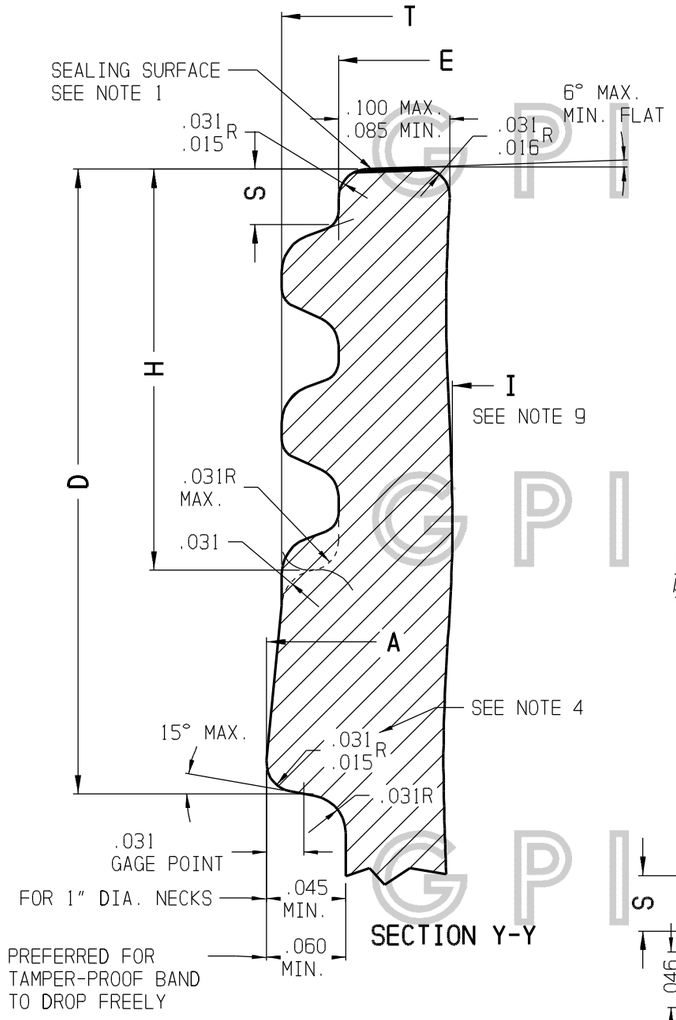
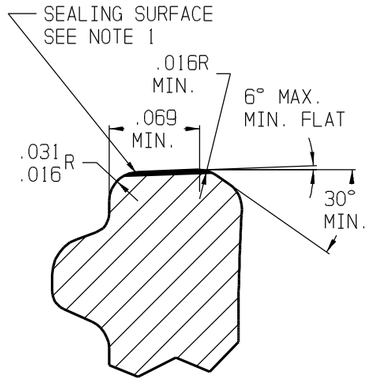
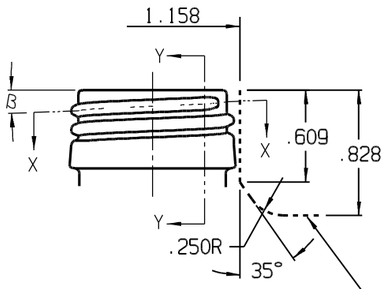
16306



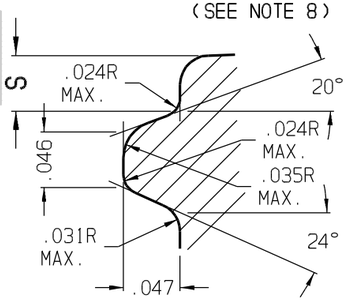
SECTION Y-Y



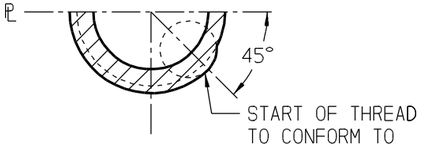
OPTIONAL CONSTRUCTION
OF SEALING SURFACE



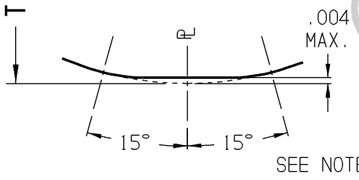
BOTTLE SHOULDER
TO CLEAR BY .125
(SEE NOTE 8)



THREAD CROSS SECTION

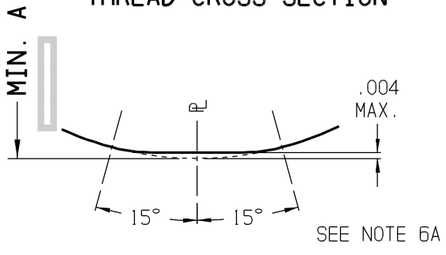


SECTION X-X



SEE NOTE 6A

OPTIONAL: DEPRESSED THREAD



SEE NOTE 6A

BEAD RELIEF (AT "MIN. A" DIA.)

SIZE	T	E	A	S	H	D	I MIN.	β	CUT. DIA.	T.P.I.
28	1.075 +.013 -.012	0.981 +.013 -.012	1.100 +.013 -.012	0.046 +.008 -.007	0.332 +.008 -.007	0.517 +.008 -.007	0.635	2° 12'	0.375	8

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. ANY MISMATCH SHOULD NOT BE GREATER THAN .010. THE PARTING LINE MUST NOT BE LESS THAN .015 FROM THE TOP OF THE FINISH.

2. 'H' DIMENSION REPRESENTS DISTANCE FROM TOP OF SEALING SURFACE DOWN TO HORIZONTAL LINE TANGENT TO THE BOTTOM SWING OF THE .031 MAXIMUM RADIUS AND IS REQUIRED FOR MOLD MAKERS GUIDANCE.

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 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.
   D. .015 MAXIMUM OUT OF PARALLEL SEALING SURFACE WITH BOTTOM OF THE BOTTLE. THIS IS FOR COCKED NECKS AND SLANTED FINISHES.
   E. .074 MAX. OUT OF PERPENDICULAR WITH BASE OF BOTTLE.

7. THREAD TO START AT 45° FROM PARTING LINE.

8. CERTAIN CAPPING MACHINE EQUIPMENT REQUIRES GUIDE BELL CLEARANCE AS SHOWN.

9. MIN. 'I' DIM. IS FOR FILLING TUBE CLEARANCE AND EXTENDS THROUGH ENTIRE LENGTH OF THE FINISH AND THE BOTTLE NECK.

10. TANGENT $\beta = \dfrac{\text{PITCH}}{\pi \text{ (MEAN BETWEEN MEAN 'T' AND MEAN 'E')}}$

11. 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.

12. 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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	GLASS FINISH NUMBER 1630	GPI DWG. NO. 16306	

28 mm ROLL-ON FINISH, 8 THREADS PER INCH