

Gently treat the products during transportation. Throwing is prohibited. Products shall be protected from collision, rain, direct sun light and pollution.

### **9.4 Storage**

Products shall be stored in well-ventilated dry clean place. They shall be prevented from direct sun light or be not piled heavily during storage.

\_\_\_\_\_ **END** \_\_\_\_\_

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