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

GB 9106-1994

**Packaging containers -- Two-piece can -- Part 1: Aluminum easy
open end and aluminum can**
(English Translation)

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Foreword

GB/T 9106 "Packaging Container Two Piece Cans" is divided into 2 parts.

---Part 1: Aluminum cans with easy-open lids;

---Part 2: Aluminum easy-open lid steel tank.

This part is Part 1 of GB/T 9106.

This section was drafted in accordance with the rules given in GB/T 1.1-2009.

This part replaces GB/T 9106.1-2009 "Packaging Container Aluminum Easy-opening Aluminum Two-piece Can". Compared with GB/T 9106.1-2009, the main technical content changes are as follows.

---Modified normative references (see Chapter 2, Chapter 2 of the 2009 edition);

--- Added two-piece cans.200 series and 202 series (see 4.1.1, Table 1);

---Modified the two-piece tank model code and added information about the nominal capacity (see 4.1.2, 4.4 in the 2009 edition);

---The structural dimensions of the two-piece tank.200 series and 202 series tank bodies have been added (see 4.3.1, Table 2, and Table 3);

---Modified the two-piece tank 206 series tank structure size (see 4.3.1, Table 4, 4.3.1, Table 1 of the 2009 edition);

---Added two-piece cans.200 series and 202 series aluminum easy-opening structure dimensions (see 4.3.2, Table 5);

---Modified the axial bearing pressure of the tank and the integrity of the coating film in the tank (see 5.2.2, Table 7, and 5.2.1, Table 3 of the 2009 edition);

---Modified the requirements for the integrity of the inner coating film of the aluminum easy-open lid and the quality index of the dry film of the aluminum easy-open lid sealing glue (see 5.3.2, Table 9, and 5.3.1, Table 5 of the 2009 edition);

---Added food safety requirements (see 5.4).

This part is proposed and managed by the National Packaging Standardization Technical

Committee (SAC/TC49).

Drafting organizations of this section. National Packaging Product Quality Supervision and Inspection Center (Guangzhou), COFCO Packaging Investment Co., Ltd., Jiamei Food Packaging (Chuzhou) Co., Ltd., Boer Asia Pacific (Foshan) Metal Container Co., Ltd., Zhuhai Dingli Packaging Products Co., Ltd., Pacific Can (North) Beijing) Co., Ltd., Shanghai Baosteel Packaging Co., Ltd., Shengxing Group Co., Ltd., Fujian Fuzhen Metal Packaging Co., Ltd., Xiamen Baofeng Industrial Co., Ltd., Guangzhou Institute of Quality Supervision and Inspection, Shanghai Baosteel Cover Co., Ltd.

1 Scope

This part of GB/T 9106 specifies the specification classification, structural dimensions, technical requirements, and technical requirements of aluminum easy-opening aluminum cans (hereinafter referred to as two-piece cans) Test methods, inspection rules and signs, packaging, transportation and storage.

This part is applicable to the manufacture, circulation and supervision of unused aluminum easy-open lids and aluminum cans for beer, carbonated and nitrogen-filled beverages for inspection, two-piece cans containing other contents can be used as reference.

2 Normative references

The following documents are indispensable for the application of this document. For dated reference documents, only the dated version applies to this document.

For undated references, the latest version (including all amendments) applies to this document.

GB/T 2828.1-2012 Sampling inspection procedures by attributes Part 1: Batch inspection sampling plan retrieved by acceptance quality limit (AQL) GB/T 4122.4 Packaging Terminology Part 4: Materials and Containers GB 4806.1 National Food Safety Standard General Safety Requirements for Food Contact Materials and Products GB 4806.9 National Food Safety Standard Food Contact Metal Materials and Products GB 4806.10 National Food Safety Standard Food Contact Paints and Coatings GB 4806.11 National Food Safety Standard Food Contact Rubber Materials and Products GB 9685 Food Safety National Standard Food Contact Material and Product Additives Use Standard GB/T 18455 Packaging Recycling Mark

3 Terms and definitions

The terms and definitions defined in GB/T 4122.4 apply to this document.

4.1 Tank

4.1.1

Two-piece cans are divided into 200 series, 202 series and 206 series according to the can mouth model. The main specifications are shown in Table 1.

4.1.2

The model code of the two-piece tank consists of the cover diameter, the mouth diameter code, the tank nominal diameter code, the tank height code and the nominal capacity.

4.2 Aluminum Easy Open Lid

Aluminum easy-open lids are divided into ring-pull type and piece-retained easy-open lids, as shown in Figure 1.

4.3 Structure size

4.3.1

The main dimensions of the tank should meet the requirements of Table 2, Table 3 and Table 4, as shown in Figure 2.

5.1 Basic requirements

5.1.1

The structural dimensions of the product should meet the requirements of 4.3, and the special tank type shall be negotiated between the supplier and the buyer.

5.1.2

The product has different requirements for the physical and chemical properties of the inner coating film and sealant due to the different filling contents.

The manufacturer shall provide samples to the buyer for filling test and obtain confirmation.

5.2.1 Appearance quality

5.2.1.1

The pattern and color of the product should be negotiated between the supplier and the buyer.

5.2.1.2

See Table 6 for the appearance quality requirements of tanks.