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Agglomerated cork discs — Specifications

Disques en aggloméré composé de liège — Spécifications

Reference number
ISO 4711:1987 (E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 4711 was prepared by Technical Committee ISO/TC 87, *Cork*.

Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

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Agglomerated cork discs — Specifications

1 Scope and field of application

This International Standard specifies the characteristics of agglomerated cork discs for crown and screw caps intended to provide impermeable closure, and the conditions of packing.

2 References

ISO 2859, *Sampling procedures and tables for inspection by attributes.*

ISO 3951, *Sampling procedures and charts for inspection by variables for per cent defective.*

ISO 8507, *Agglomerated cork discs — Methods of test.*

3 Classification and characteristics

3.1 Classification of discs for crown caps

These discs are classified on the basis of their behaviour under pressure into five types:

- Type A: 100 % of the discs are resistant to a pressure of 1 MPa.
- Type B: 100 % of the discs are resistant to a pressure of 0,75 MPa.
- Type C: 100 % of the discs are resistant to a pressure of 0,50 MPa.
- Type D: more than 50 % of the discs are resistant to a pressure of 0,50 MPa.
- Type E: less than 50 % of the discs are resistant to a pressure of 0,50 MPa.

The behaviour under pressure shall be determined in accordance with ISO 8507.

3.2 Moisture content

The moisture content, determined in accordance with ISO 8507, shall be less than

- 8 % for cork discs for crown caps;
- 10 % for cork discs for screw caps.

3.3 Finishing

The bases of the discs shall be perfectly circular and parallel, with the edges well cut so that an angle as near as possible to 90° is formed between the bases and the surface formed.

Examination in accordance with ISO 8507 shall not reveal any foreign bodies, scraps, cork granules or mildew.

3.4 Dimensional tolerances

Diameter and thickness values, determined in accordance with ISO 8507, shall be agreed between the interested parties. The permissible tolerances are shown in the table.

Table

Tolerance	Discs for crown caps	Discs for screw caps
on diameter	± 0,2 mm	+ ^{0,3} ₀ mm
on thickness	± 0,1 mm	± 0,2 mm

3.5 Flexibility

If a disc is rolled around a mandrel, in accordance with ISO 8507, it shall not break or show signs of separation of granules.

NOTE — For discs cut from cork agglomerate boards, it is possible to verify flexibility on strips cut from the board.