

Glass container finishes —

Part 1: Specification for continuous thread finish

UDC 621.798.147:666.171:683.533.8

Confirmed February 2008

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British Paper and Board Industry Federation (PIF)	Glass Manufacturers' Federation*
British Paper Bag Federation	Institute of Packaging
British Tin Box Manufacturers' Federation	Institute of Trading Standards Administration*
Chemical Industries Association*	Ministry of Defence*
Collapsible Tube Manufacturers' Association	Oil Companies Materials Association
Confederation of British Industry	Paintmakers' Association of Great Britain Ltd.
Crown Agents for Oversea Governments and Administrations	Pira (The Research Association for the Paper and Board, Printing and Packaging Industries)*
Department of Trade — Paper, Printing, Publishing, Services & Distribution	Soap and Detergent Industry Association
Department of Transport	Society of Motor Manufacturers and Traders Limited
Fibreboard Packing Case Manufacturers' Association	Timber Packaging and Pallet Confederation

The organizations marked with an asterisk in the above list, together with the following, were directly represented on the committee entrusted with the preparation of this British Standard:

Association of the British Pharmaceutical Industry	Department of Prices and Consumer Protection
British Photographic Manufacturers' Association	Fruit and Vegetable Canners' Association
British Soft Drinks Council	Honey Importers and Packers' Association
British Tin Box Manufacturers' Federation (closures)	National Association of Cider Makers
Campden Food Preservation Research Association	National Association of Soft Drinks Manufacturers
Dairy Trade Federation	Process Plant Association
Department of Health and Social Security	Scotch Whisky Association
	Scottish Association of Soft Drinks Manufacturers
	Wine & Spirit Association of Great Britain

This British Standard, having been prepared under the direction of the Packaging and Freight Containers Standards Committee, was published under the authority of the Executive Board on 31 March 1978

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First published January 1953
First revision March 1978

The following BSI references relate to the work on this standard:

Committee reference PKM/563
Draft for comment 74/62682 DC

ISBN 0 580 10110 X

Amendments issued since publication

Amd. No.	Date of issue	Comments
2818	April 1979	
4146	December 1982	Indicated by a sideline in the margin

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Foreword

This Part of BS 1918, prepared under the direction of the Packaging and Freight Containers Standards Committee at the request of the Glass Manufacturers' Federation, was first published in 1953.

Two types of screw thread finishes, known as R-3/2 and R-4, have been in use for many years and were specified in the original standard. In recent years additional screw finishes, using the basic design features of the original series, have come into general use and these are incorporated in this standard as R5 and R6 series.

The prefix R-3/2 is to be known in future as R3.

All dimensions are in millimetres (mm) as detailed in BS 4602.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, pages 1 to 8, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

1 Scope

This Part of BS 1918 specifies glass dimensions for four series of external screw neck finishes as follows.

- | | |
|--|----|
| a) Shallow continuous thread finishes | R3 |
| b) Tall continuous thread finishes | R4 |
| c) Medium/shallow continuous thread finishes | R5 |
| d) Medium continuous thread finishes | R6 |

A method of gauging the minimum outside diameter of the glass threads is also specified.

This British Standard does not specify requirements for closures.

2 References

The title of the publication referred to in this standard is given on the inside back cover.

3 Dimensions and tolerances

3.1 Continuous thread finishes. British Standard glass finishes and thread profiles shall have dimensions as detailed in Table 1 to Table 4 and in Figure 1 to Figure 4, relating to the R3, R4, R5 and R6 finishes respectively.

3.2 General. All essential dimensions in R3, R4, R5 and R6 finishes may be ascertained by any appropriate form of measurement, except that the minimum T dimension shall be measured by a Parnaby gauge. The gap of this gauge shall be the minimum T dimension and shall have two engaging surfaces conforming to the thread circumference; the width of each of these surfaces shall be one-tenth of the circumference of the minimum T dimension. Figure 5 shows details of this gauge which, for convenience, should be manufactured combined with a ring gauge made to the maximum T dimension for use in gauging the maximum diameter.

3.3 Sealing surface. The sealing surface may be flat or radial and shall conform to the dimensions shown in Figure 1 to Figure 4. It shall be as regular and smooth as possible.

3.4 Finish with depressed thread. If a depressed thread is used it shall comply with Figure 6.