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**Cereals — Determination of bulk density,  
called “mass per hectolitre” —**

**Part 1:  
Reference method**

*Céréales — Détermination de la masse volumique, dite «masse à l'hectolitre» —*

*Partie 1: Méthode de référence*

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## Foreword

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International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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 7971-1 was prepared by Technical Committee ISO/TC 34, *Food products*, Subcommittee SC 4, *Cereals and pulses*.

This first edition of ISO 7971-1 cancels and replaces ISO 7970:1986, which has been editorially revised. The title has been changed to make it Part 1.

ISO 7971 consists of the following parts, under the general title *Cereals — Determination of bulk density, called "mass per hectolitre"*:

- *Part 1: Reference method*
- *Part 2: Routine method*



# Cereals — Determination of bulk density, called “mass per hectolitre” —

## Part 1: Reference method

### 1 Scope

This part of ISO 7971 specifies the reference method for the determination of bulk density, called “mass per hectolitre”, of cereals.

NOTE Several routine methods are used in different countries. A routine method for the determination of bulk density, called “mass per hectolitre” utilizing a 1 litre measuring container is given in ISO 7971-2 <sup>[1]</sup>.

### 2 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

#### 2.1

##### mass per hectolitre

ratio of the mass of a cereal to the volume it occupies after being poured into a container under well-defined conditions

NOTE It is expressed in kilograms per hectolitre at a stated moisture content.

### 3 Principle

A sample is poured in a controlled manner from a hopper into a 20 l container, which is then weighed.

### 4 Requirements for apparatus

#### 4.1 General

The apparatus used shall comply with the following requirements, which correspond to those in OIML Recommendations R 15 <sup>[2]</sup>, and shall be similar to that shown in Figure 1.

NOTE For information, the requirements for the apparatus specified in this International Standard comply with those prescribed in the relevant Council Directive of the European Communities <sup>[3]</sup>.

#### 4.2 Description and operation

##### 4.2.1 Pre-filling measure

The pre-filling measure has a capacity of 24 l. Its internal form is a right circular cylinder with height approximately equal to its diameter.

Dimensions in millimetres

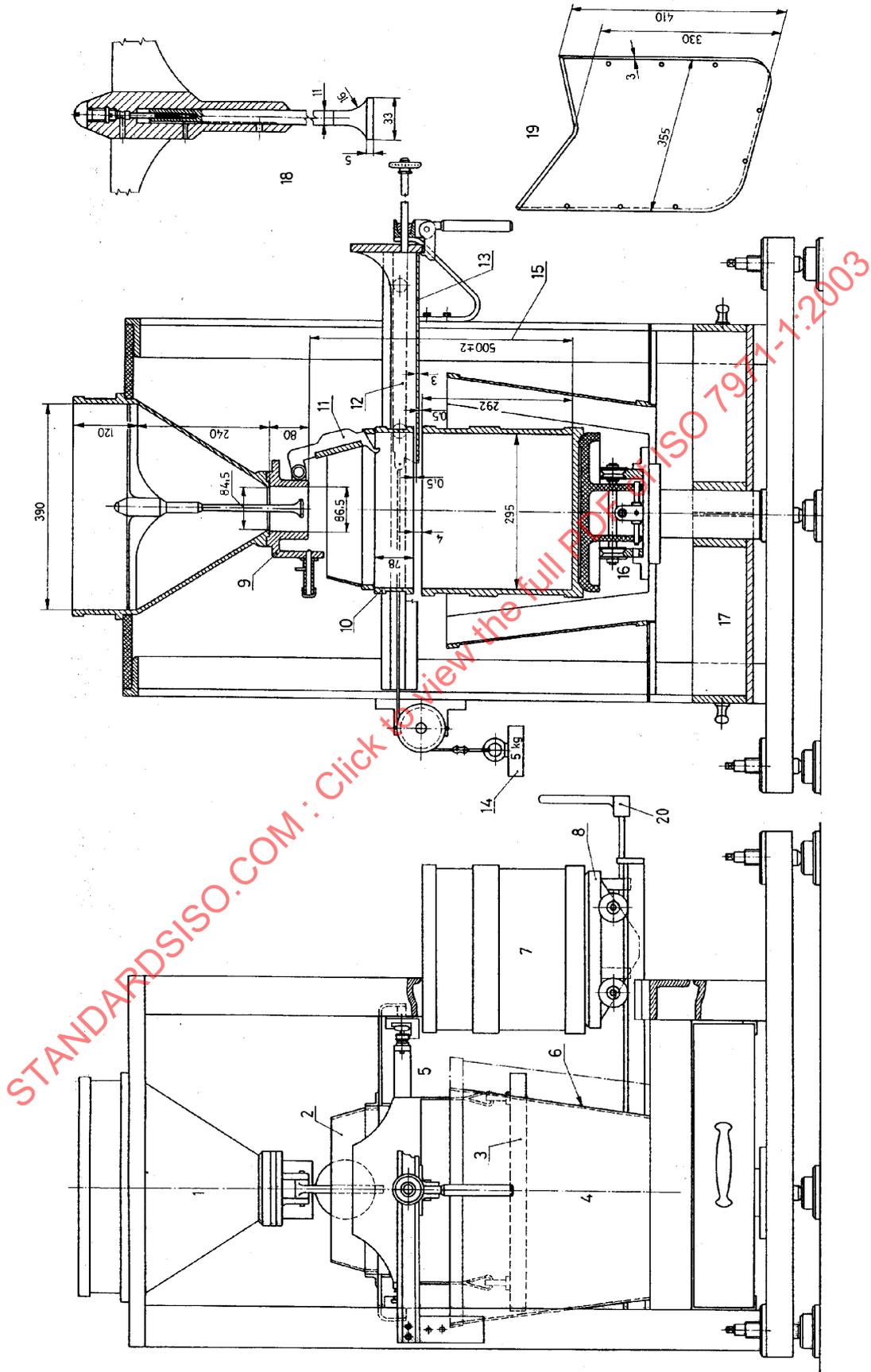


Figure 1 — Apparatus for determining bulk density of cereals

**Key**

1	filling hopper	7	20 l measuring container	15	height of flow
2	truncated cone for guiding the flow of grain	8	base support of measuring container	16	wedged base support of measuring container in filling position
3	straightedge counterweight	9	tapered emptying tube	17	collecting box for surplus grain
4	guiding skirt for surplus grain	10	guiding collar for grain flow	18	distributor
5	guide by rail and rollers of the frame of the straightedge	11	shutter	19	straightedge
6	removable part of skirt allowing the measuring container to be removed	12	frame of straightedge	20	handle of wedge for base support
		13	straightedge		
		14	straightedge counterweight		

NOTE This figure is for information only except for the dimensions shown, which are obligatory.

**Figure 1 — Apparatus for determining bulk density of cereals** (*continued*)

#### 4.2.2 Filling hopper

The hopper has the shape of a truncated vertical circular cone surmounted by a cylindrical rim. Its lower part terminates in an axial tube with a slightly tapering bore, the wider end of which is at the bottom. A shutter, hinge-mounted on the tube and able to close the tube completely, controls the emptying process.

The hopper receives from the pre-filling measure a quantity of grain greater than the capacity of the measuring container.

#### 4.2.3 Distributor

The distributor is an inverted circular mushroom-shaped element connected to the bottom end of a vertical rod positioned in the axis of the hopper.

The rod lowers the distributor inside the tapered tube to an adjustable level from top to bottom to allow adjustment of the apparatus: lowering the distributor increases the rate of flow of the grain, which collects in greater quantity owing to compaction in the measuring container, thus giving higher results; conversely, the results are lower when the distributor is raised.

#### 4.2.4 Measuring container

The measuring container has a capacity of 20 l. Its internal form is a right circular cylinder with height approximately equal to its diameter. Its upper edge is ground flat.

#### 4.2.5 Base support for the measuring container

A base on rails supports the container and allows it to travel underneath the hopper, in the axis of which it can be locked, or taken out of the chassis for easy removal.

#### 4.2.6 Protection and guiding collar for grain flow

A cylindrical collar, of the same diameter as the measuring container, is placed between the hopper and the measuring container, leaving a horizontal space between its lower edge and the upper edge of the container to allow the passage of a straightedge.

During filling, the collar, which is surmounted by a truncated cone-shaped section, protects the grain as it drops and at the end retains the surplus grain.

#### 4.2.7 Straightedge (levelling blade)

The straightedge is a flat, thin but rigid steel blade, sharpened to the form of an open V at the front. It is fixed horizontally in a frame mounted on rollers and driven in its plane by a counterweight.

The frame guides the straightedge across the grain in the gap between the collar and the upper edge of the measuring container. The movement shall be continuous and not jerky, and the straightedge shall touch neither the collar nor the container.

In its movement, the straightedge levels the grain to the level of the measuring container, thus giving a determined volume.

#### 4.2.8 Collecting box for surplus grain

At the same time as levelling the grain, the straightedge also closes off the lower surface of the collar as it removes from the container any grain surplus to its capacity.

When the straightedge is drawn back, with the container removed, this surplus grain falls into a collecting box placed beneath the base of the container and towards which the grain is guided by a skirt.

#### 4.2.9 Overall assembly

The apparatus is assembled in a rigid chassis equipped with a verticality adjustment screw; verticality is checked by means of a plumb-line or a spirit-level.

The hopper with its tube and distributor, the collar and the measuring container shall be coaxial and positioned vertically by means of the adjustment device described above, the upper edge of the measuring container thus being horizontal.

#### 4.2.10 Weighing device

The grain contained in the measuring container is weighed using an equal-beam balance which has been weighted to compensate for the mass of the empty container. Therefore, one single weighing gives the mass of the grain.

### 4.3 Dimensions

#### 4.3.1 Pre-filling measure

This shall have the following dimensions:

- volume to top: 24 l  $\pm$  0,1 l;
- internal diameter: 300 mm  $\pm$  10 mm;
- internal height: approximately 340 mm, adjusted to obtain the specified volume.

#### 4.3.2 Filling hopper

This shall have the following dimensions:

- a) top rim
  - internal diameter: 390 mm  $\pm$  1 mm,
  - height: 120 mm  $\pm$  2 mm;

- b) truncated-cone body
- upper internal diameter: 390 mm  $\pm$  1 mm,
  - lower internal diameter: 84,5 mm  $\pm$  0,2 mm,
  - height: 240 mm  $\pm$  1 mm;
- c) emptying tube
- top internal diameter: 84,5 mm  $\pm$  0,2 mm,
  - bottom internal diameter: 86,5 mm  $\pm$  0,2 mm,
  - length: 80 mm  $\pm$  0,5 mm.

#### 4.3.3 Distributor

This shall have the following dimensions:

- a) diameter of the rod: 11 mm  $\pm$  0,2 mm;
- b) mushroom-shaped element
- diameter: 33 mm  $\pm$  0,2 mm,
  - head thickness: 5 mm  $\pm$  0,2 mm,
  - connecting radius to the rod: 16 mm  $\pm$  0,5 mm;
- c) distance from bottom surface of mushroom to bottom end of emptying tube: 14 mm  $\pm$  0,5 mm<sup>1)</sup>.

#### 4.3.4 Measuring container

This shall have the following dimensions:

- volume up to ground top: 20 l  $\pm$  0,01 l;
- internal diameter: 295 mm  $\pm$  1 mm;
- internal height: approximately 292 mm, adjusted to obtain the specified volume.

#### 4.3.5 Base support for measuring container

This shall have the following dimensions:

- distance between bottom of inside of container and bottom end of emptying tube: 500 mm  $\pm$  2 mm;
- distance between top of container and lower surface of straightedge: 0,5 mm  $\pm$  0,2 mm.

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1) For instruments which are not compared with the international standard apparatus (see definition in OIML Recommendations R 15), this distance is fixed definitively during construction as  $\pm$  0,5 mm. For instruments which have been compared with the international standard apparatus, this distance is fixed during the comparison.

**4.3.6 Protection and guiding collar for grain flow**

This shall have the following dimensions:

- internal diameter: 295 mm ± 1 mm;
- height: 78 mm ± 2 mm;
- distance between lower edge of collar and upper surface of straightedge: 0,5 mm ± 0,2 mm.

**4.3.7 Straightedge (levelling blade)**

This shall have the following dimensions:

- thickness of blade: 3 mm ± 0,2 mm;
- mass of driving counterweight: 5 kg ± 0,1 kg.

**4.3.8 Chassis**

A plumb-line shall be provided of length at least 500 mm (or spirit-level of the same sensitivity), for checking verticality.

**4.4 Calibration and adjustment**

**4.4.1 Calibration**

Calibration of the apparatus (I) is carried out by comparison with a national or international standard apparatus<sup>2)</sup> (E).

Use a cereal free from impurities, at the same temperature and under the same condition of humidity as the atmosphere of the room where the measurement is to be made. For this purpose, spread the cereal in a thin layer and leave it for 10 h (one night) in the room where the measurement is to be made, ensuring that the relative humidity of the air does not exceed 60 %.

Carry out six measurements with each apparatus, using the same sample of 24 l of grain, in the following order. Before each new measurement, the grain contained in the measuring container should be well mixed with the grain that has fallen into the collecting box during the previous measurement.

Measurement No.	1	2	3	4	5	6
Order of measurements	E-I	I-E	E-I	I-E	E-I	I-E

**4.4.2 Accuracy error**

The accuracy error of the apparatus is the difference between the arithmetic mean of the six measurements using apparatus I and the arithmetic mean of the six measurements using apparatus E.

The maximum permissible accuracy error is ± 10 g.

**4.4.3 Adjustment**

If the maximum permissible error specified in 4.4.2 is exceeded, the apparatus shall be adjusted by changing the height of the distributor (4.2.3). In this case, repeat the test described in 4.4.1.

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2) See definition in OIML Recommendations R 15.

## 5 Sampling

It is important the laboratory receive a sample which is truly representative and has not been damaged or changed during transport or storage.

Sampling is not part of the method specified in this part of ISO 7971. A recommended sampling method is given in ISO 13690 [4].

## 6 Procedure

### 6.1 Preliminary operations

Place the measuring container (4.2.4) in its filling position and lock it in place so that its axis coincides with that of the guiding collar (4.2.6) and the filling hopper (4.2.2). Bring the straightedge (4.2.7) to its starting position and lock it in place. Close the shutter of the emptying tube. Check the verticality of the chassis and, if necessary, adjust it with the regulating screw so that the upper edge of the measuring container is horizontal during filling.

### 6.2 Determination

Fill the pre-filling measure (4.2.1) to the top with the cereal, without compacting the grain, and pour the contents of the measure into the filling hopper (4.2.2) with the shutter in place. Open the shutter and let all the grain flow into the measuring container (4.2.4) and the protection and guiding collar (4.2.6). When the hopper is empty, release the retaining screw of the straightedge (4.2.7). As soon as the straightedge has reached its final position, unlock the measuring container, remove it from its rolling base and weigh its contents to the nearest 5 g using the weighing device (4.2.10).

Return the straightedge to its starting position and lock it in place, allowing the surplus grain to pass from the protection and guiding collar into the collecting box (4.2.8).

## 7 Expression of results

The bulk density,  $\rho$ , expressed in kilograms per hectolitre, equals

$$\rho = \frac{m}{0,2} = 5m$$

where  $m$  is the mass, in kilograms, of cereal contained in the 20 l measuring container.

Express the result to two decimal places.

## 8 Test report

The test report shall specify:

- a) all information necessary for the complete identification of the sample;
- b) the sampling method used, if known;
- c) the test method used, with reference to this part of ISO 7971;
- d) all operating details not specified in this part of ISO 7971, or regarded as optional, together with details of any incidents which may have influenced the test results.