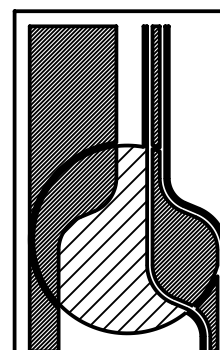


CONTAINER SPECIFICATION DATA					
CAPACITY		GLASS DETAIL		NECK FINISH DETAIL	
BRIM FULL	1080	WEIGHT	430,00	TYPE	Special
FILL POINT	1000	COLOUR	flint	SPEC,	
DESIGN DATA					
CONTAINER OVERAL HEIGHT	168,4	CHAMFER SEAT IN MOULD TOP			1,2
HEIGHT SHRINKAGE FACTOR GLASS	1,004	MOULD NECK DIAMETER			78,2
HEIGHT CONTRACTION ALLOWANCE	0,67	BLANK NECK DIAMETER			77,9
O/HT. OF GLASS IN EQUIPMENT	169,07	RING NECK DIAMETER			78
FINISH HEIGHT	9	SEA TED FINISH HEIGHT			8,93
MOULD EQUIPMENT DATA			BDF PB BB 5 1/2		
INVERT	50	BLANK HOLDER/ASS No.			21
MOULD HOLDER/ASS No	54	BLANK H-DIM			69,85
MOULD H-DIM	9,53	NECKRING DOVETAIL DIAMETER			133,4
BOTTOMPLATE DOVETAIL DIAMETER	117	BAFFLE FUNNEL DIAMETER			post type
BLOWHEAD No.	2a	TAKE OUT TONGUE No			
VOLUME CALCULATIONS					
BLOWMOULD VOLUME CALCULATIONS					
GLASS VOLUME=GLASSWEIGHT /	2,5 DENSITY COLD GLAS				172
VOLUME COMPLETE COLD CONTAINER = GLASSVOLUME+BRIMFULL					1252
VOL HOT CONTAINER = VOLUME COLD CONTAINER x		1,0148 SINKAGE&SHRINKAGE		1270,5296	
VOLUME MOULD+BOTTOM = VOLUME HOT CONTAINER -		75,190 SEA TED FINISH		1195,340	
VOLUME BLOWMOULD CAVITY					1170,666
VOLUME BOTTOM CAVITY					24,6736
TOLERANCE ON TOTAL DISPLACEMENT					+/- 1
PRESS BLOW BLANKMOULD VOLUME CALCULATION					
	HOT GLASS DENSITY	+ PLUNGER VOLUME			
PARISON VOLUME = GLASSWEIGHT/	2,45	202,841			378,351
VOL. BLANK+BAFFLE =		VOL. PARISON -		84,608 NECKRING-PLG VOLUME	293,743
VOLUME BLANK CAVITY					287,084
VOLUME BAFFLE CAVITY					6,659
TOLERANCE ON TOTAL DISPLACEMENT					+/- 1

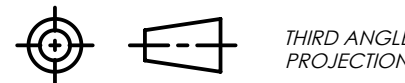
INVERT CENTRE :-
'H' DIMENSION :-
ASSEMBLY :-
SCALE : 1:1



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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



SURFACE FINISH
CAST: ~ ROUGH FINE: ~ POLISH: ~

JOB NAME		1000ml BANKA JAR	
ITEM	LAYOUT	QUANTITY	
CUSTOMER	Raudkull	REF. NO.	
ORDER NO.	-	DRAWN BY	JBB
MATERIAL		CHECKED BY	
MACHINE	PB DG 5"1/2	DATE	9/04/2014
REVISIONS			
DRG No: BIEB511-04			