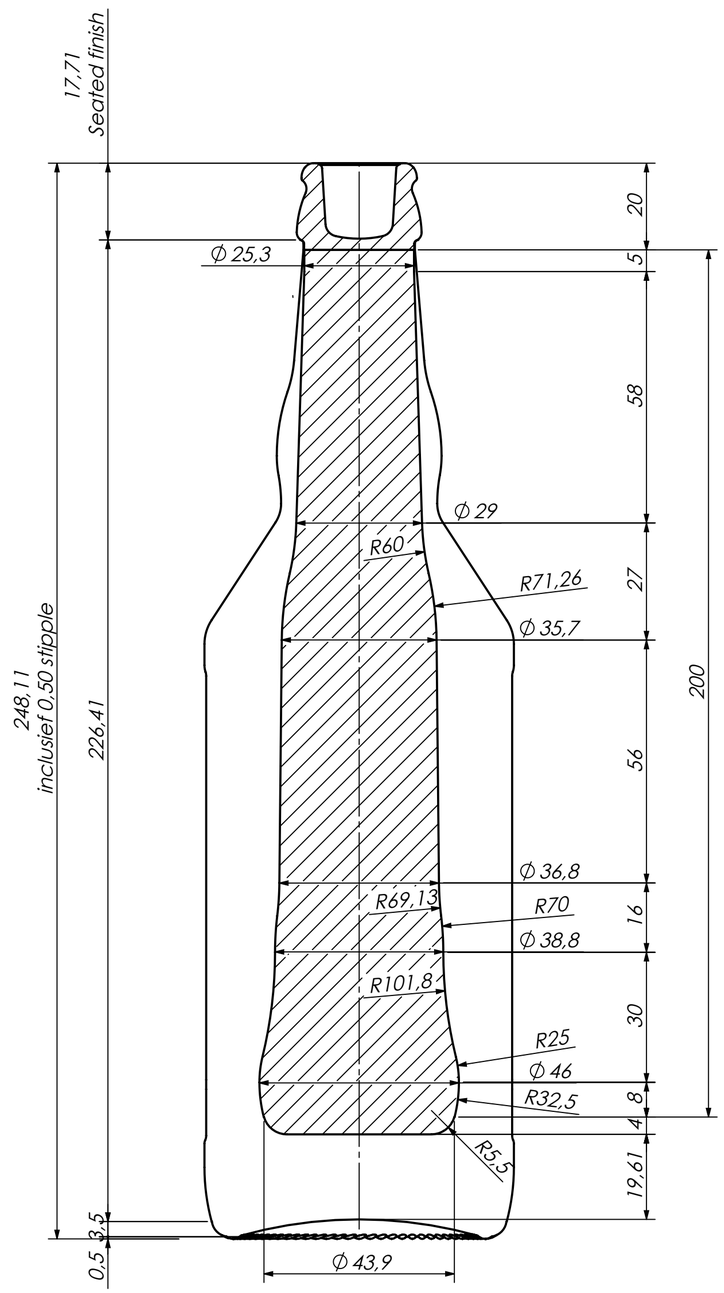

CONTAINER SPECIFICATION DATA

CAPACITY		GLASS DETAIL		NECK FINISH DETAIL	
BRIM FULL	520	WEIGHT	345,00	TYPE	26-600
FILL POINT	500	COLOUR	Flint	SPEC,	

DESIGN DATA

CONTAINER OVERAL HEIGHT	247	CHAMFER SEAT IN MOULD TOP	0,8R
HEIGHT SHRINKAGE FACTOR GLASS	1,004	MOULD NECK DIAMETER	25,7
HEIGHT CONTRACTION ALLOWANCE	0,99	BLANK NECK DIAMETER	25,3
O/HT. OF GLASS IN EQUIPMENT	247,99	RING NECK DIAMETER	25,4
FINISH HEIGHT	12	SEATED FINISH HEIGHT	11,3

MOULD EQUIPMENT DATA — Heye 5 DG BB

INVERT	85,7	BLANK HOLDER/ASS No.	2101200097
MOULD HOLDER/ASS No	2101200016	BLANK H-DIM	92,1
MOULD H-DIM	66,7	NECKRING DOVETAIL DIAMETER	89
BOTTOMPLATE DOVETAIL DIAMETER	92	BAFFLE FUNNEL DIAMETER	65,2
BLOWHEAD No.	1	TAKE OUT TONGUE No	1

VOLUME CALCULATIONS

BLOWMOULD VOLUME CALCULATIONS

GLASVOLUME=GLASSWEIGHT /	2,5 DENSITY COLD GLAS	138,000
VOLUME COMPLETE COLD CONTAINER = GLASSVOLUME+BRIMFULL		658,000
VOL HOT CONTAINER = VOLUME COLD CONTAINER x	1,013 SINKAGE&SHRINKAGE	666,554
VOLUME MOULD+BOTTOM = VOLUME HOT CONTAINER -	9,724 SEATED FINISH	656,830
VOLUME BLOWMOULD CAVITY		649,648
VOLUME BOTTOM CAVITY		7,182
TOLERANCE ON TOTAL DISPLACEMENT		+/- 1,5

BLOW BLOW BLANKMOULD VOLUME CALCULATION

	HOT GLASS DENSITY	x OVERCAPACITY %	
PARISON VOLUME = GLASSWEIGHT/	2,43	41,674	201,142
VOL. BLANK+BAFFLE =	VOL. PARISON -	7,276 NECKRING-PLG VOLUME	193,866
VOLUME BLANK CAVITY			188,535
VOLUME BAFFLE CAVITY			5,331
TOLERANCE ON TOTAL DISPLACEMENT			+/- 1

INVERT CENTRE :
'H' DIMENSION :
ASSEMBLY :
SCALE : 1:1

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DO NOT SCALE DRAWING
IF IN DOUBT ASK

TOLERANCES UNLESS OTHERWISE SPECIFIED
DIMS: 0.0 ± 0.2 DIMS: 0.00 ± 0.05
REMOVE BURRS & SHARP EDGES IN
ACCORDANCE TO STANDARD PRACTICE

THIRD ANGLE PROJECTION

SURFACE FINISH
CAST: ROUGH: FINE: POLISH:

JOB NAME	500ml YAK DA SEBE		
ITEM	LAYOUT	QUANTITY	
CUSTOMER	BELSTEKLOPROM	REF. NO.	
ORDER NO.	20190058	DRAWN BY	JBB
MATERIAL		CHECKED BY	
MACHINE	Heye 5" BB DG	DATE	27-2-2019

REVISIONS

DRG No: BIEB825-04