

GB/T 13521-1992

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**NATIONAL STANDARD
OF THE PEOPLE'S REPUBLIC OF CHINA**

GB/T 13521-92

Crown cap

冠形瓶盖

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National Standard of the People's Republic of China

GB/T 13521-92

Crown cap

1 Main content and application scope

This Standard specifies the basic dimension, technical requirements, test methods, inspection rules, marks, packaging, transportation, and storage of bottle caps which are for beverages such as beer and soft drinks, and which are made of electro-tinned (or electro-chromed) tinplate.

This Standard applies to the bottle cap for sealing which complies with GB 10809.

2 Reference standards

GB 2520 Cold-reduced electrolytic tinplate

GB 2828 Sampling procedures and tables for lot-by-lot inspection by attributes

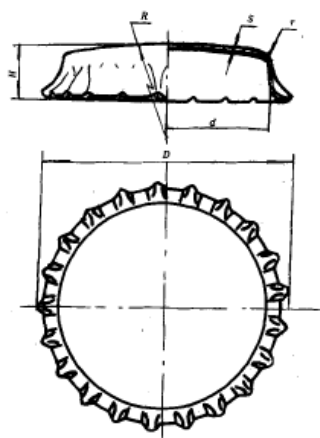
GB 9681 Hygienic standard of products of polyvinyl chloride for food packaging

GB 5009.67 Method for analysis of hygienic standard of product of polyvinyl chloride for food packaging

GB 10809 Glass container - dimension of crown bottleneck

3 Product structure and basic dimension

3.1 Structure is shown in below figure.



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3		4.3.2	5.3.2	
4	Category C	4.1.1	5.1.1	6.5
		4.2.1	5.2.1	
5		4.2.2	5.2.2	
6		4.2.3	5.2.2	
		4.2.4	5.2.2	
7		4.4.2	5.4.2	
		4.4.3	5.4.3	

6.5 Inspection level IL = S-3.

6.6 Sampling plan type: 1-time sampling plan for normal inspection.

6.7 Judgment procedures

6.7.1 Take samples randomly in accordance with sampling plan.

6.7.2 Inspect the samples according to Table 3. Except the Category A, the statistics of nonconformance products shall be in accordance with the specifications of GB 2828. The judgment of batch conformance/nonconformance shall be performed according to the judgment groups of sampling plan.

6.7.3 Unqualified batch products of Category A must not leave factory. The manufacturer of the product shall carry out full inspection or rework process. Then re-submit to inspection. The products can only leave the factory after passing the inspection.

6.7.4 Batch of products which have been judged as Category B, Category C unqualified products may be handled by both Supplier and Purchaser through negotiation.

7 Marks, packaging, transportation, and storage

7.1 Package box or bag shall be accompanied with a qualified label. It shall contain production unit, product name, built-in number, production date, factory date, and storage period. Packing quantity per unit is less than or equal to 10,000.

7.2 Bottle caps must be packaged with polyethylene bags firstly. And outer surface shall be packaged with woven bag, carton box or in other way according to user requirements.

7.3 Means of transport must be clean and dry. Rain, snow invasion and product packaging breakage shall be avoided during transportation.

7.4 Finished products' warehouse shall be dry and well ventilated. There shall be no contact with corrosive and toxic chemicals in the process of handling and storage.

7.5 Under the above specified conditions, the storage life is one year.

_____ **END** _____

Additional Explanation:

This Standard was proposed by Ministry of Light Industry of the People's Republic of China.

This Standard is responsibly drafted by the Packaging Science Research Institute of Ministry of Light Industry.

The main drafters of this Standard are Yin Xiaohong, Zeng Muxuan, Long Guohua, Pang Weiping, and Xia Chunxuan.

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