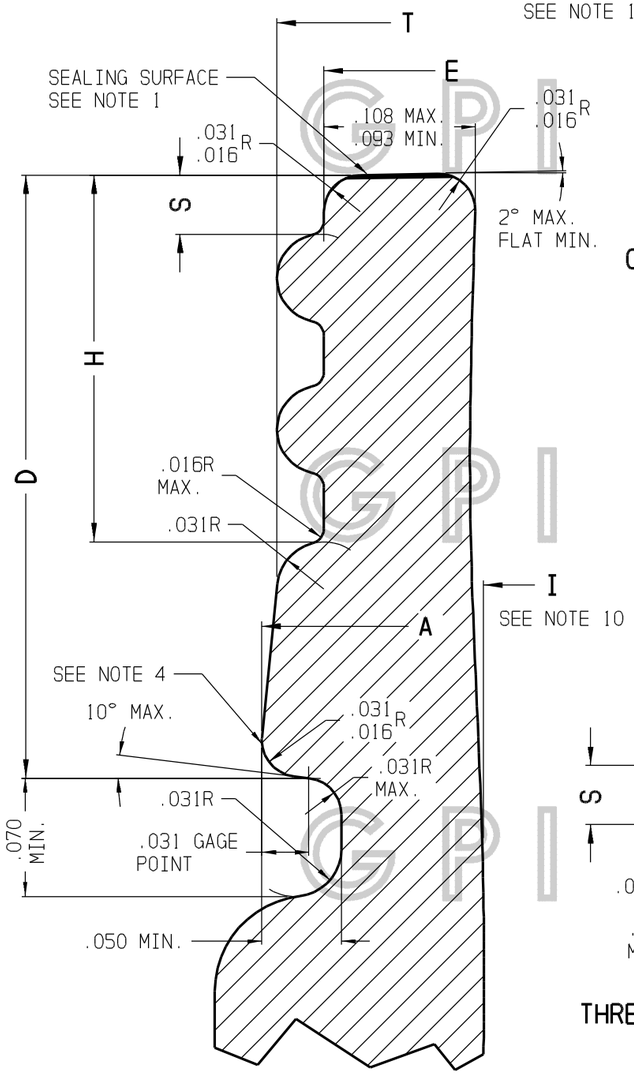
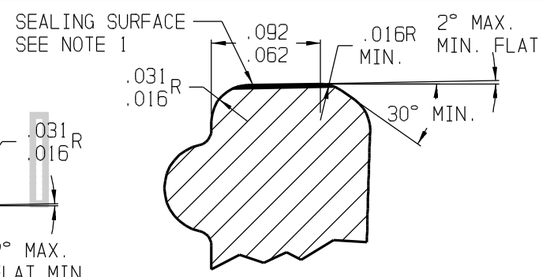
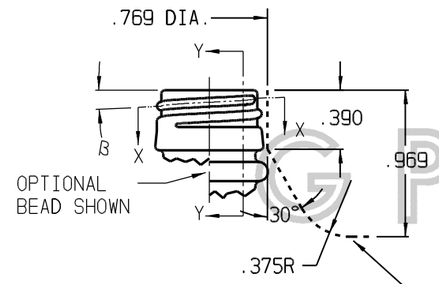
16055

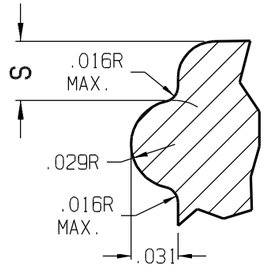




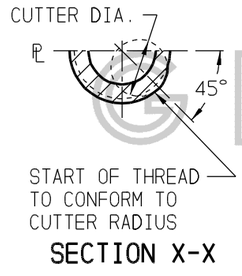
OPTIONAL CONSTRUCTION OF SEALING SURFACE



BOTTLE SHOULDER TO CLEAR BY .125, SEE NOTE 8. FOR OBLONG OR LARGE DIA. BODY MOLDS, SEE NOTE 9. SEE G.P.I. GLASS FINISH 1620 FOR DIMENSION DETAILS OF SHOULDER AND GUIDE BELL.



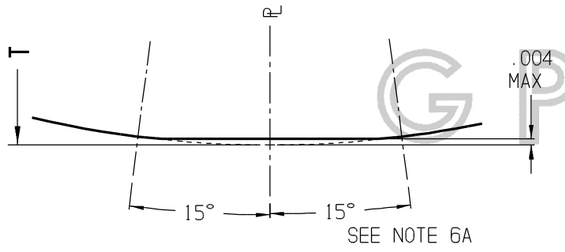
THREAD CROSS SECTION



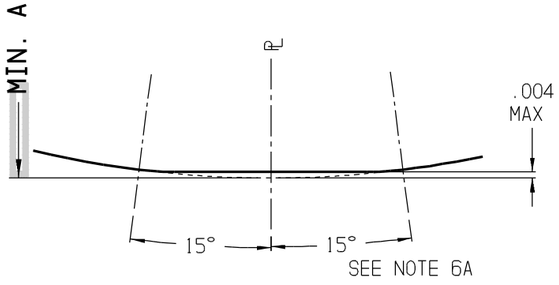
SECTION X-X

SIZE	T	E	A	S	H	D	I MIN.	ß	CUT. DIA.	T.P.I.
18	0.694 ±.010	0.632 ±.010	0.714 ±.010	0.039 ±.008	0.242 +.008 −.007	0.398 +.008 −.007	0.325	2° 45'	0.375	10

1. SEALING SURFACE MUST BE SEAMLESS TOP, FLAT PREFERRED, SMOOTH AS POSSIBLE, AND MUST NOT DIP DOWN ON THE INSIDE OF THE FINISH. GLASS SUPPLIERS MAY USE A 2° MAX. ANGLE ON MOLD TO ENSURE THAT SEALING SURFACE WILL NOT DIP DOWN ON INSIDE. IF MEASURED FROM EXTREME TOP OF FINISH, THIS ANGLE INCREASES 'H' AND 'D' DIMENSIONS A MAX. OF .002. THIS SURFACE SHOULD BE AS PARALLEL AS POSSIBLE WITH THE BASE OF THE BOTTLE.
2. 'H' DIMENSION REPRESENTS DISTANCE FROM TOP OUTER EDGE OF SEALING SURFACE DOWN TO HORIZONTAL LINE TANGENT TO THE TOP SWING OF THE .031 RADIUS OF THE BEAD.
3. SATISFACTORY THREADING REQUIRES A MINIMUM OF 405° OF FULL WIDTH AND DEPTH OF THREAD. BEYOND THAT, THREAD IS TO RUN INTO BEAD. WALL OR 'E' DIAMETER BEYOND MINIMUM FULL DEPTH OF THREAD SHOULD BE INCREASED GRADUALLY TO FULL 'T' DIAMETER IN NO LESS THAN A 90° TURN.
4. RADIUS TO BE AS SHARP AS POSSIBLE AND NOT TO EXCEED .031 MAX. RADIUS.
5. THE RADIUS, ANGLE, AND DEPTH OF LOCKING RING IS VERY IMPORTANT FOR THE PROPER SEALING AND REMOVAL OF THE CAP.
6. REQUIREMENTS FOR GOOD APPLICATION OF ROLL-ON CLOSURE:
   A. THE RELIEF OF THE THREAD AND THE 'A' DIAMETER OF THE BEAD AT THE MOLD SEAM IS NOT TO EXCEED .008 ON DIAMETER IN AN ARC OF 30 DEGREES.
   B. THE MINIMUM TOLERANCES OF THE THREAD 'T' DIAMETER AND THE BEAD 'A' DIAMETER DO NOT APPLY TO DEPRESSED AREAS.
   C. VERTICAL MISMATCH OF THREAD NOT TO EXCEED .004 AT MOLD SEAM.
7. THREAD TO START AT 45° FROM PARTING LINE.
8. CAPPING EQUIPMENT LIMITS CONTOUR OF SHOULDER OF BOTTLE AND BEAD AS INDICATED BY BROKEN LINES.
9. TOP SHOULDER ANGLE MUST BE AS LARGE AS POSSIBLE TO WITHSTAND A VERTICAL SEALING FORCE (IN POUNDS) OF APPROXIMATELY TEN TIMES THE FINISH SIZE. BEFORE ANY OBLONG GLASS IS MADE, CONTACT CLOSURE MANUFACTURER FOR ACTUAL SEALING FORCE TO BE USED ON CUSTOMERS' GLASS.
10. MINIMUM 'I' DIMENSION IS FOR FILLING TUBE CLEARANCE AND EXTENDS THROUGH ENTIRE LENGTH OF THE FINISH AND THE BOTTLE NECK.
11. TANGENT $\beta = \frac{\text{PITCH}}{\pi\,(\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
12. PROPER APPLICATION AND FUNCTION OF CLOSURE REQUIRES THAT VARIATIONS IN THE 'E' DIAMETER SHOULD FOLLOW THOSE OF 'T' SUBJECT TO NORMAL MANUFACTURING CONDITIONS, INCLUDING THE THREAD PROFILE ILLUSTRATED.
13. THIS FINISH IS NOT INTENDED TO BE USED FOR CONTENTS UNDER PRESSURE. FOR SUCH APPLICATIONS IT IS THE RESPONSIBILITY OF THE GLASS CONTAINER PURCHASER TO CONSULT WITH ITS CLOSURE AND CONTAINER SUPPLIERS.



OPTIONAL: DEPRESSED THREAD



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	GLASS FINISH NUMBER 1605	GPI DWG. NO. 16055	
18 mm ROLL-ON, 10 THREADS PER INCH			