CHANDLER
GLASS & PACKAGING

DIMENSIONAL SPECIFICATIONS

BVS 30 x 60

GLASS MOUTH FINISH FOR WINE BOTTLES
DERIVED FROM EN16293 NORM

NEW ZEALAND · AUSTRALIA · USA

v11 April 2017

Dimensions for the BVS mouth finish: 30 x 60

30 x 60			NOMINAL TOLERANCE
T	Thread Diameter	28.3	± 0.3 see note ①
E	Seal Diameter	26.1	± 0.3 see note ①
L	Diameter on the locking ring	28.9	± 0.3 see note ①&②
N	Diameter under mouth finish (bottle neck diameter)	25.5	see note ③
F	Total height of the finish	21.4	± 0.2
S	Distance between top & start of thread	2.8	± 0.25
H	Height of threaded part	10.4	± 0.2
X	Distance from the top to diameter Y	59.5	
Y	Neck diameter at level X	29.6	Ovality Tolerance ① ± 0.7 ② ± 0.4

① Absolute ovality limits measured with a Parnaby gauge for T and L

② For optimum application of the capsule, the mean diameter L $\frac{Ømax + Ømin}{2}$ must be in the same tolerance ± 0.20mm

③ Under-tuck limits L – N = 3.0mm minimum to 4.0mm maximum differential (1.50mm MIN to 2.0mm MAX. each side)

Important to use double tolerance of 'Y' dimension:

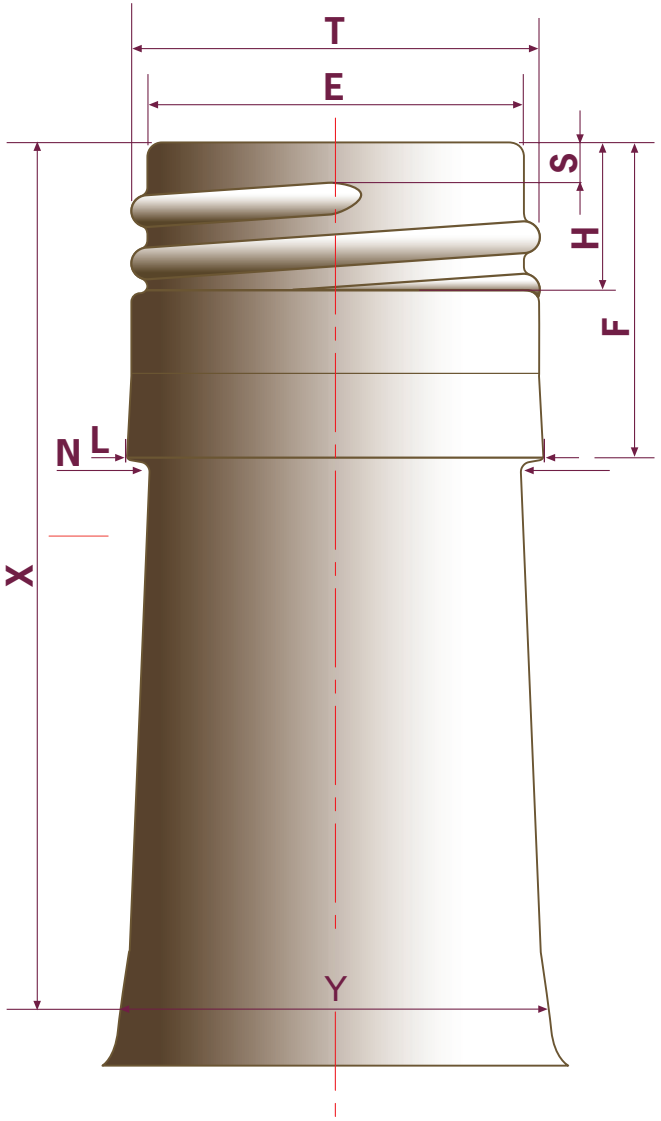
If the glass makers tolerance is outside the total circumference, the cap will not fit well – measure at 5° from seam and 90° to seam.

Tolerance 1 = limit of absolute ovality on a batch of bottles.

Tolerance 2 = limit of ovality on the average diameters of one specific bottle.

Average diameter = $\frac{Y\,max + Y\,min}{2}$

Do not exceed to value of the average diameter + tolerance②

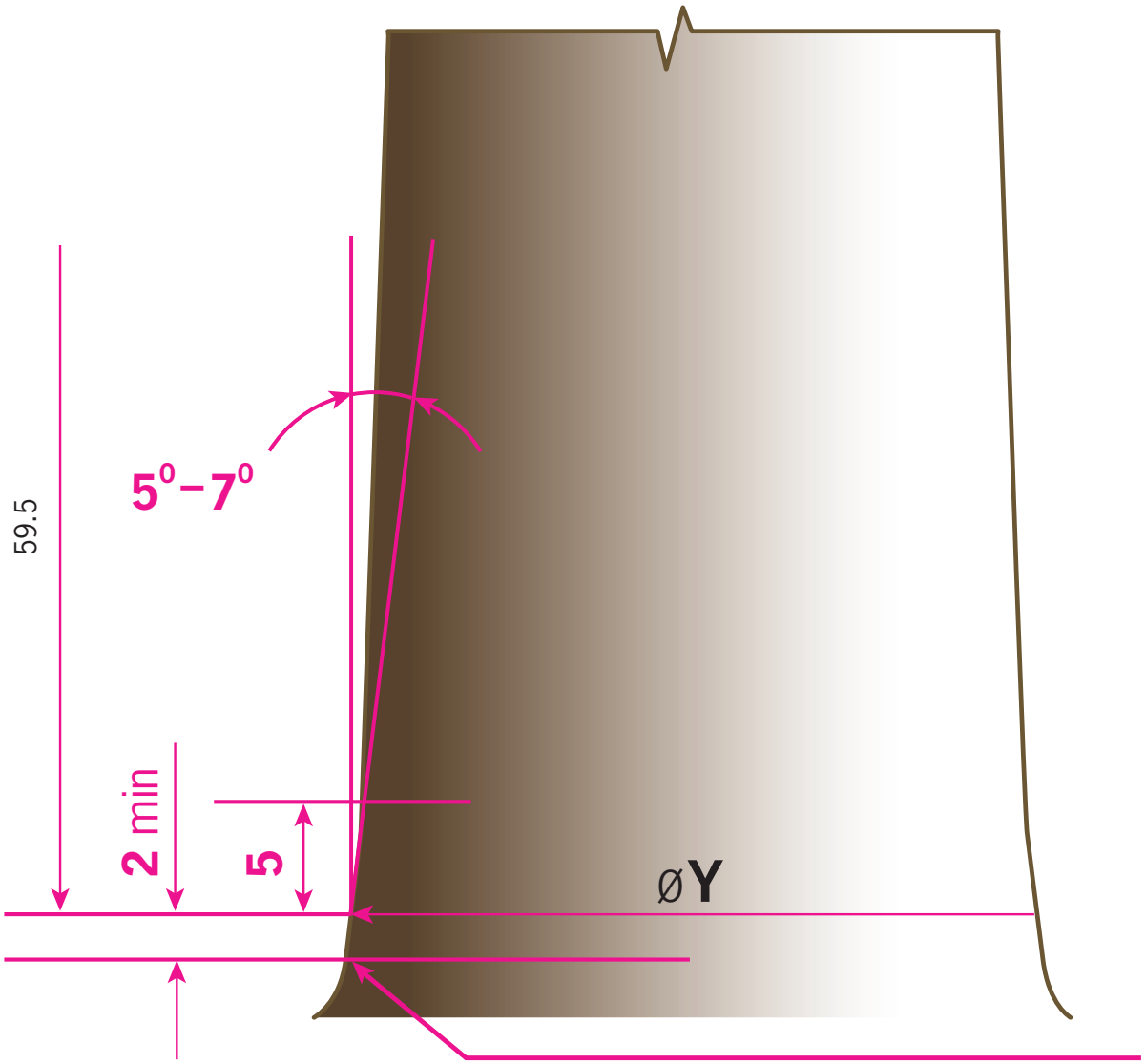


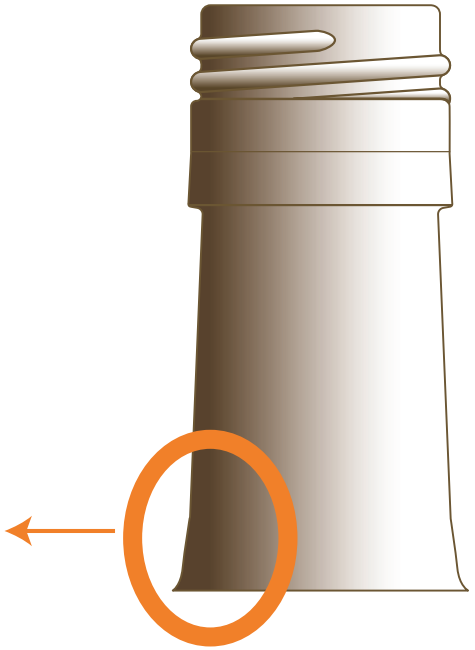
Use in conjunction with CE.T.I.E norm DT 22 – Depressed thread

(Dimensions in millimetres)

CHANDLER GLASS & PACKAGING

Neck Profile: Glass BVS Mouth 30 x 60





Note: The 5°–7° angle must continue for a minimum of 2mm beyond the point Y to allow the cap vertical movement during the capping operation (compression and elastic memory of the liner. Beyond this 2mm point, the profile/design is at the glassmakers discretion.

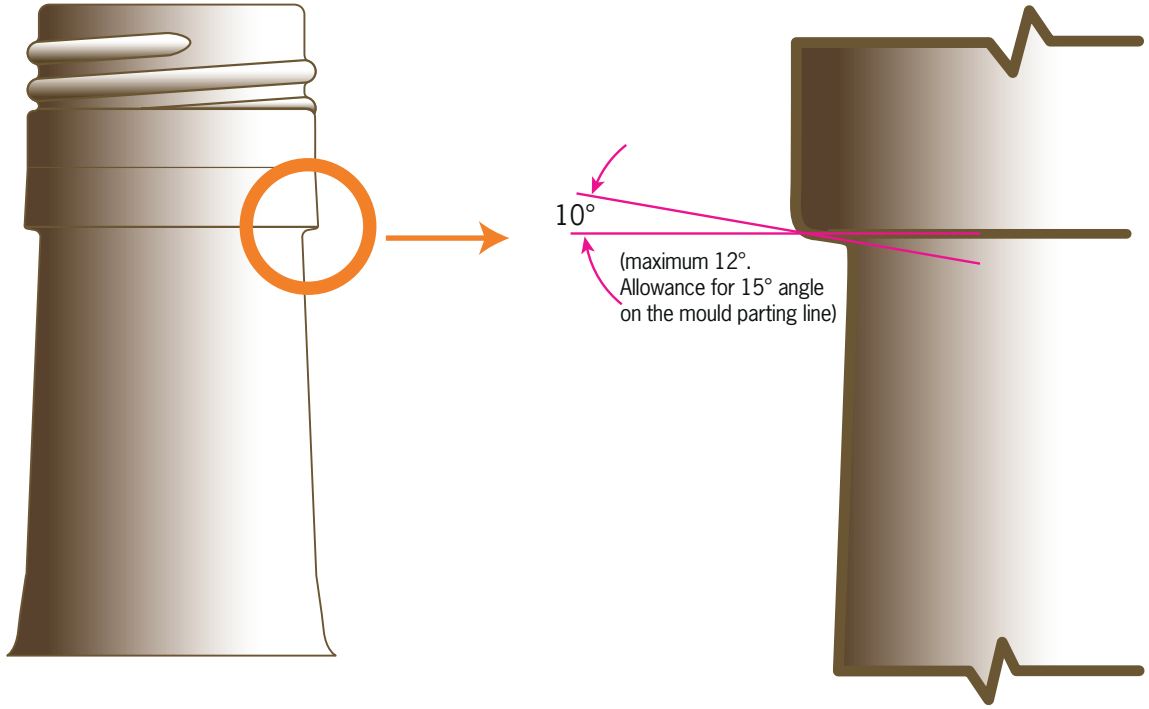
- 5°–7° angle at Y point, is a specific requirement for Chandler

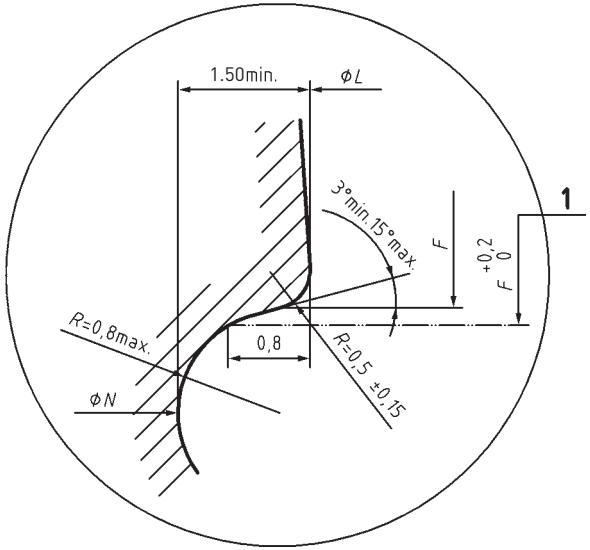
(Dimensions in millimetres)

CHANDLER GLASS & PACKAGING

Construction of transfer bead: Glass BVS Mouth 30 x 60

BVS 30 x 60





Key

1 gauge measurement

F crimping edge, vertical height, threaded finishes

L locking bead diameter

N neck (under bead) diameter

Under-tuck limits L – N = 3.0mm minimum to 4.0mm maximum differential (1.50mm MIN to 2.0mm MAX. each side)

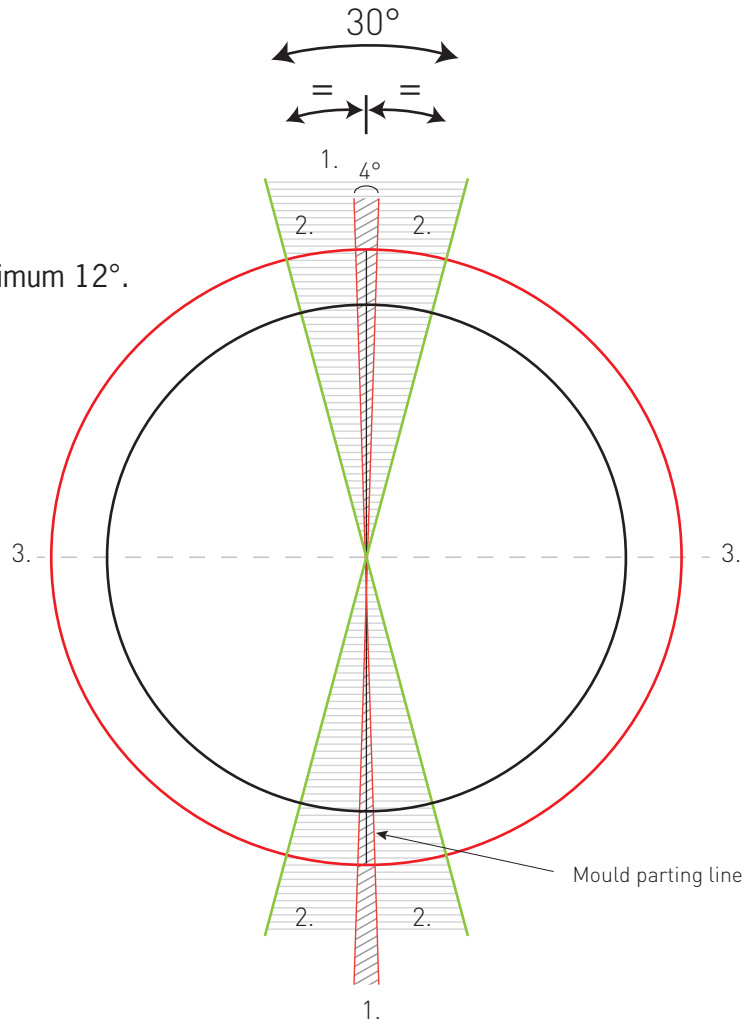
- 12° maximum under-tuck angle, is a specific requirement for Chandler

CHANDLER
GLASS & PACKAGING

BVS Mouth Finish — Plan View Special Requirements for under-tuck angle

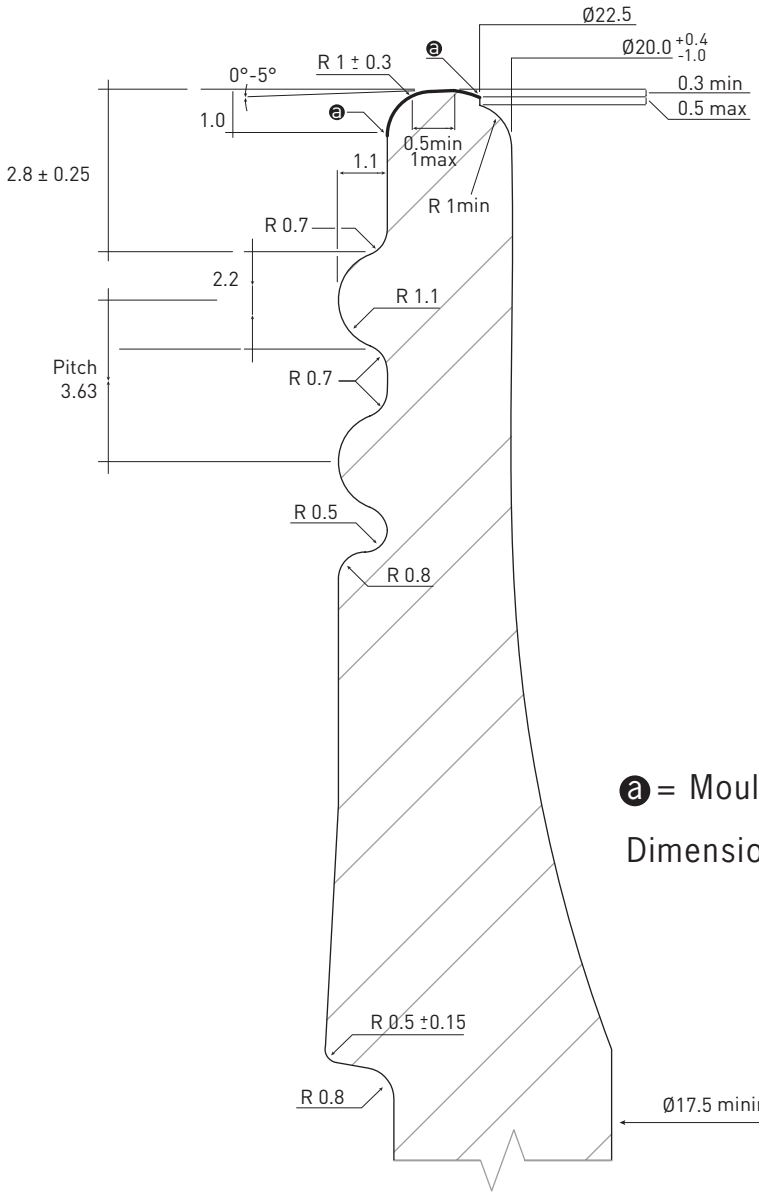
Under-tuck bead angles are measured in six positions in three zones.

Zone 1. Measure on or within 2° of both mould parting lines. Maximum 15° angle.
Zone 2. Measured any two positions within 15° either side of mould parting line. Maximum 12°.
Zone 3. Measured 90° either side of mould parting line.
Target 10° angle (maximum 12°)



NB: Among all under-tuck bead angles that are measured, if the largest angle is outside of the specification, the bottle is not qualified (the largest angle determines whether the bottle is within specification or not).

Thread Finish Profile: BVS Mouth 30 x 60



ⓐ = Mould parting line

Dimensions in millimetres

CHANDLER GLASS & PACKAGING

Depressed Thread DT22 – Option: BVS Mouth 30 x 60

"Depressed threads" are used on continuous thread finishes to reduce the thread depth at and adjacent to the mould parting line.

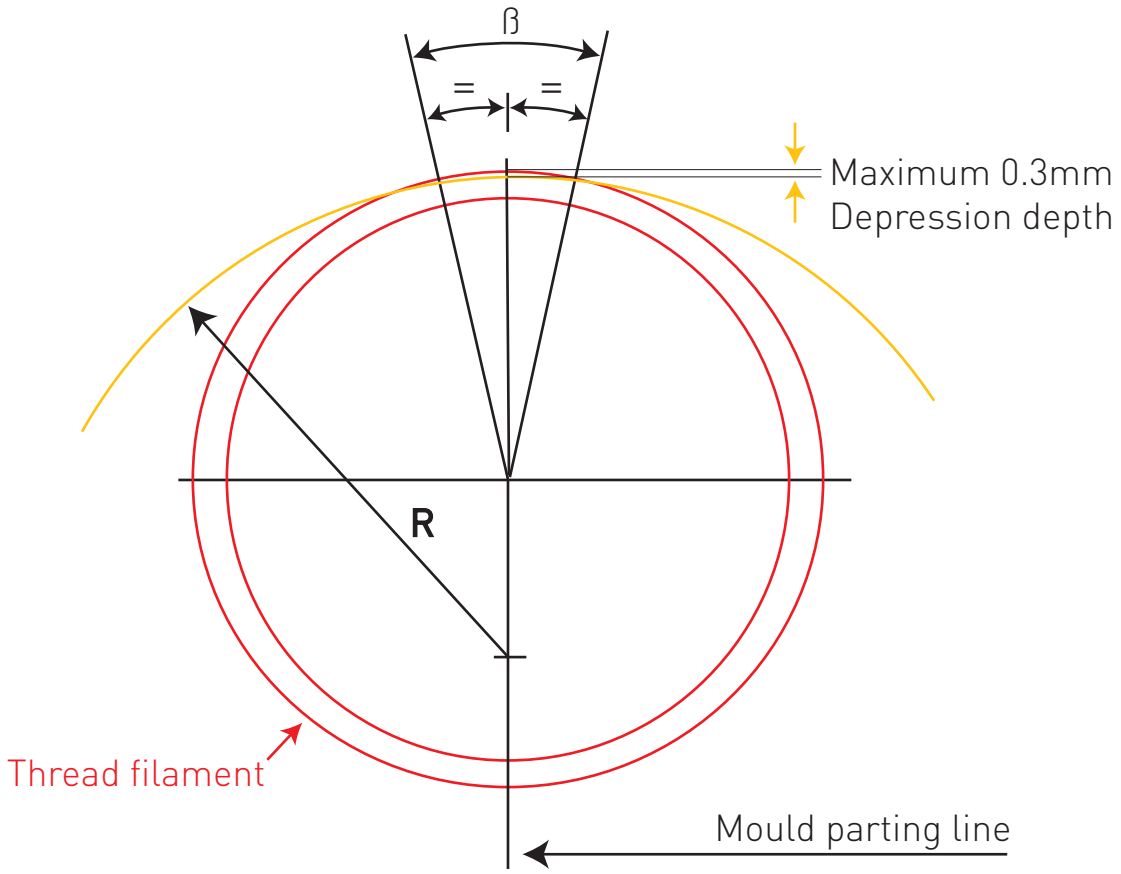
It is used to reduce the risk of any prominent seam line or off-set mould joint scraping the internal lacquer from the inside of pre-formed metal closures.

1. The depression does not exceed 30° arc (ß) centrally placed on the mould parting line and does not generally exceed a depth of 0.30mm. The actual values may vary with nominal neck diameter

2. It is normally recommended that the start and finish of thread is at least 45° from the mould parting line.

3. Depressed threads have previously not been used on ROPP type finished, where the closure is formed on the neck finish. The exception is with the BVS thread where torque values must be maintained under 18lb/in.

4. Minimum tolerances of thread diameter do not apply to the depressed thread area.



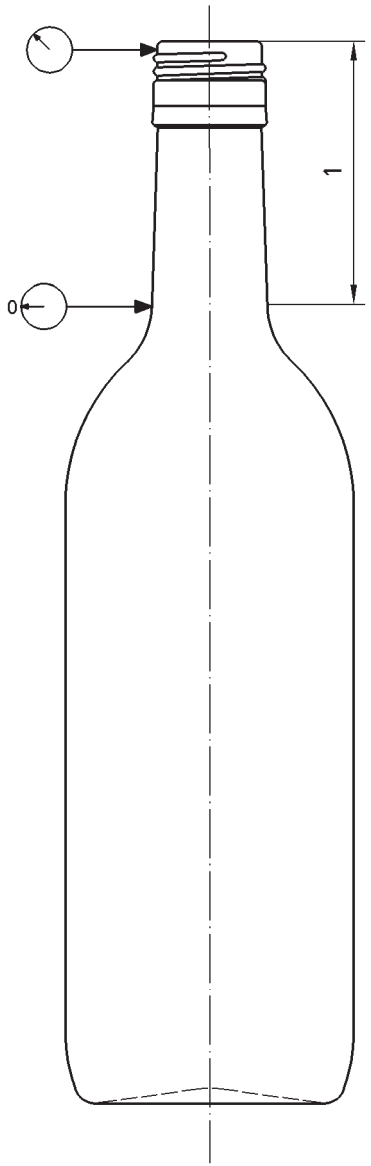
ß = 30°

CE.T.I.E

Control of bottle and neck verticality

Deep BVS finishes require a good control of bottle verticality as per CETIE data sheet DT 2 [4].

Additionally, because of the special closure application on this finish, further controls for “bent necks” are also required for optimum performance.



Key

1 neck length

Measurement and tolerance for “bent necks”

Necklength	Tolerance ±
≤ 50 mm	Not applicable
> 50 mm to ≤ 80 mm	1,1 mm
> 80 mm	1,3 mm