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Ceylon Standard Specification for Aluminium Foils and Linings

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BUREAU OF CEYLON STANDARDS

CEYLON STANDARD SPECIFICATION FOR ALUMINIUM FOILS AND LININGS

C. S. 120: 1971

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BUREAU OF CEYLON STANDARDS
53, Dharmapala Mawatha,
COLOMBO 3.

Ceylon Standards are subject to periodical revision in order to accomodate the progress made by industry. Suggestions for improvement will be recorded and brought to the notice of the Committees to which the revisions are entrusted.

This Standard does not purport to include all the necessary provisions of a contract.

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CEYLON STANDARD SPECIFICATION FOR ALUMINIUM FOILS AND LININGS

FOREWORD

This Ceylon Standard Specification has been prepared by the Drafting Committee on Aluminium Foils and Linings. It was approved by the Mechanical Engineering Divisional Committee of the Bureau of Ceylon Standards, and was authorised for adoption and publication by the Council of the Bureau on 1971-12 02.

This standard specification was prepared to guide both the consumer and the manufacturer, since a large proportion of our requirements of Aluminium Foils and Linings are manufactured locally.

All quantities and dimensions in this standard have been given in S I. units Inch equivalents have been given in certain places and will be in force until such time as the industry switches over to the metric system completely.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value observed or calculated expressing the result of a test or observation shall be rounded off in accordance with C. S. 102: Ceylon Standard on Presentation of Numerical Values. The number of figures to be retained in the rounded off values shall be the same as that of the specified value in this standard.

In the preparation of this standard, assistance has been derived from the Indian and British Standards.

1. SCOPE

This Ceylon Standard covers requirements for Aluminium Foils and Linings of thickness not exceeding 0.1 mm.

2. TERMINOLOGY

2·1 Light Gauge Foil – Aluminium foil which has a thickness up to and including 0·009 mm.

2·2 Medium Gauge Foil – Aluminium foil which has a thickness over 0·009 mm. and up to and including 0 04 mm.

2·3 Heavy Gauge Foil – Aluminium foil which has thickness over 0·04 mm.

2·4 Tagger Foil – Aluminium foil used in air-tight containers.

2·5 Set of Linings – Three sheets of aluminium foil of appropriate sizes used to line one chest constitute a set.

3. TYPES

3·1 There shall be four types of aluminium foil depending on the purpose for which they are used.

(a) Aluminium foil for caps on glass dairy product containers.

(d) Aluminium for Tea Chest Linings and Desiccated Coconut Chest Linings.

(c) Aluminium Tagger Foil.

(d) Aluminium foil for wrappers.

4. GENERAL REQUIREMENTS FOR ALL TYPES

4·1 Material

4·1·1 Aluminium alloys having either of the following chemical compositions shall be used for the manufacture of Aluminium Foils and Linings. Lubricants wherever used shall be non-toxic. Unless otherwise indicated all limits are maxima.

Grade (1)	Constituent	Percent
	Aluminium not less than	99·0
	Copper	0·10
	Silicon	0·5
	Iron	0·7
	Manganese	0·1
	Zinc	0·1
	Total impurities Cu+Si+Fe+Mn+Zn	1·0

Grade (2)	Constituent	Percent
(For thicknesses above 0·015 mm only)	Copper	0·1
	Magnesium	0·1
	Silicon	0·6
	Iron	0·7
	Manganese	0·8 to 1·5
	Zinc	0·2
	Aluminium	Remainder
	Chromium and Titanium and/or other grain refining elements	0·2

4·1·2 Condition – The material shall be either annealed or of an intermediate temper.

4·1·3 Tensile properties – Tensile strength of the material shall comply with the following requirements:

TABLE 1
TENSILE PROPERTIES

Composition	Condition	Tensile Strength			
		Minimum		Maximum	
		*MPa	kgf/mm²	*MPa	kgf/mm²
Grade 1	Annealed (soft)	—	—	100	10·2
	Intermediate temper	105	10·7	150	15·3
Grade 2	Annealed (soft)	—	—	120	12·2
	Intermediate temper	135	13·8	180	18·4

5. (a) ALUMINIUM FOILS FOR CAPS ON GLASS DAIRY PRODUCT CONTAINERS

5·1 Dimensions

5·1·1 The widths of capping foil shall be as agreed between the manufacturer and the purchaser. The tolerance on the agreed width shall be ± 0·35 mm.

5·1·2 The nominal thickness of capping foil shall be within the range 0·05 mm to 0·06 mm.

5·1·3 There shall normally be no joins in any reel. However a maximum of 2 joins per reel will be permitted if acceptable to the purchaser.

The core shall be made of metal, cardboard or plastics. The ends of the core shall not project beyond the exposed edges of the foil.

5·2 Coating

Capping foil shall be plain or finished with an outer surface coating material and/or printed according to the requirements of the purchaser. Transfer of colouring matter or printing ink to the inner surface of the foil shall not take place.

* MPa = 10^6 Pascal (Pa), 1 Pa = 1 N/m²

Any surface coating used shall not contain substances injurious to health or have any deleterious effect on the quality, flavour, odour or appearance of the dairy product.

Capping foil shall be supplied in the pre-lubricated condition unless otherwise specified by the purchaser. The quality of the lubricant shall be such that surfaces of the foil will retain their brightness and will not stick.

5·3 Finish

5·3·1 Aluminium capping foil shall be free from nicks, burrs or creases and there shall be no perforrations when tested in accordance with the method given in Appendix C.

5·4 Sampling

5·4·1 Lot – In any consignment all the reels of one size and quality manufactured at the same place on one date shall be grouped together to constitute a lot.

5·4·2 The number of reels to be examined from each lot shall be in accordance with Table 2 and the reels shall be selected at random.

TABLE 2

NUMBER OF REELS TO BE EXAMINED AND PERMISSIBLE NUMBER OF DEFECTIVE REELS

No. of reels in the lot (1)	Sample size (2)	Permissible no· of defective reels (3)
Up to 10	All	0
11 - 50	10	1
51 - 150	15	1
151 - 300	25	2
301 - 500	30	3

5·5 Examinations and Tests

5·5·1 4 test pieces shall be taken from each reel selected as in 5·4 and from any part of the reel excluding the first and last metres.

5·5·2 The following tests shall be carried out as described in the Appendices. One test piece shall be used for each test.

(i) Perforation test (Clause 5·3·1).

(ii) Tensile test (Clause 4·1·3).

(iii) Coating test in case of coated foil.

(iv) Test for thickness and width (Cluase 5·1).

5·6 Conformity to Standard

5·6·1 A reel selected as in 5·4 shall be considered as conforming to requirements of this standard if all test pieces pass the tests mentioned in 5·5·2.

5·6·2 The lot shall be considered as conforming to requirements of this standard if the number of defective reels is less than the number specified in column 3 of Table 2.

5·7 Packing and Marking

5·7·1 Reels shall be packed as agreed between the manufacturer and the purchaser.

5·7·2 Each reel shall have printed labels pasted to the two ends with the following information.

(i) Manufacturer's name or trade mark.

(ii) Date of manufacture.

(iii) Nominal thickness and width of the foil.

(iv) Type of surface coating (i. e. plain, lacquered or printed).

(v) Mass in kilogrammes.

When packed, the outside of the package shall also be marked with the above information.

5·7·3 The cores shall be marked with the manufacturer's name or trade mark.

6. (b) ALUMINIUM FOILS FOR TEA CHEST LININGS AND DESICCATED COCOUNT CHEST LININGS

6·1 Dimensions

6·1·1 Dimensions and tolerances on dimensions of aluminium foils for tea chest linings shall be as given in Table 3 (a) or Table 3 (b).

TABLE 3 (a)

METRIC DIMENSIONS FOR TEA CHEST LININGS

Length mm	Tolerance on length mm	Width mm	Tolerance on width mm	No. of sheets in a set
1650	$^{+\ 100}_{-\ 2}$	650	± 2	1
425	± 2	425	± 2	2
1850	$^{+\ 100}_{-\ 2}$	650	± 2	1
525	± 2	425	± 2	2
2134	$^{+\ 100}_{-\ 2}$	508	± 2	1
635	± 2	508	± 2	2
1675	$^{+\ 100}_{-\ 2}$	457	± 2	1
457	± 2	457	± 2	2

TABLE 3 (b)

INCH DIMENSIONS FOR TEA CHEST LININGS

Length in	Tolerance on length in	Width in	Tolerance on width in	No. of sheets in a set
66	$^{+\ 4}_{-\ 0{\cdot}1}$	26	± 0·1	1
17	± 0·1	17	± 0·1	2
74	$^{+\ 4}_{-\ 0{\cdot}1}$	26	± 0·1	1
21	± 0·1	17	± 0·1	2
84	$^{+\ 4}_{-\ 0{\cdot}1}$	20	± 0·1	1
25	± 0·1	20	± 0·1	2
67	$^{+\ 4}_{-\ 0{\cdot}1}$	18	± 0·1	1
18	± 0·1	18	± 0·1	2

6·1·2 The thickness of aluminium foils for tea chest linings shall be between 0·020 and 0·028 mm and the tolerance allowed on the agreed thickness shall be ± 8%.

6·1·3 Dimensions and tolerances on dimensions of aluminium foils for desiccated coconut chest linings shall be as given in Table 4 (a) or Table 4 (b).

TABLE 4 (a)

METRIC DIMENSIONS FOR DESICCATED COCONUT CHEST LININGS

Length mm	Tolerance on length mm	Breadth mm	Tolerance on breadth mm	No. of sheets in a set
2134	+ 100 − 2	508	± 2	1
635	± 2	508	± 2	2

TABLE 4 (b)

INCH DIMENSIONS FOR DESICCATED COCONUT CHEST LININGS

Length in	Tolerance on length in	Breadth in	Tolerance on breadth in	No. of sheets in a set
84	+ 4 − 0·1	20	± 0·1	1
25	± 0·1	20	± 0·1	2

6·1·4 The nominal thickness of aluminium foil for desiccated coconut chest linings shall be 0·017 mm and the tolerance shall be ± 8%.

6·2 Finish

6·2·1 Aluminium foils for tea chest linings shall be interleaved with tissue paper and should be free from nicks, burrs or creases. The number of perforations per square metre of the foil shall not exceed 200 when tested by the method given in Appendix C.

6·2·2 Aluminium foils for desiccated coconut chest linings shall be interleaved with grease proof paper and should be free from nicks, burrs or creases. The number of perforations per square metre of the foil shall not exceed 300 when tested by the method given in Appendix C.

6·2·3 Tissue or grease proof paper should be free from any substance injurious to health or have any deleterious effect on the quality of the packed material.

6·3 Packing and Marking

6·3·1 50 sets of the same type and of the same dimensions shall be wrapped in paper to form a bundle. The bundles shall be packed in boxes as agreed between the manufacturer and the purchaser.

6·3·2 Each bundle and box shall be marked with the following information:

(i) Manufacturer's name or trade mark.

(ii) Date of manufacture.

(iii) Type of linings (i. e. whether it is for packing tea or desiccated coconut).

(iv) Nominal thickness of foil and the length and breadth.

(v) Number of sets in a bundle or box.

6·4 Sampling

6·4·1 **Lot** – In any consignment all the bundles containing one type of linings manufactured at the same place on one date shall be grouped together constitute a lot.

6·4·2 The selection of sets for examination shall be as follows: Sets shall be selected at random as in Table 5, from at least 10% of the bundles.

TABLE 5

NUMBER OF SETS TO BE SELECTED AND PERMISSIBLE NUMBER OF DEFECTIVE SETS

No. of sets in the lot (1)			Sample size (2)	Permissible no. of defective sets (3)
Up to		10	All	0
11	—	50	10	1
51	—	200	15	1
201	—	1 000	20	1
1 000	—	5 000	40	2
5 001	—	10 000	60	3
10 001	—	30 000	75	4
30 001	—	50 000	90	5

6·5 Examination and Tests

6·5·1 3 test pieces shall be taken from each sheet in a set selected as in 6·4· The following tests shall be carried out for each sheet as described in the Appendix.

(i) Perforation test (Clause 6·2).

(ii) Tensile test (Clause 4·1·3).

(iii) Test for thickness and other dimensions (Clause 6·1).

6·6 Conformity to Standard

6·6·1 A set selected as in 6·4 shall be considered as conforming to requirements of this standard if all the test pieces from the selected set pass the tests given in clause 6·5·1·

In case of failure, one more set shall be taken from the same bundle and tests shall be carried out.

Should the additional test pieces pass the tests, the set represented shall be accepted as conforming to this standard. If the re-test pieces fail the re test, the set represented shall be considered as not conforming to this standard.

6·6·2 The lot shall be considered as conforming to requirements of this standard if the number of defective sets is less than the number given in column 3 of Table 5.

7. (c) ALUMINIUM TAGGER FOIL

7·1 Dimensions

7·1·1 The thickness of Aluminium Tagger Foil shall be as agreed between the manufacturer and the purchaser. The tolerance on the agreed thickness shall be + 8%.

7·1·2 Foil shall be supplied in reels, and the width and the reel diameter shall be as agreed between the manufacturer and the purchaser. The tolerance on agreed width shall be ± 0.35mm.

7·1·3 There shall normally be no joins in any reel. However a maximum of two joins per reel will be permitted if acceptable to the purchaser.

The core shall be made of metal, cardboard or plastics. The ends of the core shall not project beyond the exposed edges of the foil.

7·2 Finish

7·2·1 Tagger foil shall be free from nicks, burrs or creases, and there shall be no perforations when tested by the method given in Appendix C. It shall be plain or printed according to the requirements of the purchaser.

7·3 Sampling

7·3·1 Sampling shall be as in 5·4.

7·4 Examination and Tests

7·4·1 Examination and tests shall be as in 5·5.

7·5 Conformity to Standard

7·5·1 Requirements shall be as in 5·6.

7·6 Packing and Marking

7·6·1 Packing and Marking shall be as in 5·7.

8. (d) ALUMINIUM FOILS FOR WRAPPERS

8·1 Dimensions

8·1·1 Light Gauge Foils and Medium Gauge Foils shall be used for wrappers. The tolerance on the thickness of Light Gauge Foil shall be ± 5%, and the tolerance on the thickness of Medium Gauge Foil shall be ± 8%.

8·1·2 Aluminium foil for wrappers shall be supplied in reels or packets of sheets and the dimensions shall be as agreed between the manufacturer and the purchaser. The tolerance on the width in case of reels shall be ± 0·35 mm. In the case of sheets the tolerance on length and breadth shall be ± 2 mm.

8·1·3 In case of reels, the core shall be made of metal, cardboard or plastics and the internal diameter shall be as agreed between the manufacturer and the purchaser. The ends of the core shall not project beyond the exposed edges of the foil.

8·2 Finish

8·2·1 Aluminium foils shall be supplied in any one or more of the following finishes.

(i) With a protective coating on the surface.

(ii) Interleaved with tissue paper.

(iii) Gummend to tissue or any other type of paper.

(iv) Waxed to tissue or any other type of paper.

(v) Laminated to polythene.

(vi) With heat sealing coating acceptable to the trade.

The composition of the protective or heat sealing coating shall be such that it does not introduce into the product wrapped substances injurious to health or have deleterious effects on the flavour or odour.

The surface shall be plain, printed, embossed or as agreed between the manufacturer and the purchaser. There shall normally be no joins in any reel. However a maximum of two joins per 1 000 metres of foil will be permitted if acceptable to the purchaser.

The thickness of the polythene film shall be as agreed between the manufacturer and the purchaser. The tolerance on the agreed thickness shall be ± 10%.

8·2·2 The number of perforations per square metre shall not exceed the limits given below when tested by the method given in the Appendix C.

Thickness of Foil (mm)	No. of Perforations
0·009	480
0·017	300
0·025	200
0·040	100

8·2·3 The moisture content shall be between 5% and 6% or as specified by the purchaser.

8·3 Packing and Marking

8·3·1 In case of reels packing and marking shall be as in 5·7.

8·3·2 When the foil is in the form of sheets, it shall be supplied in packets of 500 sheets and the packets shall be packed in boxes or as agreed between the manufacturer and the purchaser. Each packet or box shall have on it the following information:

(i) Manufacturer's name or trade mark.

(ii) Date of manufacture.

(iii) Description of the type of foil.

(iv) Nominal thickness and size.

(v) Nett mass and/or nett metal mass in kilogrammes.

8·4 Sampling

8·4·1 In case of reels, sampling shall be as follows:

8·4·1·1 Lot – In any consignment, all the reels of one size and quality manufactured at the same place on one date shall be grouped together to constitute a lot.

8·4·1·2 Reels shall be seleted at random as in Table 6 A.

TABLE 6 A

NUMBER OF REELS TO BE SELECTED AND PERMISSIBLE NUMBER OF DEFECTIVE REELS

No. of reels in the lot (1)	Sample size (2)	Permissible no. of defective reels (3)
Up to 10	All	0
11 — 50	10	1
51 — 200	15	1
201 — 500	20	2
501 — 1 000	30	2
1 001 — 3 000	40	3

8·4·2 In case of packets, sampling shall be as follows:

8·4·2·1 Lot – In any consignment, all the packets containing sheets of one type and one size manufactured at the same place on one date shall be grouped together to constitue a lot.

8·4·2·2 The selection of sheets for examination shall be as follows:

5 sheets shall be selected at random from each packet selected as in Table 6 B.

TABLE 6 B

NUMBER OF PACKETS TO BE SELECTED AND PERMISSIBLE NUMBER OF DEFECTIVE PACKETS

No. of packets in the lot (1)			Sample size (2)	Permissible no. of defective packets (3)
Up to		10	All	0
11	—	50	10	1
51	—	150	15	1
151	—	300	30	2
301	—	500	40	2
501	—	1 000	60	3

8·5 Examination and Tests

8·5 1 In case of reels, 5 test pieces shall be taken from any part of the reel excluding the first and last metres, and shall be subjected to tests given in 8·5 3.

8 5·2 In case of packets, a test piece shall be taken from each sheet selected as in 8·4·2·2.

8·5 3 The following tests shall be carried out as described in the Appendices. One test piece shall be used for each test.

(i) Perforation test (Clause 8·2·2).

(ii) Tensile test (Clause 4·1·3).

(iii) Test for thickness and other dimensions (Clause 8·1).

(iv) Moisture test.

(v) Coating test in the case of coated foils.

8·6 Conformity to Standard

8·6·1 A reel shall be considered as conforming to requirements of this standard if all test pieces selected as in 8·5·1 pass the tests mentioned in clause 8·5·3.

8·6·2 A packet shall be considered as conforming to requirements of this standard if all test pieces selected as in 8·5·2 pass the tests mentioned in clause 8·5·3.

8·6·3 The lot shall be considered as conforming to requirements of this standard if the number of defective reels or packet is less than the number given in column 3 of Table 6A in case of reels and column 3 of Table 6B in case of packets.

APPENDIX A

METHOD FOR DETERMINING THE THICKNESS OF FOIL AND THE MASS OF APPLIED FILM

A-1 **PROCEDURE** – Prepare specimens of the material of known area from flat uncreased samples by cutting round a metal template with bevelled edges with a sharp knife.

Remove any printing lacquer and lubricant by washing the surface with a suitable solvent, e.g. acetone.

Dry the specimens and weigh on a balance accurate to at least 5 mg. and record the mass in grammes, x

Immerse the specimens in a suitable solvent until the film begins to separate. Then strip the film from the foil, re-immerse in the solvent, and rub gently with cotton wool until all traces of the substrate, if any, are removed.

Then dry the foil and weigh on the balance, recording the mass in grammes, y.

A-2 **CALCULATION OF RESULTS**

For a specimen of A m^2 area.

(1) $\frac{y}{A}$ = mass of foil per unit area, in $g/m.^2$

$$\text{Thickness of foil, mm} = \frac{\text{mass per unit area } (g/m^2) \times 10^{-3}}{\text{density of foil } (kg/m^3)}$$

Where density of foil made of grade (1) aluminium = $2 \cdot 71\ kg/m^3$
and density of foil made of grade (2) aluminium = $2 \cdot 73\ kg/m^3$

(2) $\frac{x - y}{A}$ = mass of film per unit area, in g/m^2

Thickness of film, mm

$$= \frac{\text{mass of film per unit area } (g/m^2) \times 10^{-3}}{\text{density of film } (kg/m^3)}$$

where for example, density of low density polythene = 0.92 kg/m^3

APPENDIX B

COATING TEST

B-1 REAGENTS

B-1·1 All reagents shall be of recognized analytical reagent quality.

B-1·2 **Acid testing solution**

Dissolve 1 g of copper sulphate pentahydrate ($CuSO_4 \cdot 5H_2O$). in 5 ml of concentrated hydrochloric acid (d_{20} = 1·18) and make up to 100 ml with distilled water.

B-2 PROCEDURE

Cut a flat sheet of the foil and float with the protective coating downwards on a bath of the above solution. At the end of 30 minutes examine the sheet with the naked eye. No corrosion shall be visible except at the edges.

APPENDIX C

PERFORATION TEST

A suitable form of apparatus is shown in Fig. 1 for the determination of the number of perforations.

Mount a 40 watt pearl or opal electric bulb in a wooden box about 180mm long, 130mm wide and 110mm deep. Across the top of the box place piece of ground or opal glass and about 7mm above it a piece of clear glass, the box and the space between the two sheets of glass being ventilated.

Fold a sheet of dark coloured opaque paper about 560mm x 300mm to form a double sheet 280mm x 300. Cut a rectangular hole in the cetre of the double sheet, the side at right angles to the folded edge of the paper being about 10mm less in length than the width of the foil strip to be examined, and the other side being about 50mm long. Fold the paper over the top and two sides of the box and secure it by means of elastic bands as shown in Fig. 1.

Use the apparatus in a darkened room with the lamp turned on. Attach the coated foil to be examined to a piece of stiff paper threaded between the two layers of opaque, and draw it through intermittently about 40mm at a time so as to close the illuminated window. The perforations may easily be seen and counted.

The number of perforations per square metre may be calculated from the number observed, the length of strip examined, and the width of the illuminated window.

Small sheets may be examined by placing them in turn over an illuminated window of the same shape as the sheet but of a smaller size.

APPENDIX D

MOISTURE TEST

Prepare specimens of the material of known area from flat uncreased samples by cutting round a metal template with bevelled edges with a sharp knife.

Weigh the specimen accurately and keep in an oven at $105° \pm 2°C$ At the end of one hour remove the specimen and weigh it again. The difference in the readings gives the moisture content which could be expressed as g/m^2 or per cent by mass.

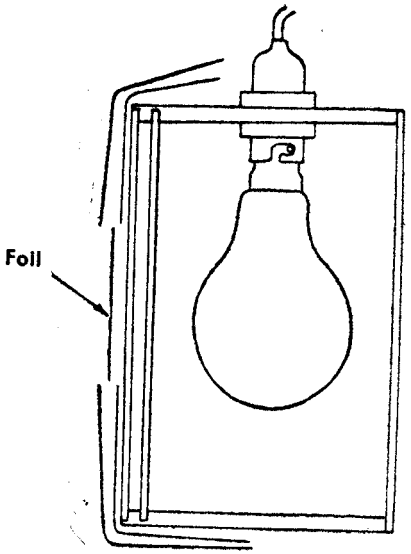
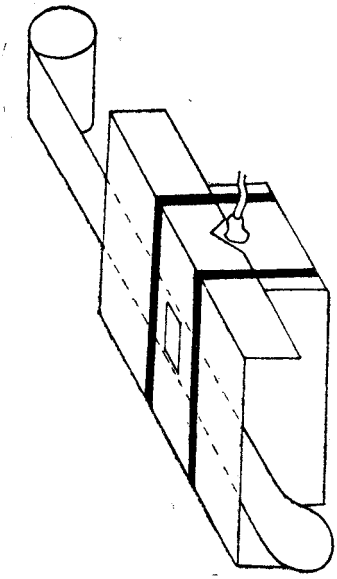


Fig. 1



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