
**Paper and board — Specification for
internal diameters of cores for reels**

*Papier et carton — Spécification des diamètres intérieurs des mandrins
pour bobines*



Reference number
ISO 13542:2006(E)

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Published in Switzerland

Foreword

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Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 13542 was prepared by Technical Committee ISO/TC 6, *Paper, board and pulps*.

This second edition cancels and replaces the first edition (ISO 13542:1995), which has been technically revised.

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Paper and board — Specification for internal diameters of cores for reels

1 Scope

This International Standard specifies the internal diameters and tolerances for cores recommended for general use with reels of paper and board in international trade.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 11093-4, Paper and board — *Testing of cores — Part 4: Measurement of dimensions*

3 Dimensions of internal diameters

The internal diameter of cores shall be as specified in Table 1 when determined in accordance with ISO 11093-4.

The difference in length between any two perpendicular internal diameters shall not exceed 0,5 mm for cores with an internal diameter < 70 mm, and 1,5 mm for cores with an internal diameter \geq 70 mm.

Table 1 — Internal diameters of cores

Dimensions in millimetres

Nominal internal diameter	Tolerances	Nominal internal diameter	Tolerances
10	$\begin{matrix} +0,5 \\ 0 \end{matrix}$	76	$\begin{matrix} +1,2 \\ 0 \end{matrix}$
12	$\begin{matrix} +0,5 \\ 0 \end{matrix}$	100	$\begin{matrix} +1,4 \\ 0 \end{matrix}$
18	$\begin{matrix} +0,5 \\ 0 \end{matrix}$	120	$\begin{matrix} +1,6 \\ 0 \end{matrix}$
25	$\begin{matrix} +0,5 \\ 0 \end{matrix}$	150	$\begin{matrix} +1,6 \\ 0 \end{matrix}$
30	$\begin{matrix} +0,5 \\ 0 \end{matrix}$	200	$\begin{matrix} +2,0 \\ 0 \end{matrix}$
40	$\begin{matrix} +0,5 \\ 0 \end{matrix}$	250	$\begin{matrix} +2,5 \\ 0 \end{matrix}$
50	$\begin{matrix} +0,5 \\ 0 \end{matrix}$	300	$\begin{matrix} +3,0 \\ 0 \end{matrix}$
60	$\begin{matrix} +0,5 \\ 0 \end{matrix}$	400	$\begin{matrix} +3,0 \\ 0 \end{matrix}$
70	$\begin{matrix} +1 \\ 0 \end{matrix}$		

4 Report

The report shall include the following information:

- a) a reference to this International Standard;
- b) a reference to ISO 11093-4 for determination of the internal diameter.

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ICS 85.060

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