

INTERNATIONAL STANDARD

ISO
9056

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Glass containers — Series of pilferproof finish — Dimensions

iTeh STANDARD PREVIEW
Réipients en verre — Série de bagues inviolables — Dimensions
(standards.iteh.ai)

ISO 9056:1990

<https://standards.iteh.ai/catalog/standards/sist/ff821127-32ae-436c-bfa2-875d5a5a33e7/iso-9056-1990>



Reference number
ISO 9056:1990(E)

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 9056 was prepared by Technical Committee ISO/TC 63, *Glass containers*.

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Glass containers — Series of pilferproof finish — Dimensions

1 Scope

This International Standard specifies the dimensions of a series of pilferproof finishes of glass containers for non-pressurized drinks and other products.

2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 7348:—¹⁾, *Glass containers — Manufacture — Vocabulary*.

3 Definitions

For the purposes of this International Standard, the definitions given in ISO 7348 apply with the following exception.

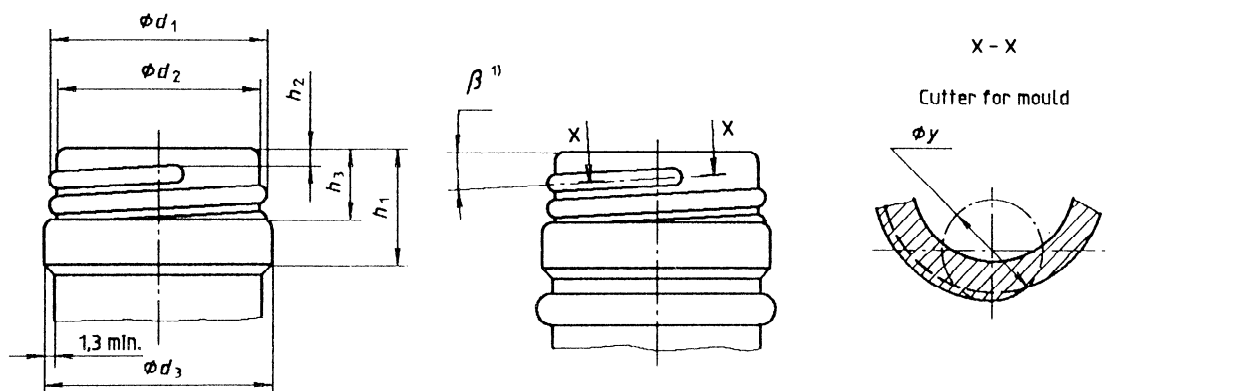
pilferproof finish: Finish designed to take a tamper-evident closure which needs to be snapped before it can be opened.

4 Dimensions

The dimensions shall be in accordance with figures 1 to 4 and table 1, depending on the shape of the finish. All untoleranced dimensions are nominal.

The glass thickness throughout the full depth of the finish shall be adequate to withstand normal handling. The finish shall be free from cracks likely to have an adverse effect on sealing performance.

1) To be published.



1) β is the helix angle, or the angle of cutter Index:

$$\tan \beta = \frac{P}{\bar{D}}$$

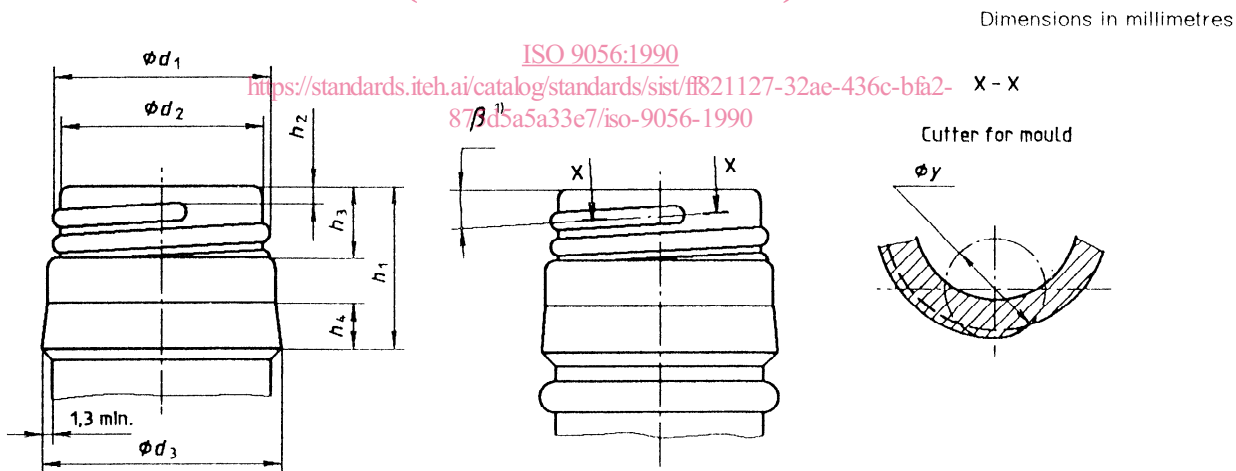
where

$$\bar{D} = \frac{\bar{d}_1 + \bar{d}_2}{2}$$

P is the pitch.

Figure 1 — Shape 1

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1) β is the helix angle, or the angle of cutter Index:

$$\tan \beta = \frac{P}{\bar{D}}$$

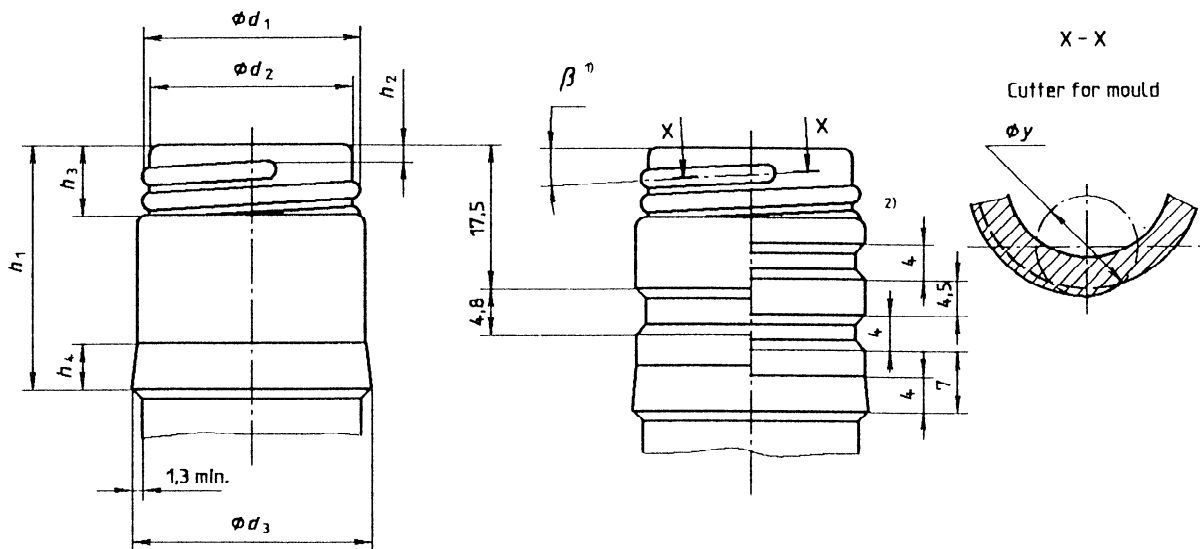
where

$$\bar{D} = \frac{\bar{d}_1 + \bar{d}_2}{2}$$

P is the pitch.

Figure 2 — Shape 2

Dimensions in millimetres



1) β is the helix angle, or the angle of cutter Index:

$$\tan \beta = \frac{P}{D}$$

where

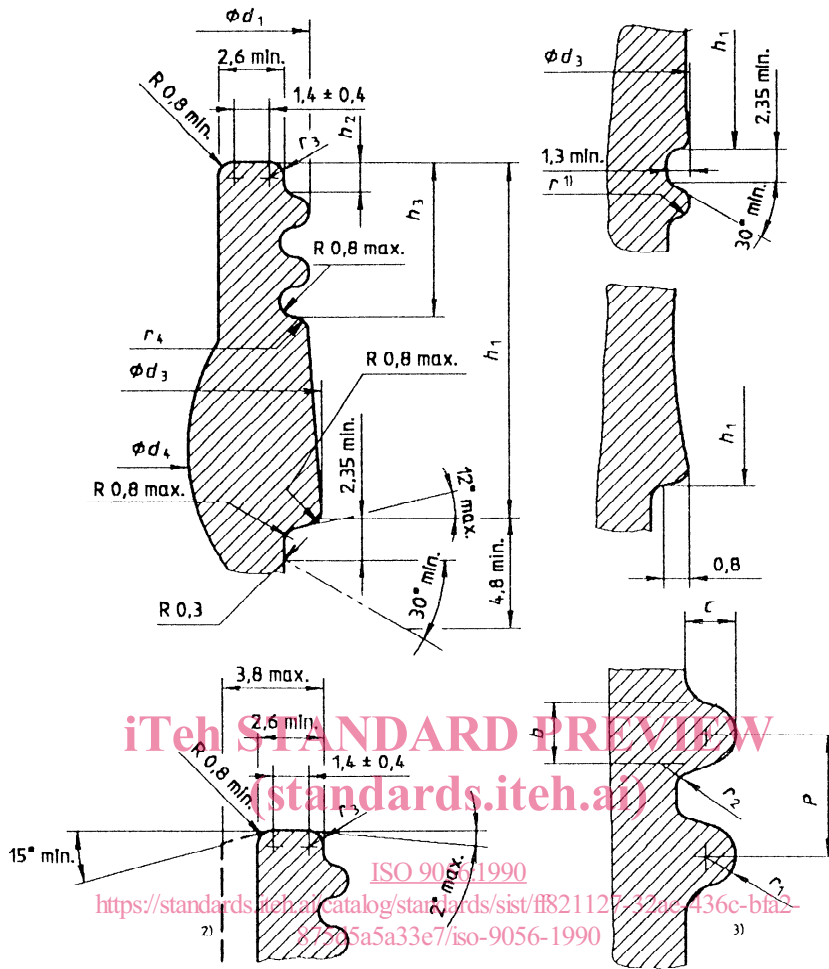
$$D = \frac{d_1 + d_2}{2}$$

P is the pitch.

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2) Alternative recesses for nominal diameter 30 mm, type C (extra deep).

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Figure 3 — Shape 3



- 1) The value of r is left to the choice of the manufacturer.
- 2) Construction of Increased wall thickness when required.
- 3) Thread detail: start of thread equal to cutter radius $y/2$.

Figure 4 — Details of construction of shape 2

Table 1 — Dimensions

Dimensions in millimetres

Nominal diameter	Shape	Type	d_1 ¹⁾		d_2 ¹⁾		d_3 ¹⁾		h_1		h_2		h_3		h_4	P	c	b	r_1	r_2	r_3	r_4	β	γ	Through-bore ²⁾ min.
			nom.	tol.	nom.	tol.	nom.	tol.	nom.	tol.	nom.	tol.	nom.	tol.											
18	2	A (standard)	21,45	$\pm 0,25$	19,75	$\pm 0,25$	21,95	$\pm 0,25$	12,75	$\pm 0,2$	1,3	$\pm 0,3$	6,8	$\pm 0,2$	2,6	2,54	0,85	1,7	0,85	0,4	0,75 $\pm 0,25$		2°46'	9,5	8
			24,4		22,3		24,9		14,05		1,6		8,3		—	3,18	1,05	2,1	1,05	0,5			2°15'	9,5	11
25	1	A (standard)	27,1		24,9		27,7		15,4		1,6		9,35		—	3,63	1,1	2,2	1,1	0,6	0,95 $\pm 0,25$	0,3 to 0,8	2°29'	9,5	13
			27,1	$-0,30$ $-0,35$	24,9	$-0,30$ $-0,35$	27,7	$-0,30$ $-0,35$	19,4	$-0,25$	1,6	$\pm 0,4$	9,35	$\pm 0,25$	5,3	3,63	1,1	2,2	1,1	0,6			2°33'	12,5	16
30	3	C (extra deep)	28,3		26,2		28,9		31,95		1,6		8,5	$-0,2$	5,3	3,18	1,05	2,1	1,05	0,5			2°7'	12,5	16
			30,15	$\pm 0,35$	27,95	$\pm 0,35$	30,8	$\pm 0,35$	21,4		1,6		9,35	$\pm 0,25$	—	3,63	1,1	2,2	1,1	0,6			2°17'	12,5	18
31	2	B (deep)	30,15		27,95		30,8		21,4		1,6		9,35		5,3	3,63	1,1	2,2	1,1	0,6			2°17'	12,5	18
			30,15	$\pm 0,35$	27,95	$\pm 0,35$	30,8	$\pm 0,35$	21,4		1,6		9,35	$\pm 0,25$	—	3,63	1,1	2,2	1,1	0,6			2°17'	12,5	18

1) For best sealing results, the mean of the maximum and minimum diameters should be as close as possible to the nominal diameter.

2) The minimum through-bore is equal to d_4 (see figure 4).

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