1. Sealing surface must be finished top flat, preferably a minimum of 0.001" above the edge of the finish. Glass suppliers may use 0.001" to 0.002" angle on hold to ensure that the surface will not slip down on edge of the bottle. Glass suppliers may use a minimum of 0.001" angle on hold to ensure that the surface will not slip down on edge of the bottle. The finished top of the finish must be polished to a high finish. This surface should be in parallel with the sides of the bottle.

2. The dimension representing the distance from the outer edge of the sealing surface to horizontal line tangent to the top edge of the side of the neck. This dimension should be a maximum of 0.030".

3. The minimum value of the threaded "T" diameter, a minimum of 0.0005" for full length and diameter of threaded, beyond that the thread is to run into bed, will be 0.001" diameter for minimum full length, threaded should be increased gradually to full "T" diameter in no less than 0.001" per turn.

4. Profile to be 0.001" max. and 0.005" minimum and not exceed 0.030" max. radius.

5. The profile angle and the depth of locking ring is very important for proper sealing and removal of the cap.

6. The relieved length of the thread and the "T" diameter at the hold beam is not to exceed 0.010" as specified in 0.001" increments.

7. The minimum tolerances of the threaded "T" diameter and the "A" diameter do not apply to the relieved area.

8. The vertical position of the thread not to exceed 0.050" at hold beam.

9. Thread to start at 0.050" from burring line.

10. The shoulder limits contour of shoulder of bottle and bed as indicated in broken lines.

11. The top shoulder limits are as large as possible to withstand a vertical sealing force (0.20 pound) of approximately ten times the friction before an unknown glass of 0.010" contact closure manufacturer for actual sealing force to be used on customers glass.

12. Minimum "T" dimension is for filling tube clearance and extends through entire length of the finish and the bottle neck.

13. The thread is not intended to be used for contents under pressure. For such applications it is the responsibility of the glass container manufacturer to consult with the closure and container suppliers.

14. Glass finish number 1605

15. 18 mm ROLL-ON, 10 THREADS PER INCH

16. EDWARD A. GRANT