1. For ideal sealing of crown liner the thread lip shall be sharp
   and not exceed 0.031 max. radius.

2. Certain capping equipment requires that neck contour be within limits
   of recommended guide contour.

3. The angle of the cutter to the fixture is equal to the helix angle.

4. The sealing surface is shown by the heavy line.

5. I dimension is measured through entire finish and neck of bottle.

6. The 'T' dimension must be maintained as shown, using a cylindrical
   type guide, with i 0.010 min. from top of finish.

7. The 'S' dimension represents the distance from the top of finish to a
   construction point measured at the first full start of thread. The 'I'
   dimension is the vertical distance from the top of the finish to the
   bottom of thread by 0.005 plus the threads of the thread contour at the
   lowest point at the end of thread.

8. Sealing surface of the finish not to be out of parallel with base of
   bottle in excess of 0.005.

9. Threads must not be deformed.

10. Top of finish should be free of radial seams and in order to prevent
    chatter when using certain types of cutters. The diameter must
    not exceed 0.031 max. at horizontal parting line. Undercut at guide
        rings should be closed 0.005 to 0.030. To provide for guide
        ring stage, 0.008 undercut is permitted on maximum side only.

11. Neck ring is parted through single thread.

12. Proper application and function of closure requires that variations
    in the 'S' dimension be subject to normal manufacturing conditions,
    including the thread profile illustrated.

13. The flat in the thread section detail is optional. When the flat is
    not used, the 'S' dimension should be reduced to 0.005 max.

14. Tangent 0° = 2 LEADS. (LEAD = 0.010 in.)

15. It is the responsibility of the glass container purchaser to consult
    with its closure and container suppliers to determine the appropriate
    pressure limits for the combination of the container, finish, and the
    closure chosen. When the container will be subjected to pressure or
    use for contents under pressure.

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GPI Dwg. No.

Glass Finish Number 535

THREADED CROWN FINISH

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