



SIZE	T	E	A	S	H	D	I MIN.	R MAX.	R ₁ MAX.	B	CUT DIA.	T.P.I.
22	0.852 ± .010	0.768 ± .010	0.877 ± .010	0.034 +.008 -.007	0.356 +.008 -.007	0.527 +.008 -.007	0.483	0.016	0.031	2° 49'	0.375	8
28	1.075 +.013 -.012	0.981 +.013 -.012	1.100 +.013 -.012	0.046 +.008 -.007	0.385 +.008 -.007	0.577 +.008 -.007	0.614	0.031	0.047	2° 57'	0.500	6
33	1.252 +.013 -.012	1.158 +.013 -.012	1.277 +.013 -.012	0.046 +.008 -.007	0.388 ± .010	0.577 +.008 -.007	0.791	0.031	0.047	2° 31'	0.500	6
38	1.459 +.017 -.018	1.365 +.017 -.018	1.486 ± .015	0.046 +.008 -.007	0.388 ± .010	0.577 +.008 -.007	0.987	0.031	0.047	2° 9'	0.500	6

- 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.
- 'H' DIMENSION REPRESENTS DISTANCE FROM TOP OF SEALING SURFACE DOWN TO HORIZONTAL LINE TANGENT TO THE BOTTOM SWING OF THE RADIUS.
- A. SATISFACTORY APPLICATION OF SCREW CAPS ON 22 mm SIZE REQUIRES THAT THE FULL DEPTH OF ROOT OF THREAD CONTINUES DOWN AS CLOSE TO THE 'H' DIMENSION AS POSSIBLE. THIS IS ALSO SATISFACTORY FOR R-O APPLICATION. BEYOND THAT POINT THE ROOT OF THREAD SHOULD TAPER OUT TO THE 'T' DIMENSION IN NO LESS THAN A 90° TURN.
B. SATISFACTORY THREADING ON SIZES 28 mm AND UP REQUIRES A MINIMUM OF 360° OF FULL DEPTH AND WIDTH OF ROOT OF THREAD FOR THE R-O CAP. BEYOND THAT POINT THE ROOT OF THE THREAD SHOULD TAPER OUT TO THE 'T' DIMENSION IN NO LESS THAN A 90° TURN.
- SATISFACTORY APPLICATION OF THE SKIRT OF ROLL-ON CLOSURES REQUIRES THE ANGLE AND THE RADII BE HELD WITHIN THE LIMITS SHOWN.
- C.T. CAPS CAN BE USED ON ALL OF THESE SIZES.
- 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.
- THREAD TO START AT 45° FROM PARTING LINE.
- CAPPING EQUIPMENT LIMITS CONTOUR OF SHOULDER OF BOTTLE AND BEAD AS INDICATED BY BROKEN LINES.
- 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 THE CLOSURE MANUFACTURER FOR ACTUAL SEALING FORCE TO BE USED ON CUSTOMERS GLASS.
- MIN. 'I' DIM. IS FOR FILLING TUBE CLEARANCE AND EXTENDS THROUGH ENTIRE LENGTH OF THE FINISH AND THE BOTTLE NECK.
- TANGENT B = $\frac{\text{PITCH}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
- 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.
- 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.

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EDWARD A. GRANT
CHAIRMAN

PRINTED AND DISTRIBUTED AS A VOLUNTARY STANDARD BY
GLASS PACKAGING INSTITUTE
COMMITTEE ON DESIGN AND SPECIFICATIONS

APPROVED FOR PUBLICATION
01-15-99

SUPERSEDES DWG. NO.
16206

GLASS FINISH NUMBER
1620

ROLL-ON FINISH

GPI DWG. NO.
16207