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**Glass containers — Vacuum lug  
finishes —**

Part 2:  
**33 medium**

*Récipients en verre — Bagues à crans pour bouchage sous vide —*

*Partie 2: 33 medium*  
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## 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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. 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.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 9100-2 was prepared by the European Committee for Standardization (CEN) Technical Committee CEN/TC 261, *Packaging*, in collaboration with Technical Committee ISO/TC 63, *Glass containers*, in accordance with the Agreement on technical cooperation between ISO and CEN (Vienna Agreement).

ISO 9100 consists of the following parts, under the general title *Glass containers — Vacuum lug finishes*:

- *Part 1: General*
- *Part 2: 33 medium*
- *Part 3: 38 regular*
- *Part 4: 38 medium*
- *Part 5: 43 and 48 regular*
- *Part 6: 53 and 58 regular*
- *Part 7: 58 deep*
- *Part 8: 63, 66 and 70 regular*
- *Part 9: 63, 66 and 70 deep*
- *Part 10: 77 regular*
- *Part 11: 82 regular*
- *Part 12: 89 regular*
- *Part 13: 100 regular*
- *Part 14: 110 regular*

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## Introduction

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.

This part of ISO 9100 is based on CE.T.I.E. (International Technical Centre for Bottling and Packaging)<sup>1)</sup> data sheet GME 20-00: 1995.

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1) Centre Technique International de l'Emboutillage et du conditionnement, 3 rue La Boétie, 75008 Paris, France  
<http://www.cetie.org>

# Glass containers — Vacuum lug finishes —

## Part 2: 33 medium

### 1 Scope

This part of ISO 9100 specifies the dimensions of a vacuum lug finish with a nominal size of 33 mm medium for wide-mouth glass containers.

### 2 Normative references

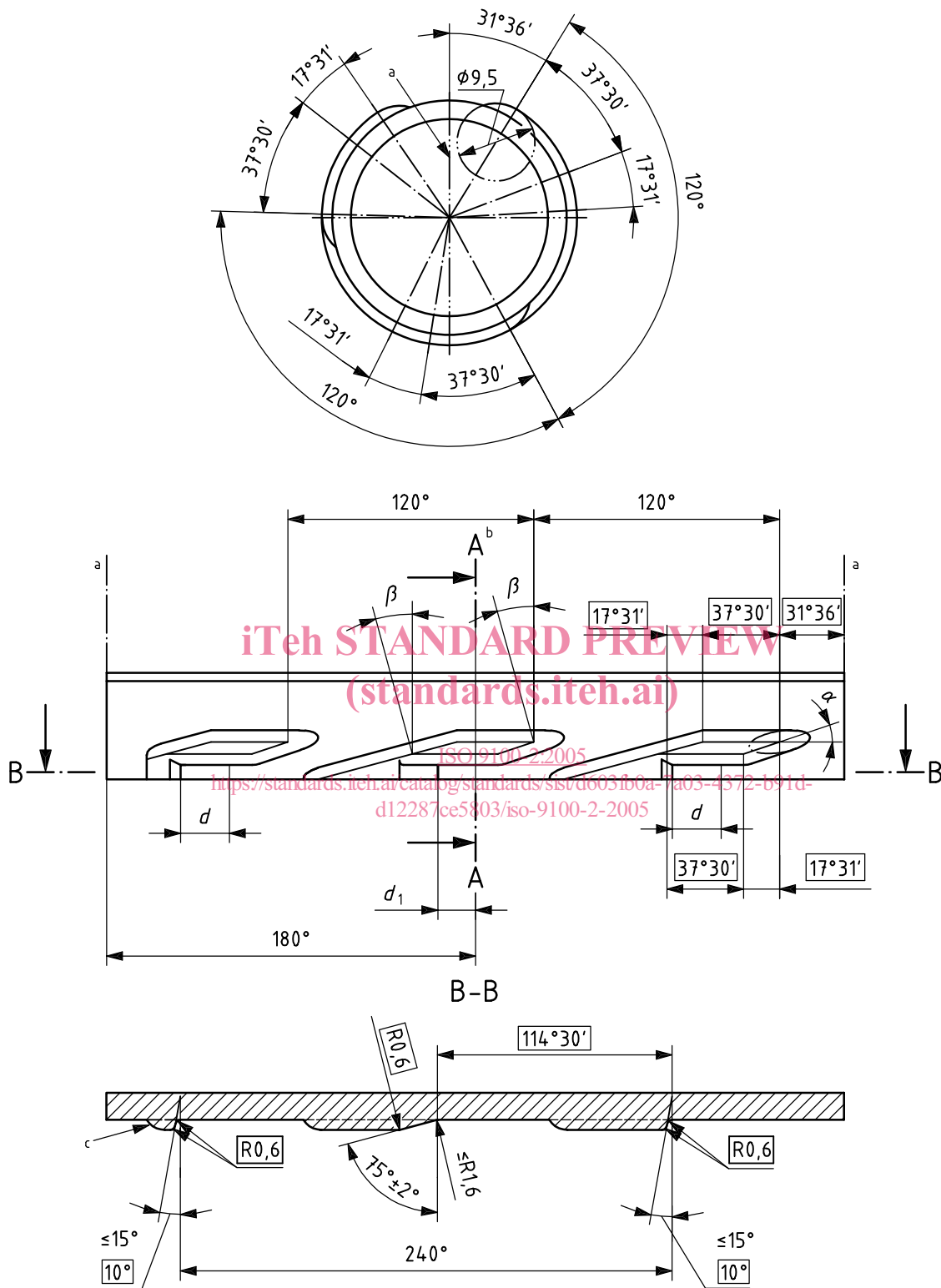
The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 2768-1, *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*

### 3 Dimensions and design

3.1 The dimensions and design of the finish shall be as shown in Figures 1 and 2 and Table 1.

3.2 Details which are not specified shall be selected in accordance with the application. For general tolerances, see ISO 2768-1.

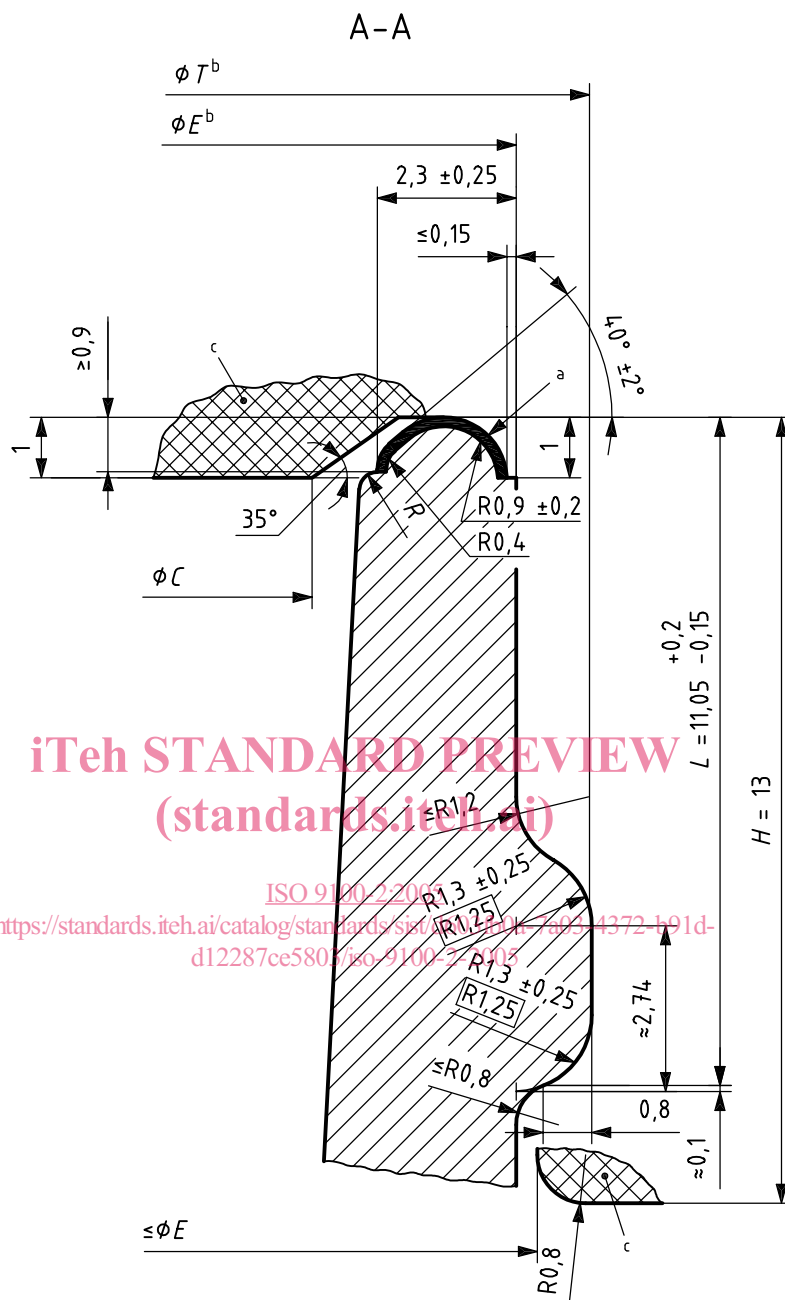


a Parting line.

b See Figure 2.

c The stop faces on the leads have a cap stopping function. Thus they shall be sharp-edged and as perpendicular to the E-wall as possible. The radius of the stop faces should be the same as of the mould. A punctual replacement of moulds is necessary to prevent worn contours.

Figure 1 — Thread construction and enlarged view section B-B



- a The sealing surface shall be free of checks, dips, crizzles and other defects which may affect proper functioning.
- b 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.
- c 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 2 — Enlarged view section A-A

Table 1 — Dimensions

Type	Diameter <i>E</i> mm	Diameter <i>T</i> mm	Diameter <i>C</i>	Cutter $\alpha^a$	Leads	Thread parameters			Chord	
						$\beta$	Pitch mm	T.P.I. <sup>b</sup>	<i>d</i> min mm	<i>d</i> <sub>1</sub> min mm
33	28,65 ± 0,30	31,15 ± 0,30	21,90	10°	3	15°08'	25,40	1	5,95	4,60
Combined minimum dimensions of <i>T</i> diameter and <i>L</i> dimension are not admissible.										
<sup>a</sup> The cutter inclination at $\alpha$ -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. <sup>b</sup> Threads per inch.										

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