



SLOVENSKI STANDARD SIST EN ISO 9100-6:2005

01-marec-2005

**Steklena embalaža – Grla za vakuumsko zapiranje - 6. del: 53 in 58, standardno
(ISO 9100-6:2005)**

Glass containers - Vacuum lug finishes - Part 6: 53 and 58 regular (ISO 9100-6:2005)

Glasbehälter - Vakuum-Nockenverschluss-Mündungen - Teil 6: 53 und 58 regular (ISO 9100-6:2005)

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Réipients en verre - Bagues a crans pour bouchage sous vide - Partie 6: 53 et 58 regular (ISO 9100-6:2005)

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Ta slovenski standard je istoveten z: EN ISO 9100-6:2005

ICS:

55.100 Steklenice. Lonci. Kozarci Bottles. Pots. Jars

SIST EN ISO 9100-6:2005

en,fr,de

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 9100-6

January 2005

ICS 55.100

English version

**Glass containers - Vacuum lug finishes - Part 6: 53 and 58
regular (ISO 9100-6:2005)**

Réipients en verre - Bagues à crans pour bouchage sous
vide - Partie 6: 53 et 58 regular (ISO 9100-6:2005)

Glasbehälter - Vakuum-Nockenverschluss-Mündungen -
Teil 6: 53 und 58 regular (ISO 9100-6:2005)

This European Standard was approved by CEN on 23 September 2004.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

Management Centre: rue de Stassart, 36 B-1050 Brussels

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Foreword

This document (EN ISO 9100-6:2005) has been prepared by Technical Committee CEN/TC 261 "Packaging", the secretariat of which is held by AFNOR, in collaboration with Technical Committee ISO/TC 63 "Glass containers".

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by July 2005, and conflicting national standards shall be withdrawn at the latest by July 2005.

Efficient packaging is of great importance for the distribution and the protection of goods. Insufficient or inappropriate packaging can lead to damage or wastage of the contents of the pack.

It is based on CE.T.I.E (International Technical Centre for Bottling and Packaging) ¹⁾ data sheet GME 20-04 : 1995.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

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1) Centre Technique International de l'Embouteillage (CETIE), 3, rue La Boétie, 75008 Paris, France, www.cetie.org

EN ISO 9100-6:2005 (E)

1 Scope

This document specifies the dimensions of vacuum lug finishes with nominal sizes of 53 mm and 58 mm regular for wide-mouth glass containers.

2 Normative references

Not applicable.

3 Dimensions

3.1 The design and dimension of the finish shall be as shown in Figures 1 to 3 and Table 1.

3.2 Details which are not specified shall be selected in accordance with the application. For general tolerances see EN 22768-1.

Dimensions in millimetres

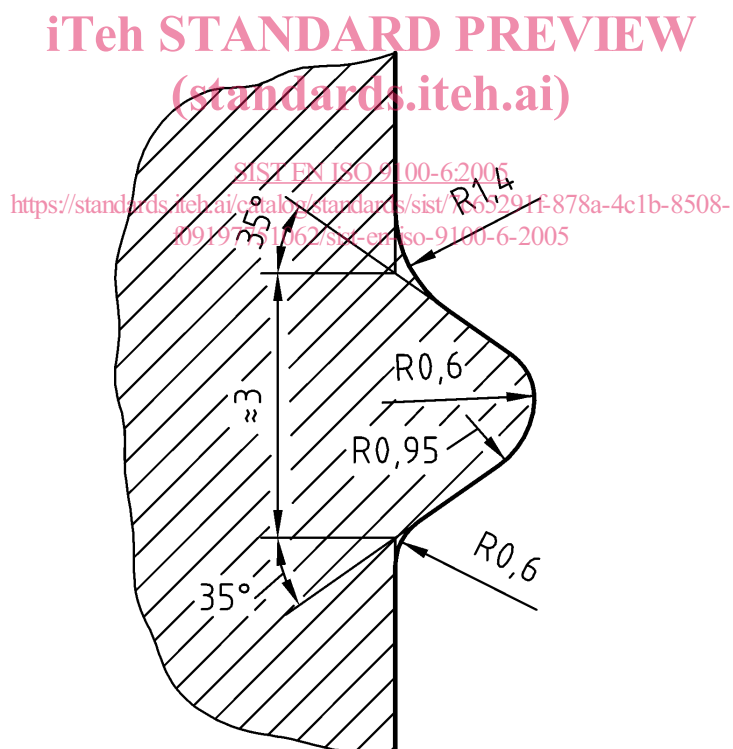
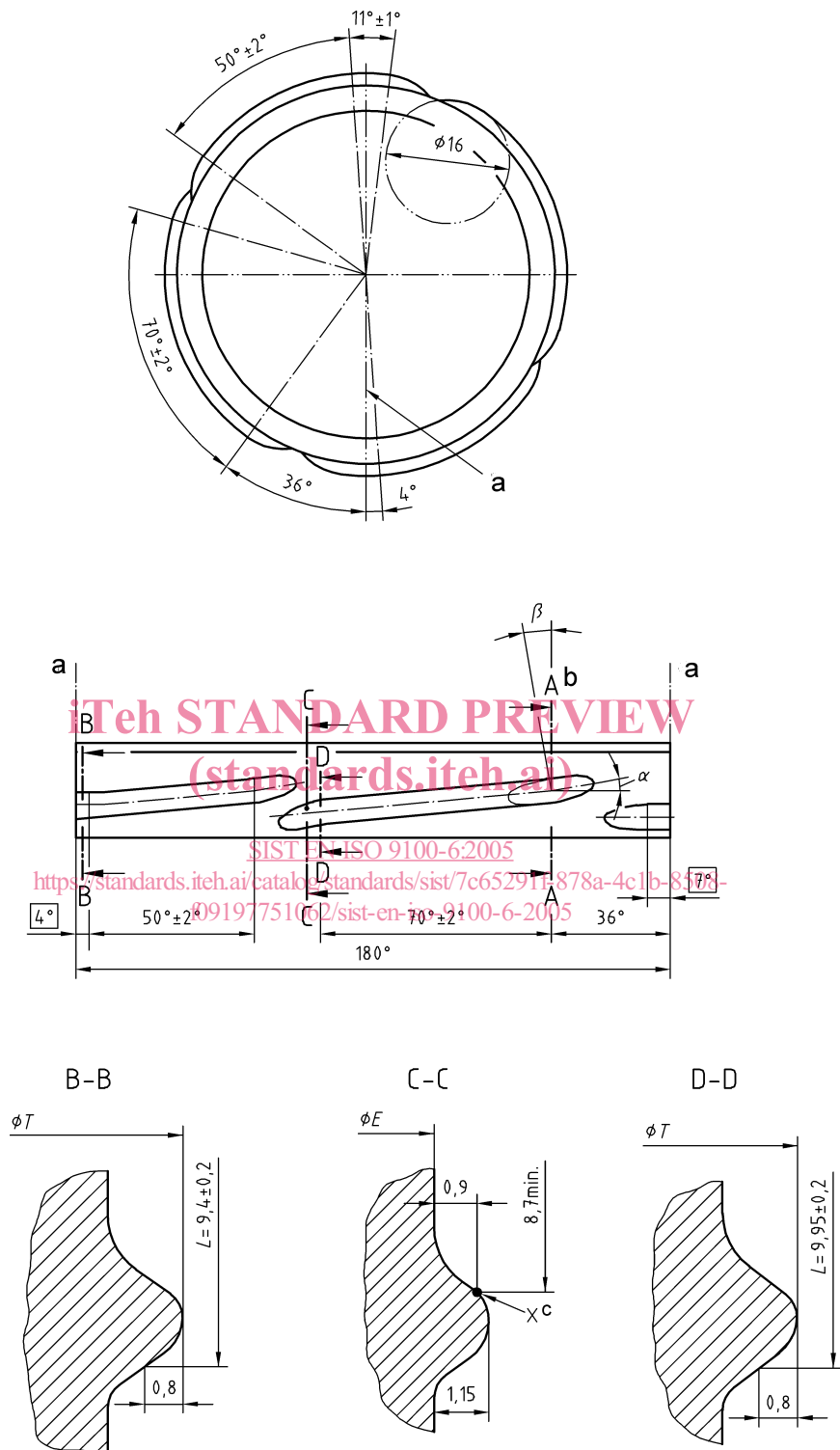


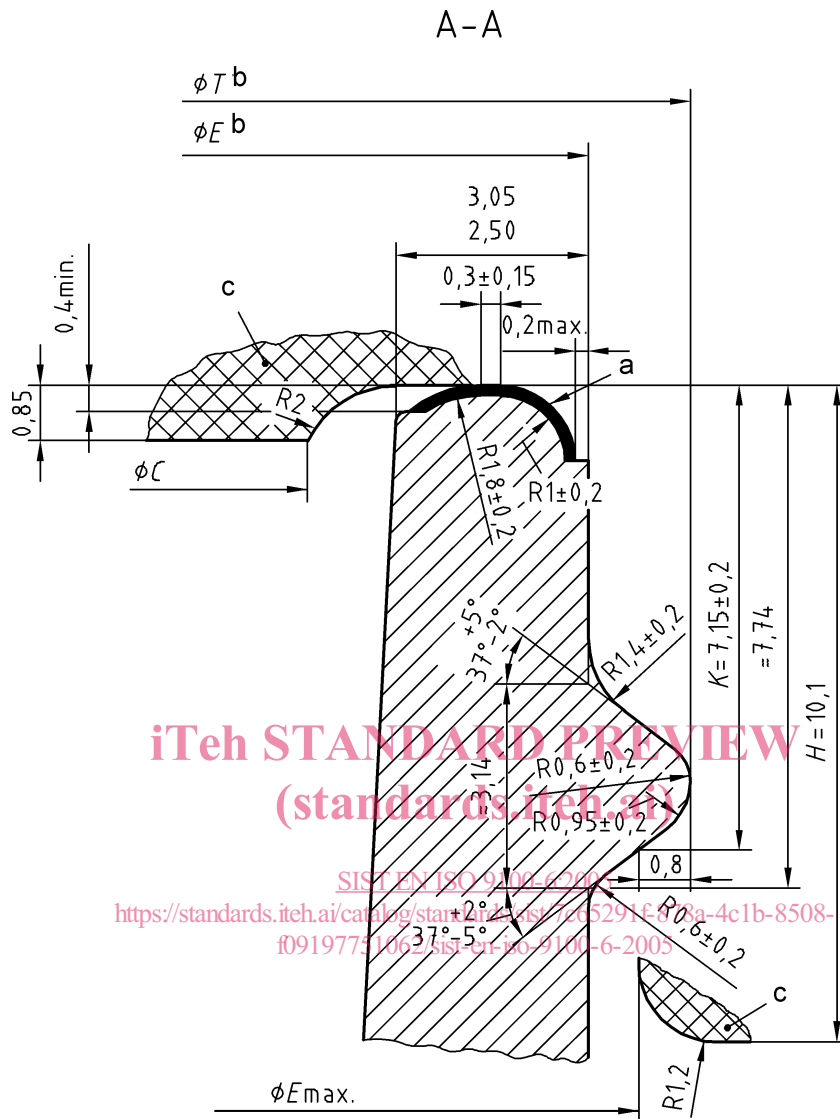
Figure 1 — Cutter profile

Dimensions in millimetres

**Key**

- a) Parting line
- b) See Figure 3
- c) In order to provide a proper cap removal, the theoretical cam-off point (X) shall be on the upper flank of the thread.

Figure 2 — Thread construction and enlarged view sections B-B, C-C and D-D



Key

- The sealing surface shall be free of checks, dips, crizzles and other defects which may affect proper functioning.
- Proper system functioning calls for keeping the ovality in the finish diameters to a minimum. E and T diameters should be concentric in relation to one another.
- Cross-hatched areas of C diameter and H height show the closure position. Glass shall clear cap limits shown. The contour below the H dimension as well as the design of a possible bead are optional. Sufficient free space shall be provided between the bead and the cross-hatched area.

Figure 3 — Enlarged view section A-A

Table 1 — Dimensions

Type	Diameter E (mm)	Diameter T (mm)	Diameter C (mm)	Cutter α^a	Leads	Thread parameters		
						β	Pitch (mm)	T.P.I. ^{b)}
53	48,80 ± 0,40	51,95 ± 0,40	42,25	10°	4	5°14'	14,50	1 ¾
58	52,70 ± 0,40	55,85 ± 0,40	46,15	10°	4	4°52'	14,50	1 ¾

^{a)} The cutter inclination at α -angle shall be maintained for all cuts. The start and end of the leads correspond to the cut-in profile as defined by the cutter diameter, except where ruffles are required to permit mould opening.

^{b)} Threads per inch

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