INTERNATIONAL STANDARD

ISO 9100

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Wide-mouth glass containers — Vacuum lug finishes — Dimensions

Récipients en verre à col large — Bagues à crans (bouchage sous vide) — Dimensions

INTERNATIONAL ISO

Reference number
ISO 9100:1992(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 9100 was prepared by Technical Committee ISO/TC 63, *Glass containers*.

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Wide-mouth glass containers — Vacuum lug finishes — Dimensions

1 Scope

This International Standard specifies the dimensions of vacuum lug finishes for wide-mouth glass containers.

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 7348:1992, *Glass containers — Manufacture — Vocabulary.*

3 Definitions

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

3.1 vacuum lug finish: Finish with lugs to hold the closure down.

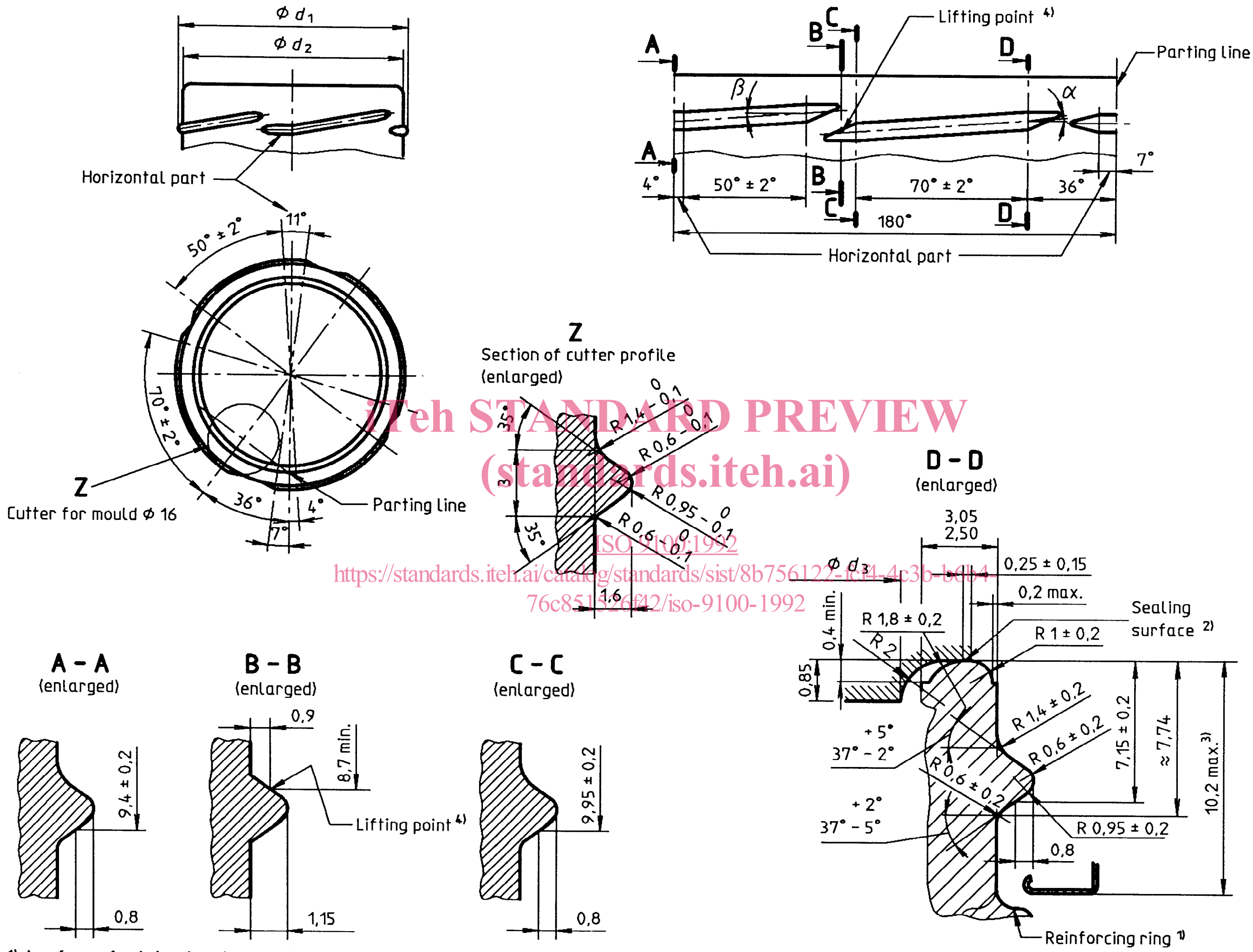
NOTE 1 The vacuum is created by a heat treatment prior to closing the container.

4 Dimensions

The dimensions shall be in accordance with figure 1 and table 1, figure 2 and table 2 or figure 3 and table 3, depending on the nominal diameter 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.

Dimensions in millimetres



1) Any form of reinforcing ring may be used provided that sufficient clearance of the closure is assured [see also 3)].

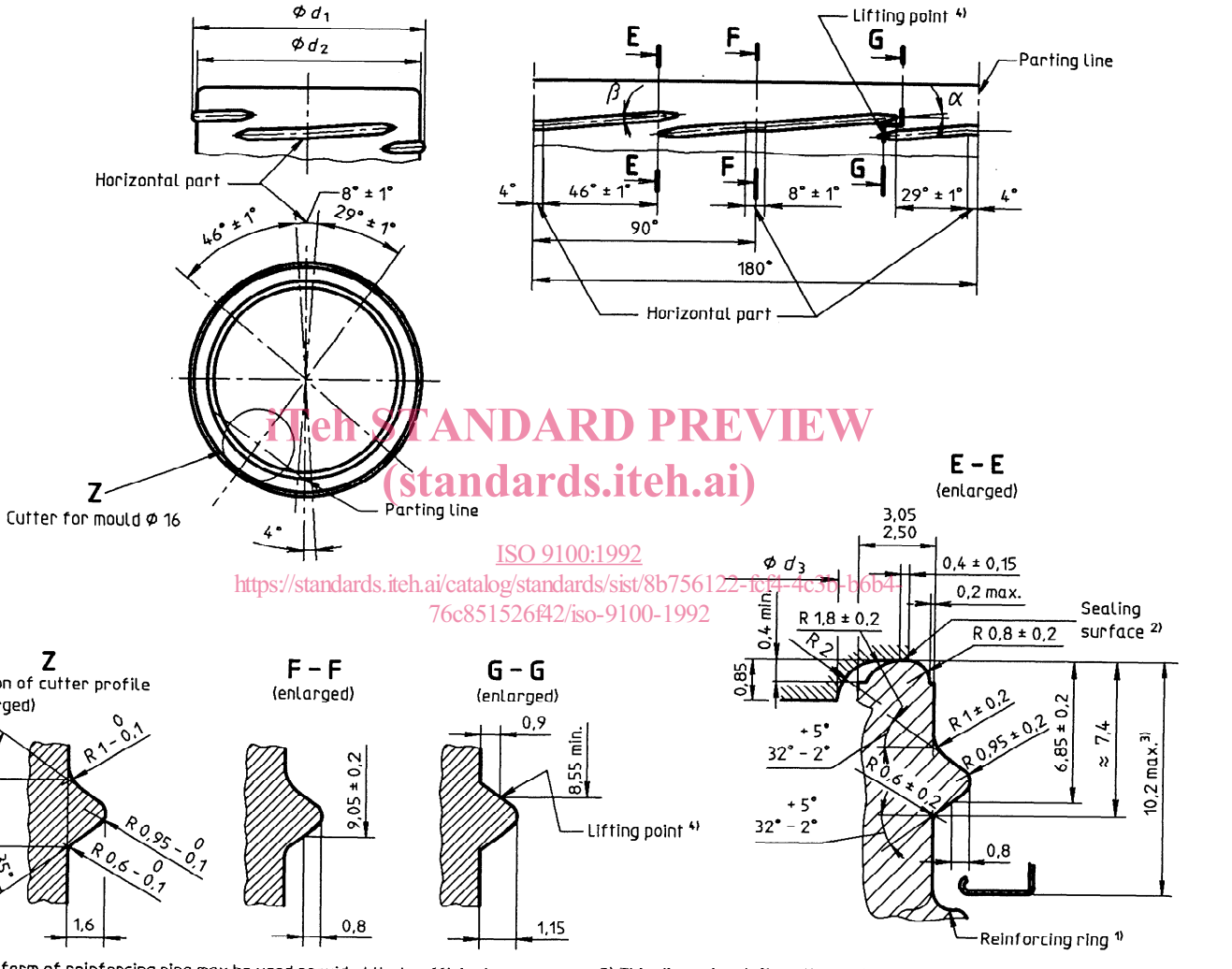
2) The sealing surface should be free from crizzles and depressions which could affect the sealing efficiency.

3) This dimension defines the position of the closure and thus ensures that sufficient space is provided between the closure and the reinforcing ring.

4) Theoretical point at which the closure is lifted while being opened.

Figure 1

Dimensions in millimetres



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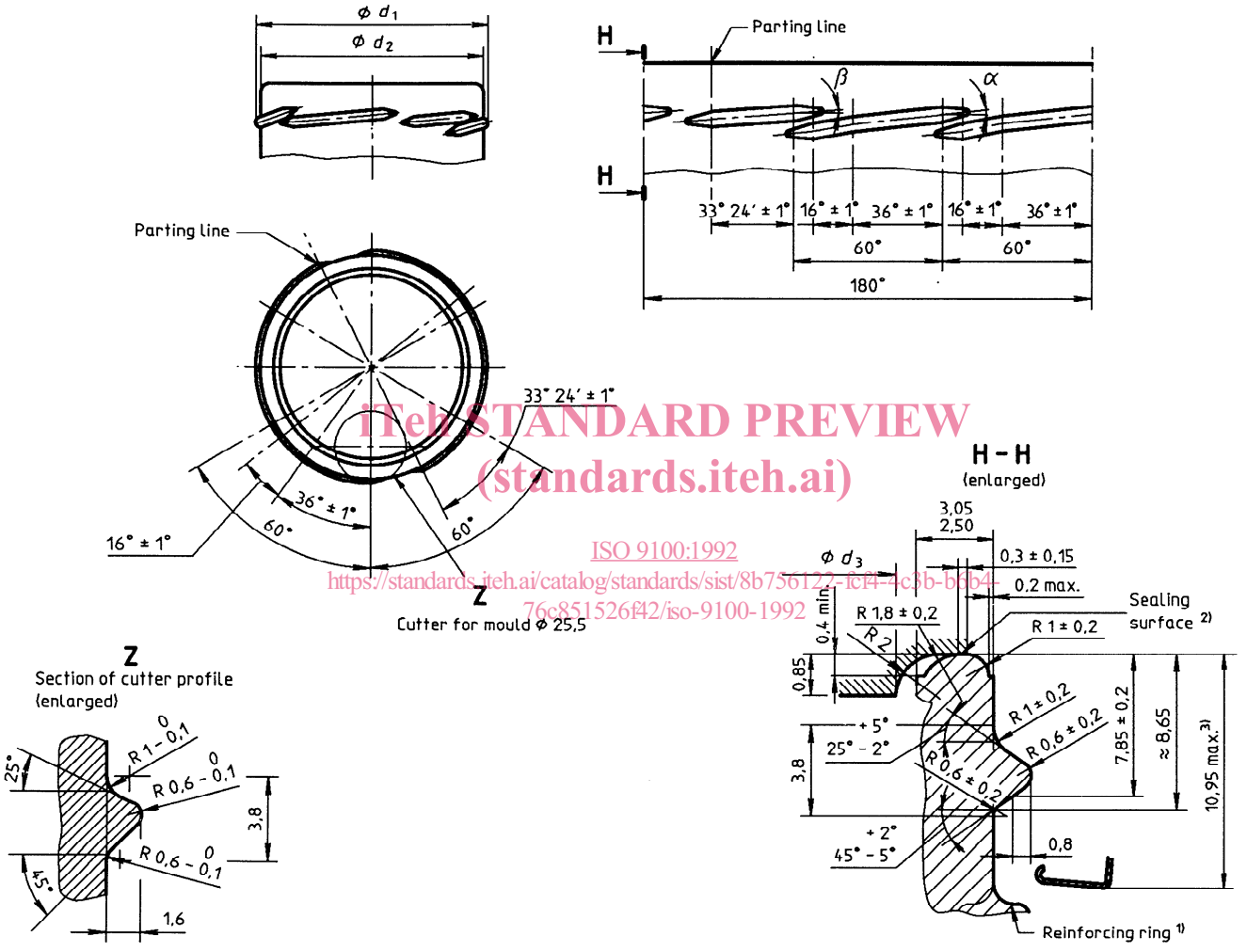
2) The sealing surface should be free from crizzles and depressions which could affect the sealing efficiency.
3) This dimension defines the position of the closure and thus ensures that sufficient space is provided between the closure and the reinforcing ring.
4) Theoretical point at which the closure is lifted while being opened.

Figure 2

Dimensions in millimetres



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3) This dimension defines the position of the closure and thus ensures that sufficient space is provided between the closure and the reinforcing ring.

Figure 3

Table 1 — Four-part thread

Nominal diameter mm	d_1 [1] mm	d_2 [1] mm	d_3 [2] mm	Pitch of thread in	Helix angle β	Angle of cutter index α
53	51,95 ± 0,4	48,8 ± 0,4	42,25	1 3/4	5° 14′	10°
58	55,85 ± 0,4	52,7 ± 0,4	46,15	1 3/4	4° 52′	10°

1) Diameters d_1 and d_2 should be concentric. The mean value for all dimensions should be aimed at; ovality should be kept to a minimum.
2) Diameter d_3 refers to the closure.

Table 2 — Four-part thread

Nominal diameter mm	d_1 [1] mm	d_2 [1] mm	d_3 [2] mm	Pitch of thread in	Helix angle β	Angle of cutter index α
63	62,05 ± 0,45	58,9 ± 0,45	52,35	1 1/2	5° 05′	5° 05′
66	64,95 ± 0,45	61,8 ± 0,45	55,25	1 1/2	4° 52′	4° 52′
70	68,95 ± 0,45	65,8 ± 0,45	59,25	1 1/2	4° 34′	4° 34′

1) Diameters d_1 and d_2 should be concentric. The mean value for all dimensions should be aimed at; ovality should be kept to a minimum.
2) Diameter d_3 refers to the closure.

Table 3 — Six-part thread

Nominal diameter mm	d_1 [1] mm	d_2 [1] mm	d_3 [2] mm	Pitch of thread for β_1 in	Pitch of thread for β_2 in	Helix angle β_1	Helix angle β_2	Angle of cutter index [3] α
82	80,75 ± 0,45	77,6 ± 0,45	71,05	1 1/4	3/4	4° 40′	7° 45′	4° 40′

1) Diameters d_1 and d_2 should be concentric. The mean value for all dimensions should be aimed at; ovality should be kept to a minimum.
2) Diameter d_3 refers to the closure.
3) For β_1 and β_2.

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