1. For ideal sealing of crown liner the thread lip must be sharp compared to 0.016 in. radius.
2. Center-lining equipment requires that neck contain be within limits of recommended glass contour.
3. The angle of the cutter to the feature is equal to the helix angle.
4. The sealing surface is shown by the heavy line.
5. A dimension is measured through entire finish and neck of bottle.
6. The E dimension must be maintained using a cylindrical type tube, e.g. .010 in. from top of finish.
7. A dimension represents the distance from the top of finish to a construction point measured at the first full start of thread. The A dimension is the radius distance from the top of the finish to the bottom point of 0.015 crest radius 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 0.025.
9. Threads must not be depressed.
10. Top of finish should be free of slight burrs in order to prevent scratching when using certain types of closures. The diameter must not exceed 0.1 diameter at horizontal pinch line. Undercut at guide pin is considered to be ideal of size 0.002 to 0.003 for pins for guide pin shunt. 0.004 undercut is permitted on outside side.
11. Neck ring is parted through single thread.
12. Proper application and function of closure requires that variations in the E dimension should follow those of A subject to normal operating conditions, including the thread profile illustrated.
13. The B dimension in the thread cross section detail is optional when the flat is not used. This E dimension should be adjusted to .005.
15. It is the responsibility of the glass container producer to consult with its closure and container suppliers to determine the appropriate pressure limits for the construction of the container. Its finish, and the closure chosen. When the container will be subjected to pressure or used for contents under pressure.

Thomas D. Finney, President of GPI

Edward A. Grant

GRACE FINISH NUMBER 550

THREADED CROWN FINISH

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