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

GB/T 10785-2025

Replacing GB/T 10785-1989

**A series of specification for light gauge metal food containers
open-top-can and metal end**

开顶金属罐及金属盖规格系列

(English Translation)

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Foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for standardization work Part 1: Structure and drafting rules for standardization documents" Drafting.

This document specifies the technical requirements related to quality. For food safety requirements, please refer to relevant laws, regulations, policies and food safety standards. document.

This document replaces GB/T 10785-1989 "Open-top metal round can specification series". Compared with GB/T 10785-1989, except for the structural adjustment in addition to the integration and editorial changes, the main technical changes are as follows.

- Changed the scope (see Chapter 1, Chapter 1 of the 1989 edition);
- Added "Terms and Definitions" (see Chapter 3);
- Changed the classification of metal cans in "Product Classification" (see 4.1.1, Chapter 3 of the 1989 edition);
- Added metal covers for open-top metal cans and their classification in "Product Classification" (see 4.1.2);
- Added "tank type code" (see 4.2);
- Added "metal can height, diameter deviation requirements" and "volume calculation formula" (see 5.1);
- Changed "Specifications and dimensions of open-top round cans" (see 5.1.1, 5.1.2, Chapter 4 of the 1989 edition);
- Added "Specifications and dimensions of open-top non-round cans" (see 5.1.3);
- Added "Specifications and dimensions of metal covers" (see 5.2).

1 Scope

This document specifies the specifications and dimensions of open-top metal cans and easy-open and easy-tear ends.

This document applies to open-top metal cans for food and beverages in the canned food industry and their easy-open and easy-tear covers.

2 Normative references

The contents of the following documents constitute essential clauses of this document through normative references in this document.

For referenced documents without a date, only the version corresponding to that date applies to this document; for referenced documents without a date, the latest version (including all amendments) applies to this document.

ISO 24021-1 Thin-walled metal containers Vocabulary and classification Part 1: Open-top cans and lids (Light gauge metal)

3 Terms and definitions

For the purposes of this document, the terms and definitions defined in ISO 24021-1 and the following apply.

Open top round can roundopen-topcan the metal can is cylindrical in shape, and one end is sealed by double rolling.

Note: The tank whose diameter is smaller than the tank height is called a vertical round tank, otherwise it is called a flat round tank.

Open top irregular can the metal can has a non-cylindrical shape and one end is sealed by double rolling.

Note: Also known as special-shaped cans, common can shapes include square cans, oval cans, trapezoidal cans and horseshoe-shaped cans.

4.1.1 Open-top metal cans

4.1.1.1

According to different structures, they are divided into three-piece cans and two-piece cans.

4.1.1.2

According to their appearance, they are divided into open-top round cans and open-top non-round cans. The specific classification and numbering shall comply with the provisions of Table 1.

Table 1 Classification and numbering of open-top metal cans

Tank type classification number Round cans Three-piece cans are numbered according to inner diameter and outer height Two-piece cans are divided into.200 series, 202 series and 206 series according to the can mouth model.