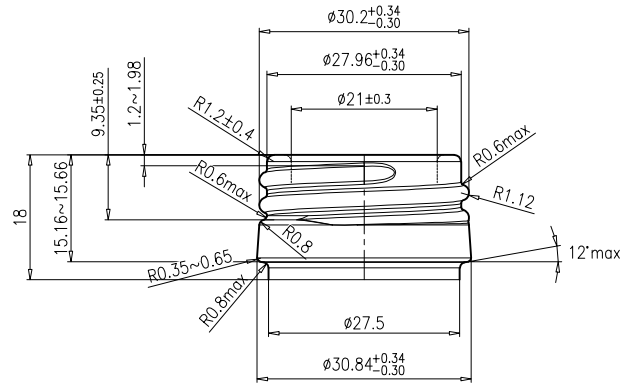
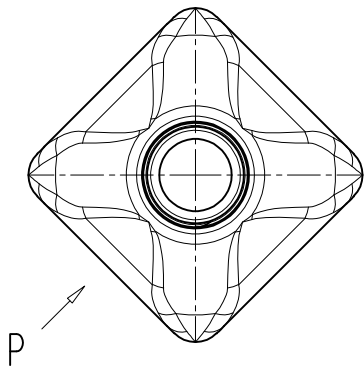
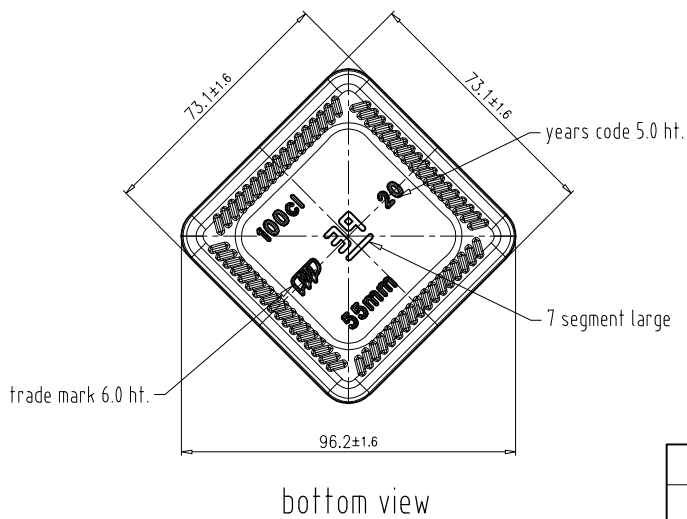
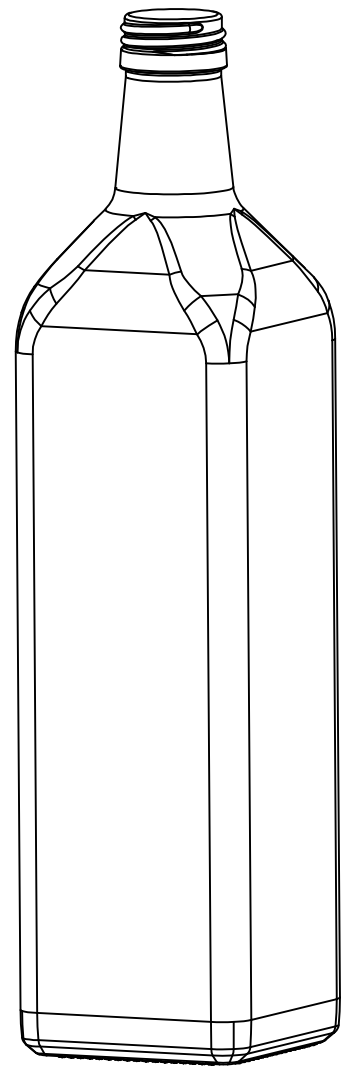
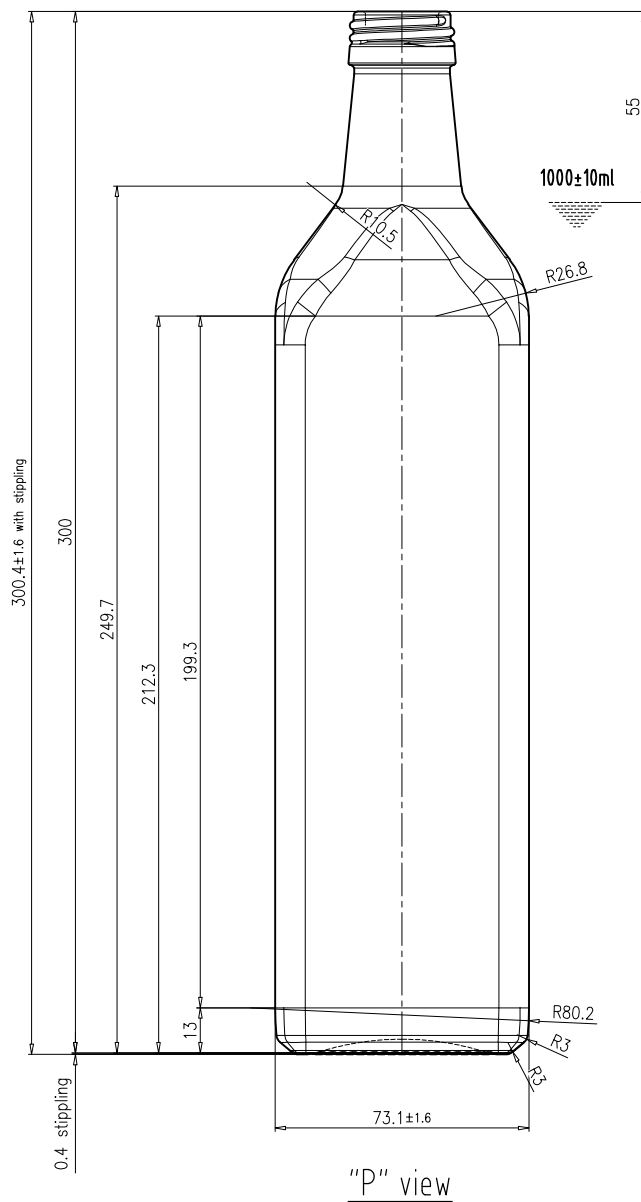
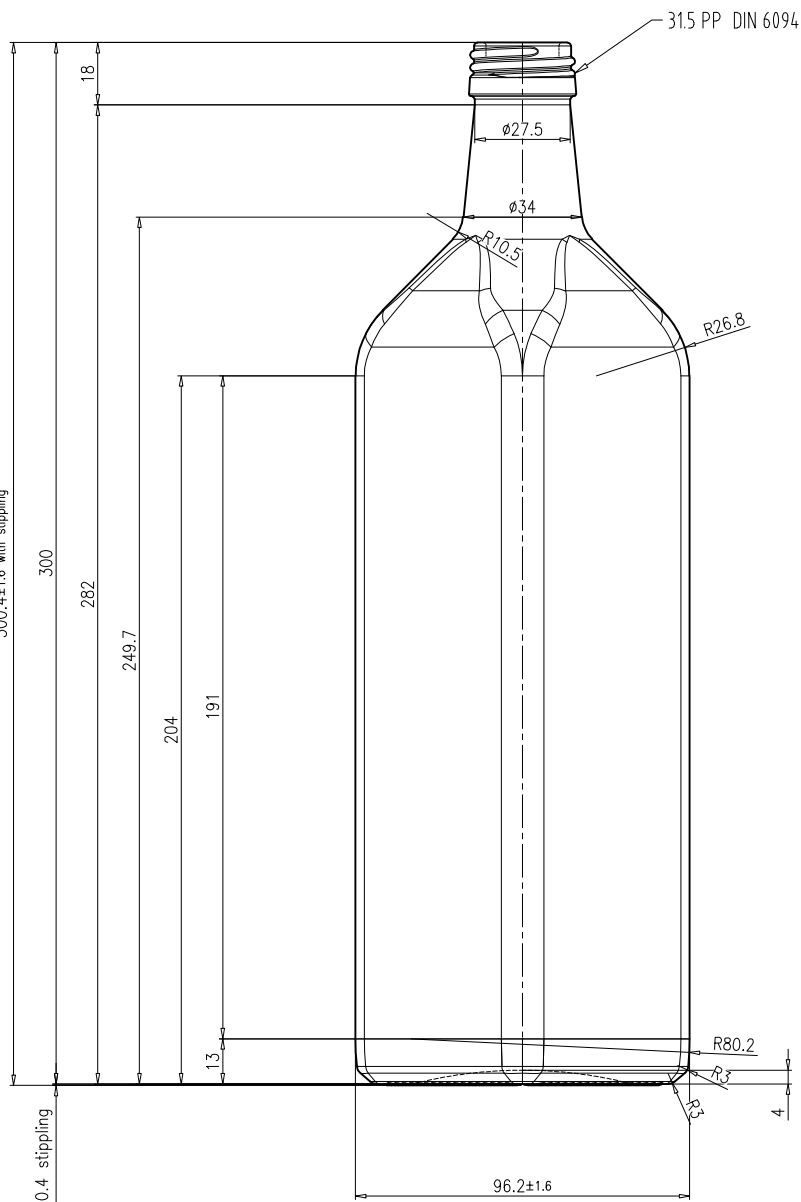


top view



scale 2:1

DIN 6094 PP31.5STD  
pitch = 3.62mm  
cutter dia = 12.5mm  
helix angle = 2°16'  
cutter angle = 2°16'



bottom view

hot finish coating	
hot end coating	
cold end coating	

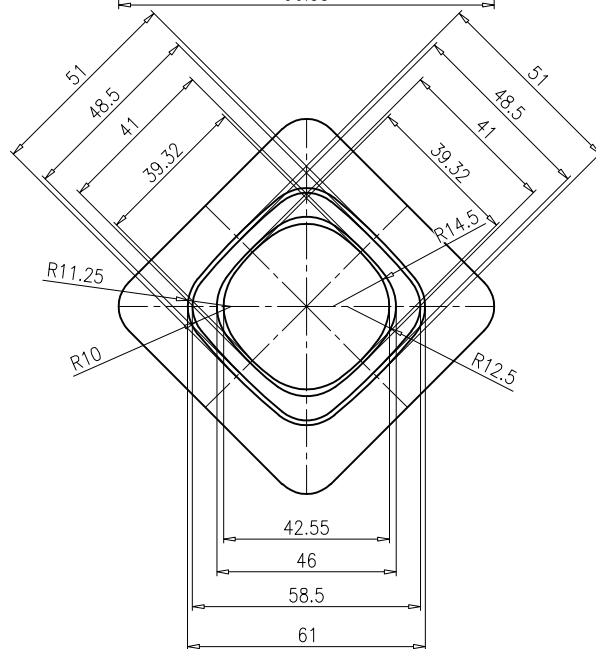
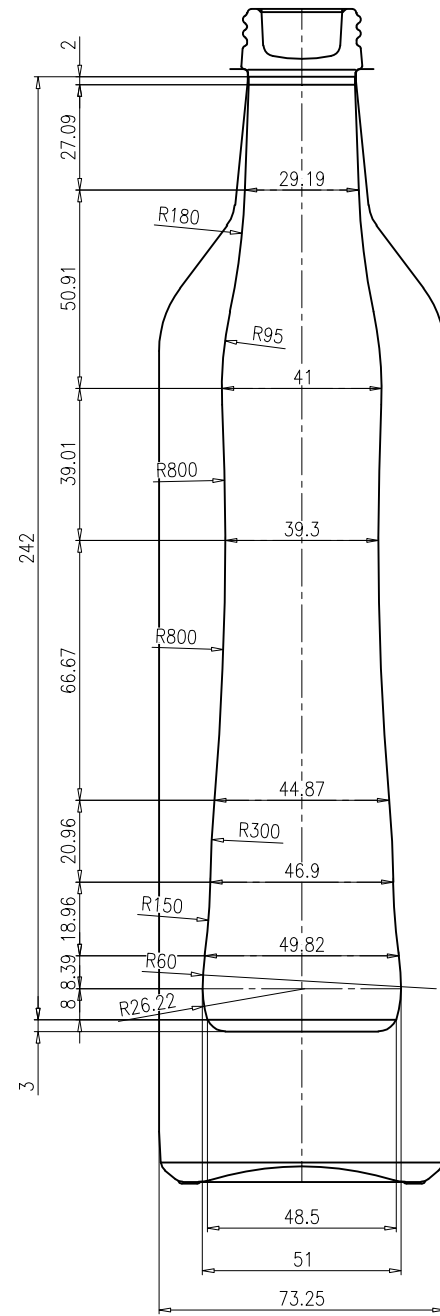
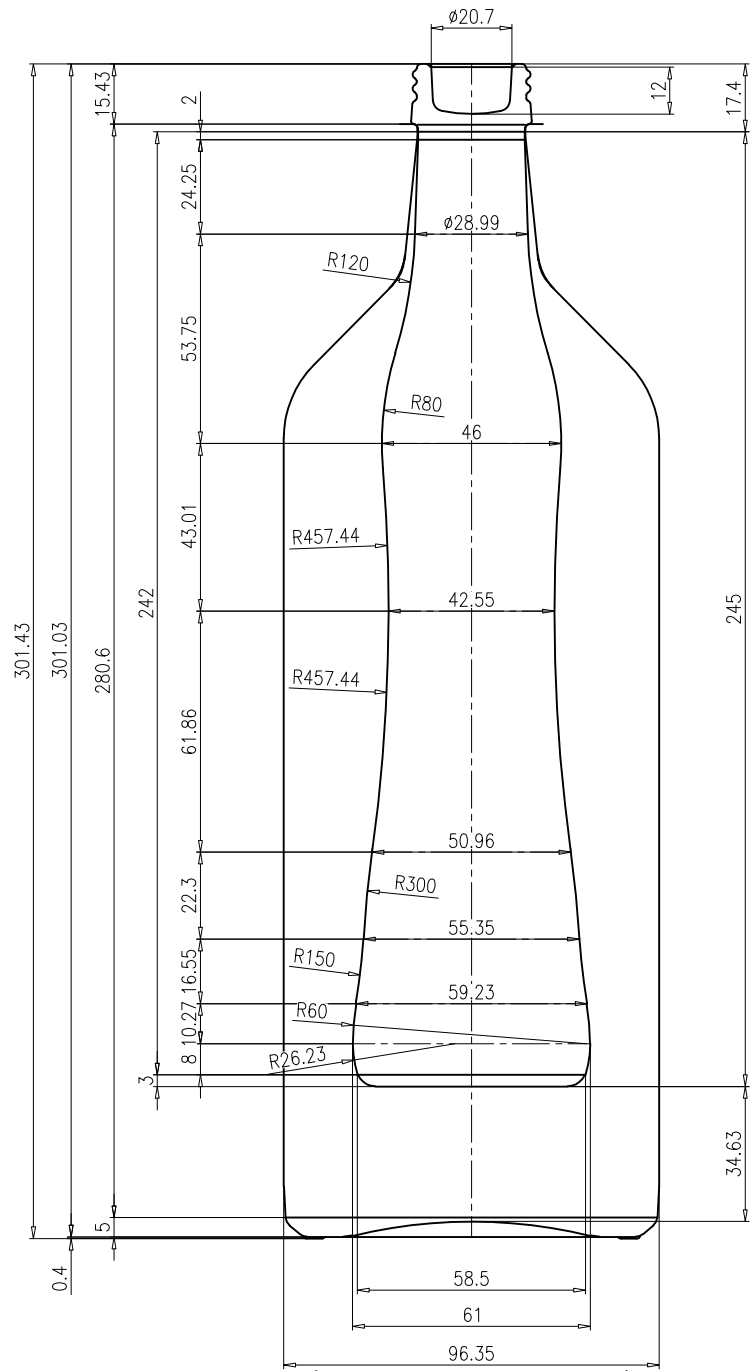
客户批准信息/CUSTOMER APPROVAL	
审批意见 DESIGNATION	
签字/SIGNATURE	
日期/DATE	

耐水性能/HYDROLYTIC RESISTANCE	*** 级/grade
应力等级/TRESS	≤ 4 级/grade
垂直负荷/VERTICAL LOAD	≥ *** N
抗冲击力/IMPACT STRENGTH	≥ *** J
内压强度/INTERNAL PRESSURE	≥ *** MPa
抗热震性能/THERMAL SHOCK	≥ 42 °C
瓶口椭圆度/OVALITY FINISH	≤ *** mm
瓶身椭圆度/OVALITY BODY	≤ *** mm
垂直轴偏差/VERTICALITY	≤ 3.3 mm
口平面不平度/BENT FINISH	≤ *** mm
口对底平行度/HORIZONTALITY	≤ 0.8 mm
瓶肩壁厚/SHOULDER THICKNESS	≥ 1.2 mm
瓶身壁厚/BODY THICKNESS	≥ 1.2 mm
瓶跟壁厚/HEEL CONTACT THICKNESS	≥ 1.2 mm
瓶底壁厚/BASE THICKNESS	≥ 2.2 mm

技术规范/SPECIFICATION

满口容量 BRIMFUL CAP	1025±10	CC	成型工艺 PROCESS	B&B	设计/DESIGN	L.T.	08-04-2020	D/M/Y	瓶口标准 FINISH	31.5 PP DIN 6094	图纸版次/REV.
灌装容量 FILLING CAP	1000±10	CC	玻璃料色 COLOR		审核/REVISION				产品编号 REGISTER		2
灌装线 FILLING LEVEL	55	mm	翻到角度 TILT ANGLE	---	批准/APPROVE				产品名称 JOB NAME	1000ml Square Marasca	
重量 WEIGHT	595±10	g			比例/SCALE	1:1	图纸尺寸使用单位 ALL DIMENSIONS ARE IN		mm		
客户名称/CUSTOMER			兄弟玻璃模具有限公司享有图纸所有权!未经允许,不得复制、使用、转抄						Brother Glass Mould MFG Co.,Ltd		

NECK DIA.		BLANK DATA		BLOW MOULD DISPLACEMENT	
MOULD NECK DIA.	27.7	WEIGHT	595 g		ml
BLANK NECK DIA.	27.3	x HOT GLASS FACTOR	0.41	BRIMFULL CAPACITY	1025
NECK RING NECK DIA.	27.5	= GOB CAPACITY	244.0 ml	+ 595 g WEIGHT x 0.40 CONSTANT	238
		+ OVERCAP 46.80 %	114.2 ml	= CONTAINER DISPLACEMENT	1263
		= GOB CAPACITY + OVERCAP	358.2 ml	+ (x 0.012) SINKAGE & SHRINKAGE	16.4
		- ( NRV 11.8 - PLV 3.8 )	8.0 ml	= TOTAL DISPLACEMENT	1278.2
		= CALC. BL 344.3 + BA DISPL. 5.9	350.2 ml	- RING CAST HEIGHT DISPLACEMENT	10.6
		'L' RATIO	---	= MOULD & BOTTOM DISPLACEMENT	1267.6
		CAP. TO SETTLE LINE	---	- BOTTOM DISPLACEMENT	18.8
		S.L.HT. FROM NR LINE	---	= MOULD CAVITY DISPLACEMENT	1248.8
		RUN /PARISON	=	TOLERANCES ON DISPLACEMENT	±1.5



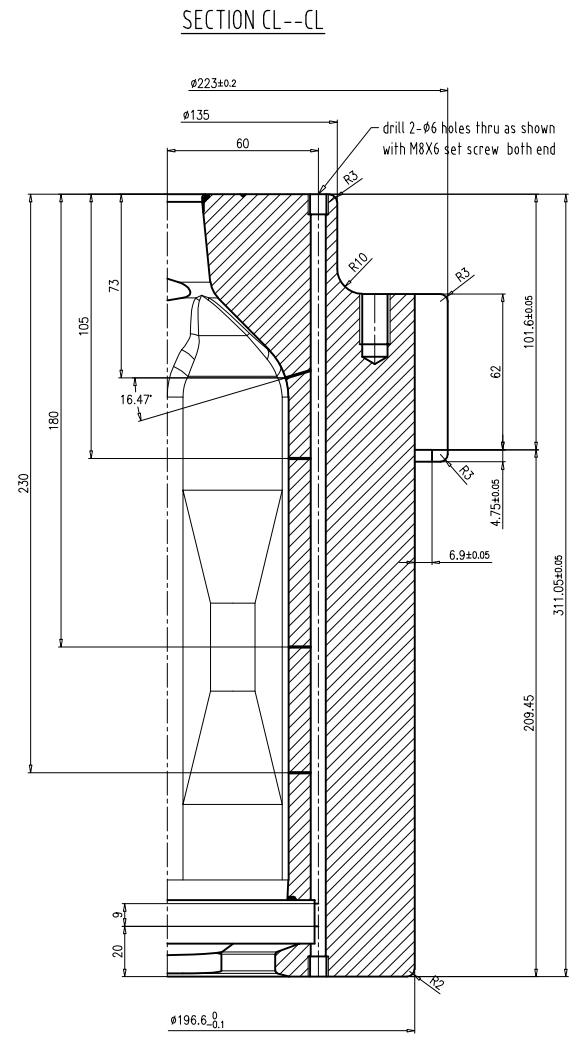
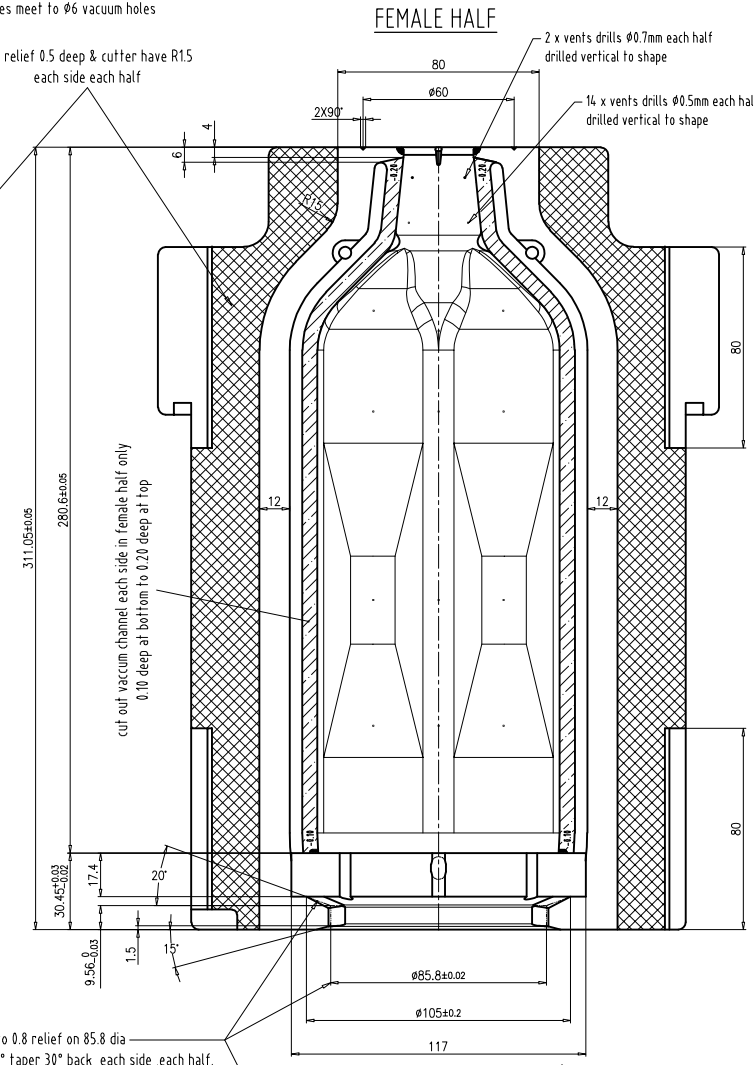
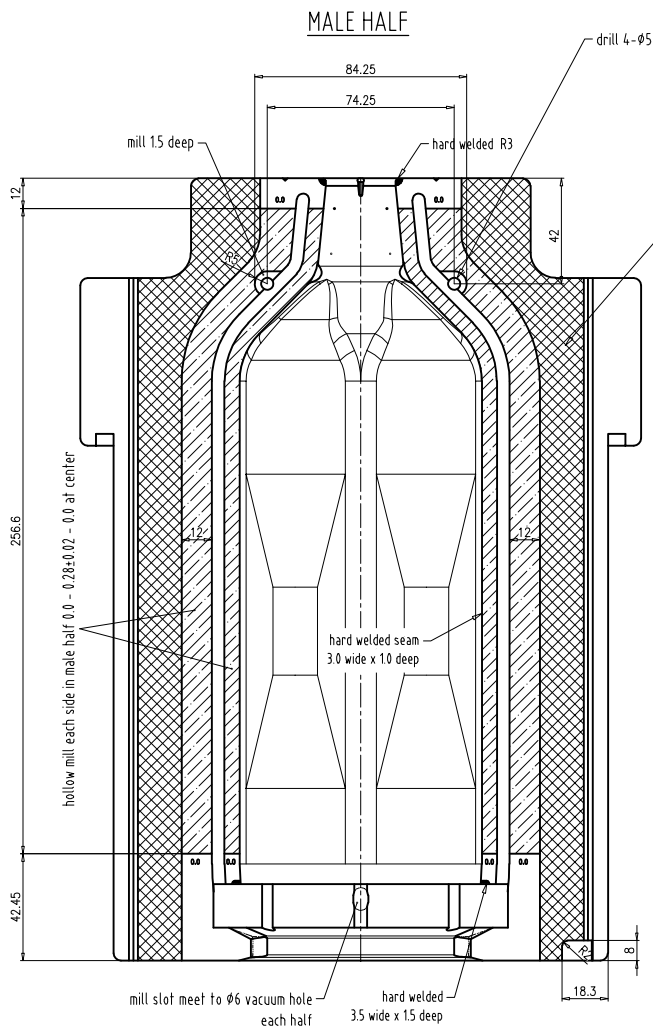
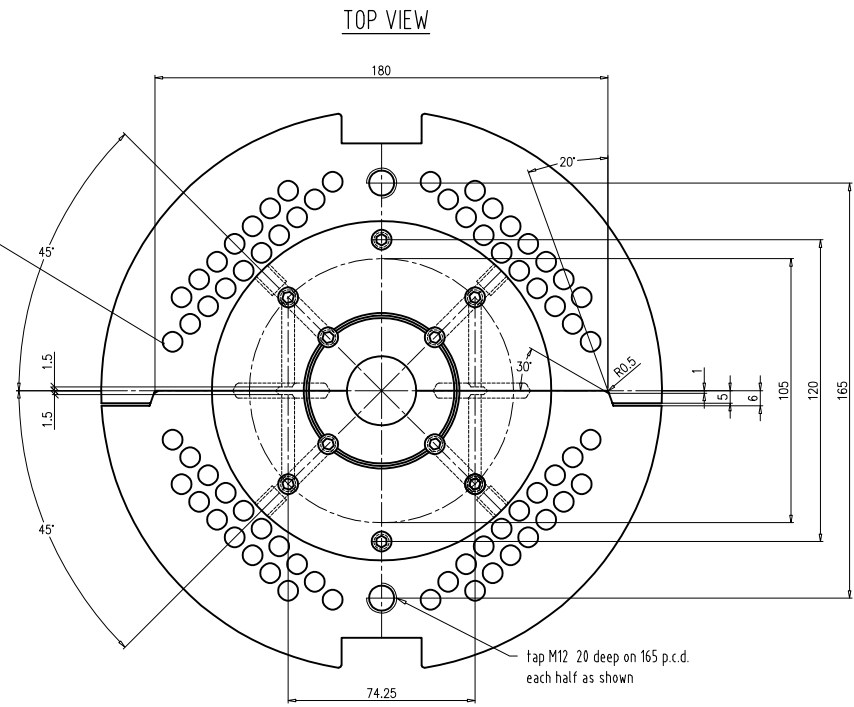
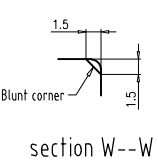
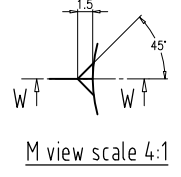
CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-PD-3
DRN	DATE	14-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY

MATERIAL	
MACHINE TYPE	IS 5" SG B&B
CUSTOMER	

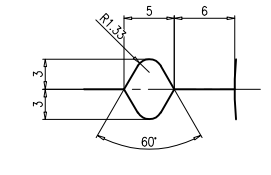
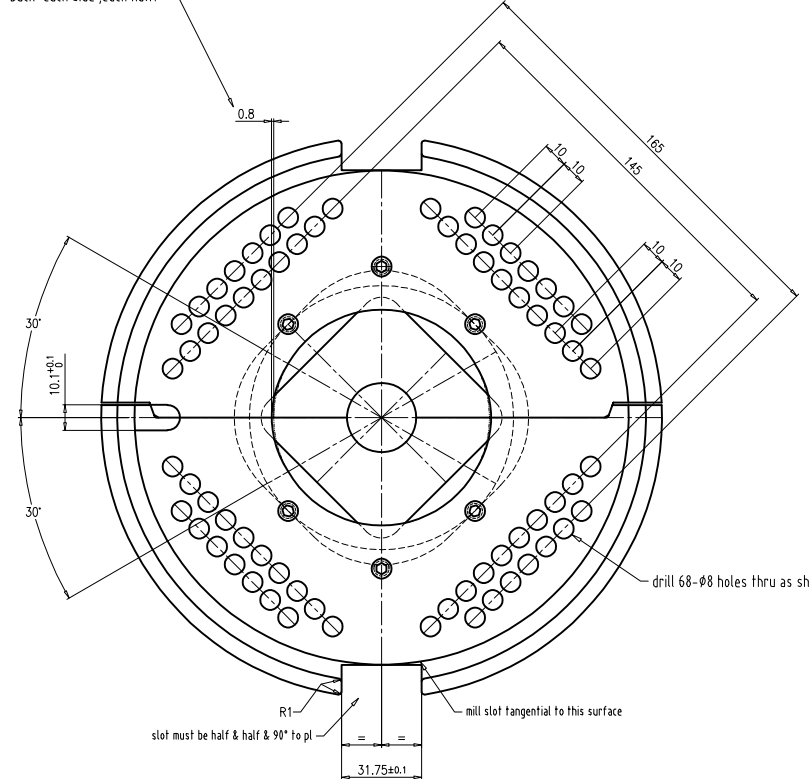
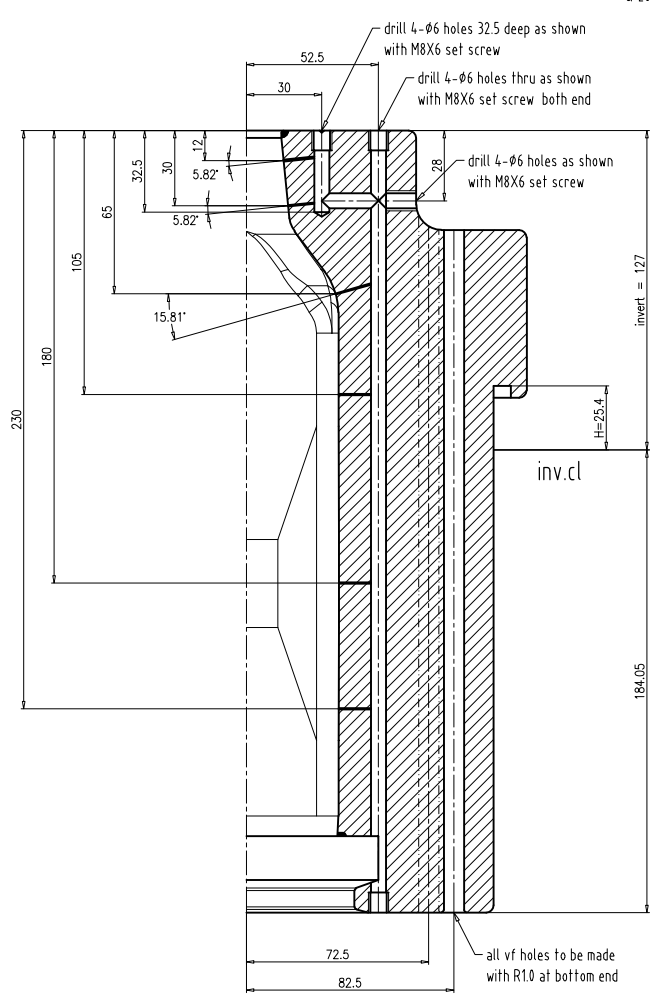
PART NAME	PARISION DESIGN
JOB NAME	1000ml Square Marasca
 Brother Glass Mould MFG Co.,Ltd	

EACH HALF ENGRAVE  
 1000ml Square Marasca 2003228  
 PART NO. 1&UP MONTH/YEAR(one half)

INVERT = 127 mm H = 25.4 mm  
 Assembly Ident.-No = 5#



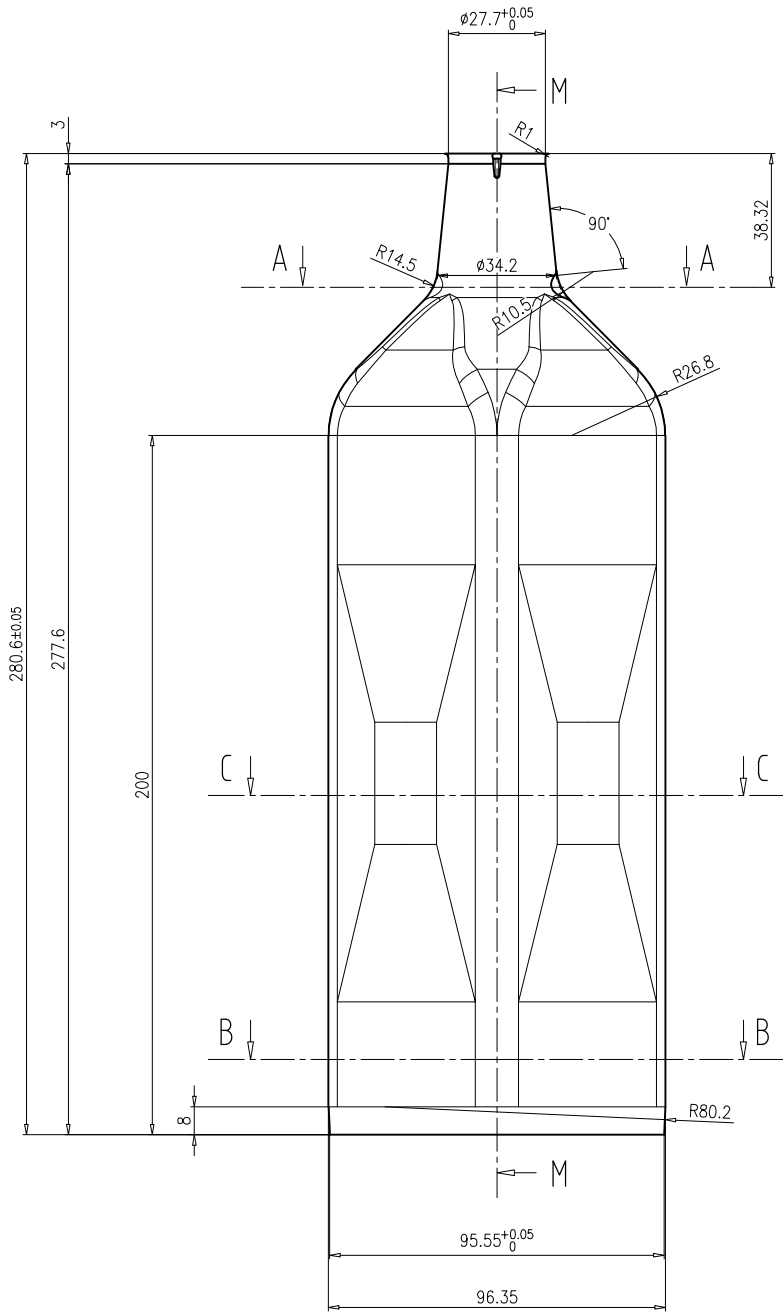
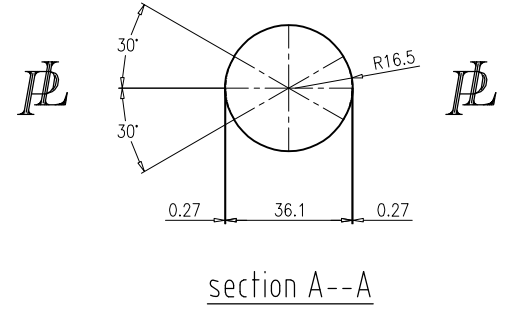
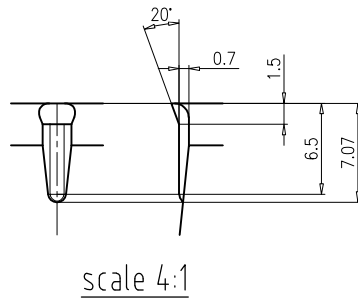
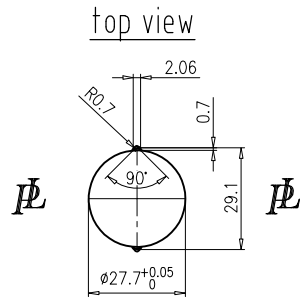
"0" to 0.8 relief on 85.8 dia & 20° taper 30° back each side, each half.



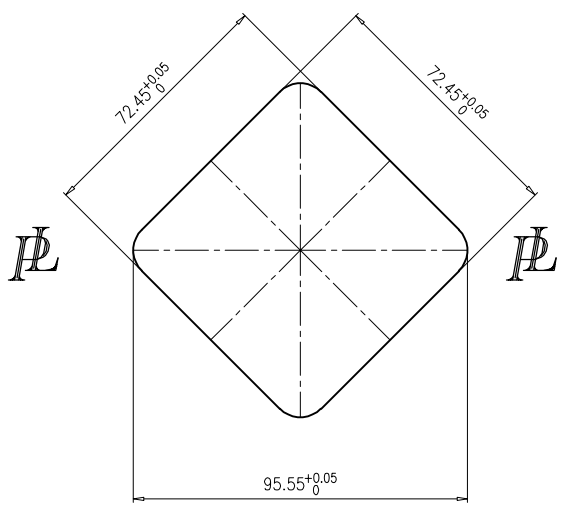
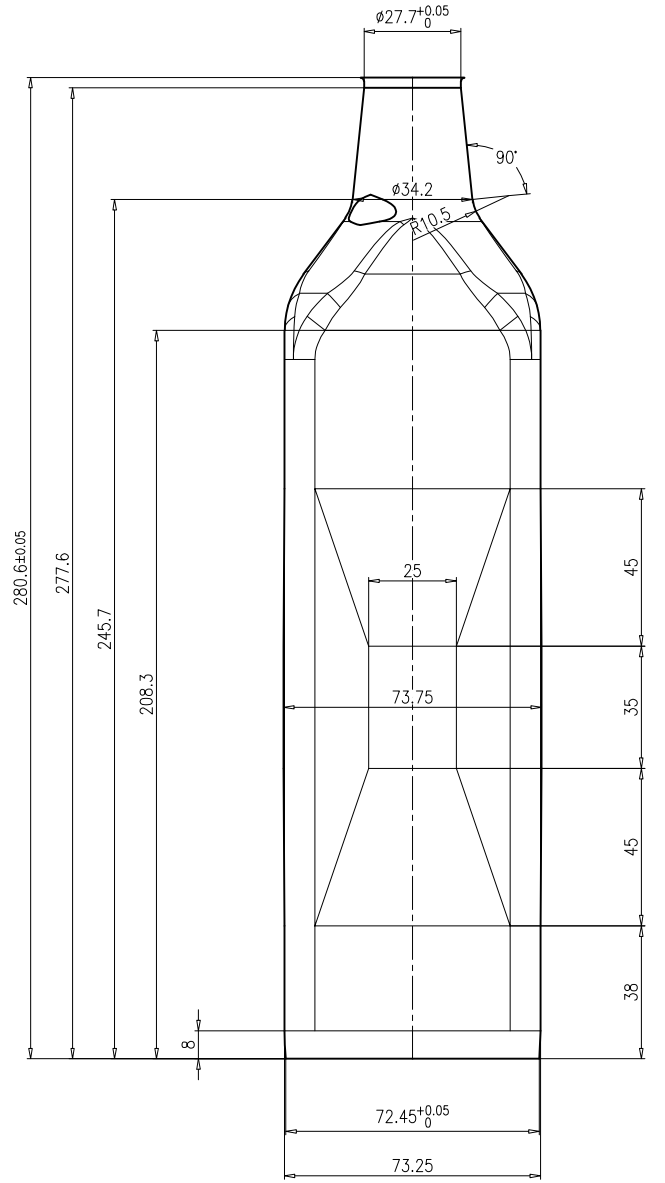
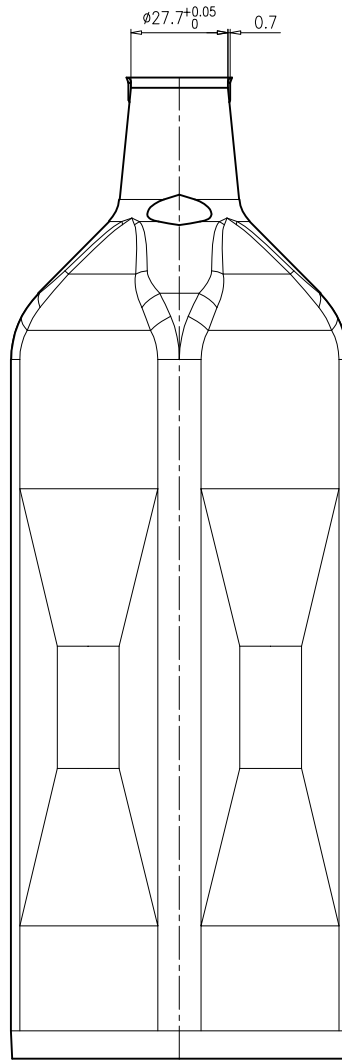
mould seams 30-35 HRC colmony detail

All undimensioned chamfers 1x45° All undimensioned radii R10mm  
 Free dimension tolerance 0.0: ±0.10 Free dimension tolerance 0.00: ±0.05  
 Angle: ±0.5° Profile ±0.05

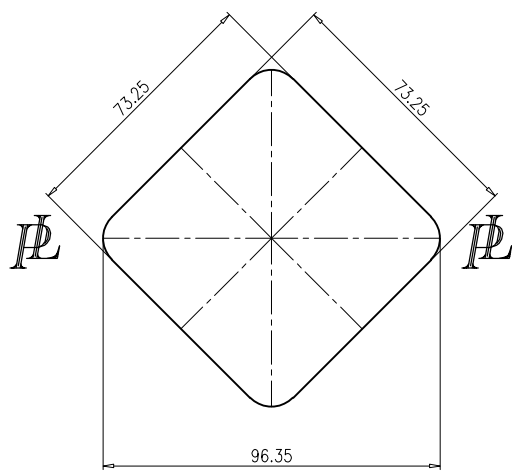
MATERIAL	CAST IRON + METAL		
MACHINE TYPE	IS 5" SG B&B		
CUSTOMER			
CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-BM-2
DRN	DATE 06-05-2020	D-M-Y /BY	L.T.
REVISION	DATE	D-M-Y /BY	
APPROVE	DATE	D-M-Y /BY	
PART NAME	BLOW MOULD		
JOB NAME	1000ml Square Marasca		



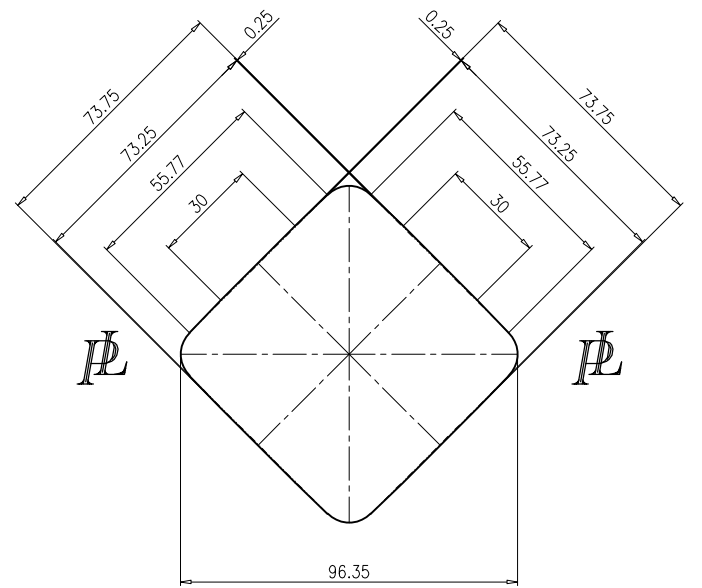
section M--M



bottom view



section B--B



section C--C

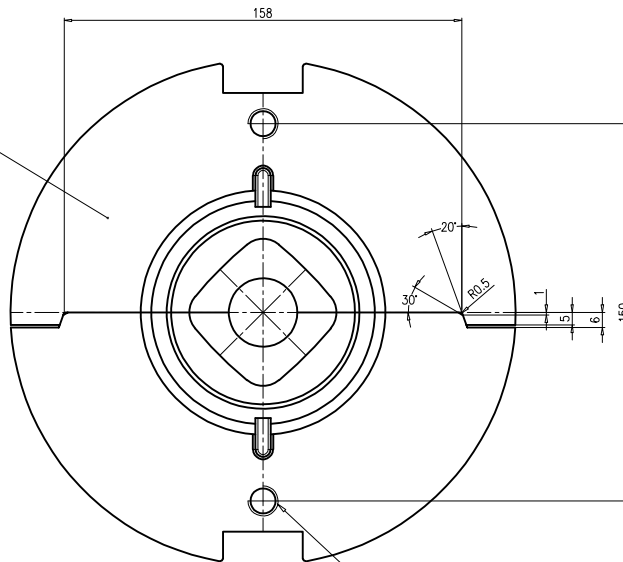
TOTAL = 1267.6 ± 1.5 ml MOULD = 1248.8 ml BOTTOM = 18.8 ml

CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-BMC-0
DRN	DATE	08-04-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY

MATERIAL		PART NAME	MOULD PROFILE
MACHINE TYPE	IS 5" SG B&B	JOB NAME	1000ml Square Marasca
CUSTOMER		 Brother Glass Mould MFG Co.,Ltd	

TOP VIEW

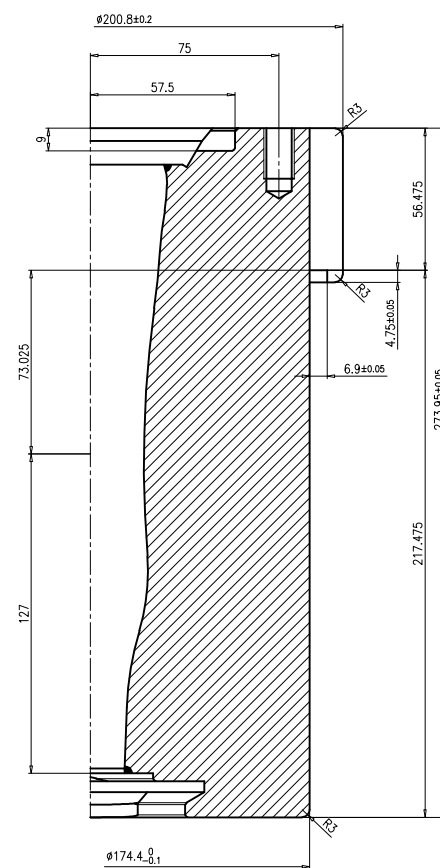
EACH HALF ENGRAVE  
1000ml Square Marasca 2003228  
PART NO. 1&UP MONTH/YEAR(one half)



tap M12 20 deep on 150 p.c.d.  
each half as shown

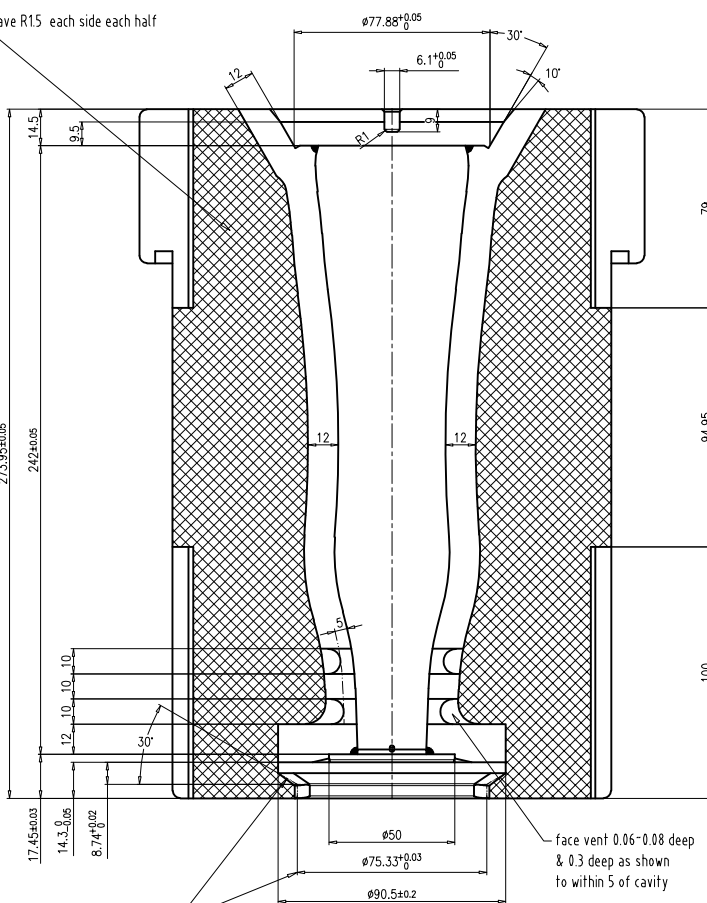
INVERT = 127 mm H = 73.025 mm  
Assembly Ident.-No = 4#

SECTION CL--CL



FEMALE HALF

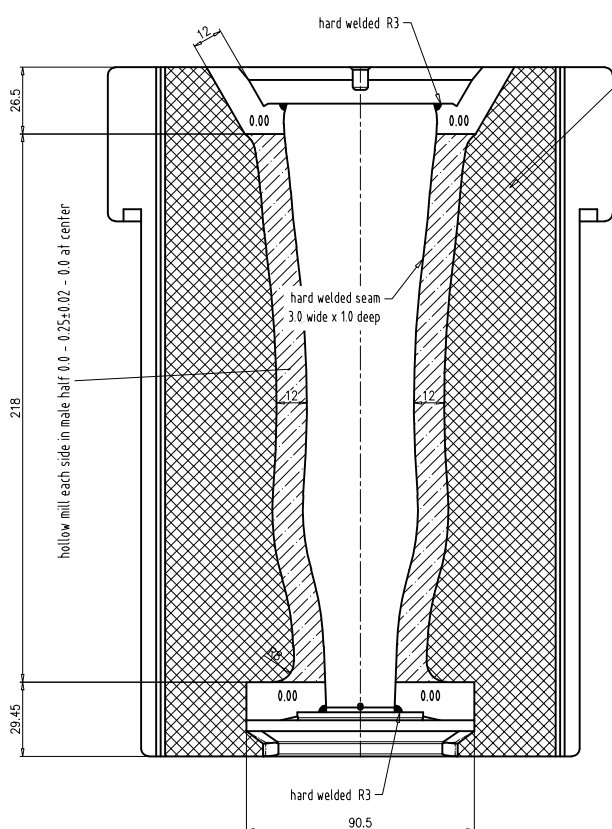
mill relief 0.5 deep & cutter have R15 each side each half



face vent 0.06-0.08 deep  
& 0.3 deep as shown  
to within 5 of cavity

relieve 0-1.0 between 30° arcs on  $\phi 75.33$   
and 30° taper both sides each half

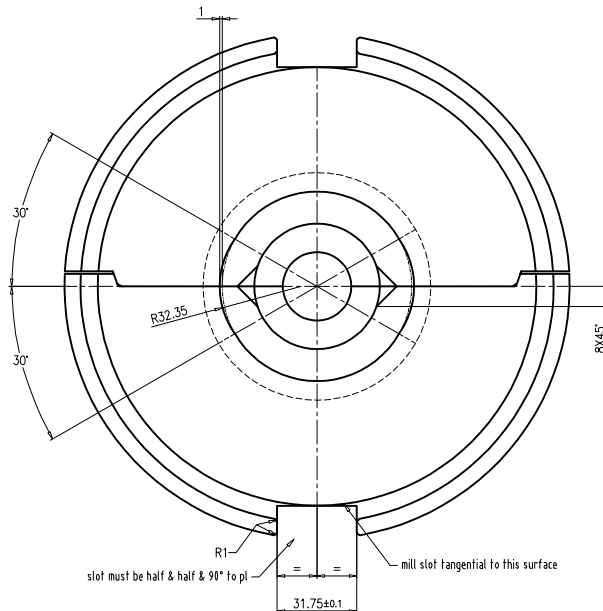
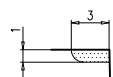
MALE HALF



hollow mill each side in male half 0.0 - 0.25±0.02 - 0.0 at center

hard welded R3

mould seams 30-35 HRC colmonoy detail



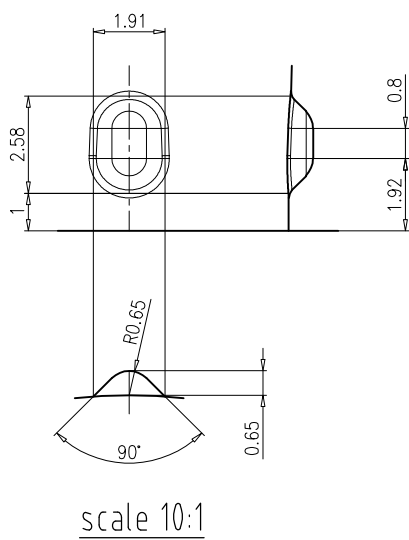
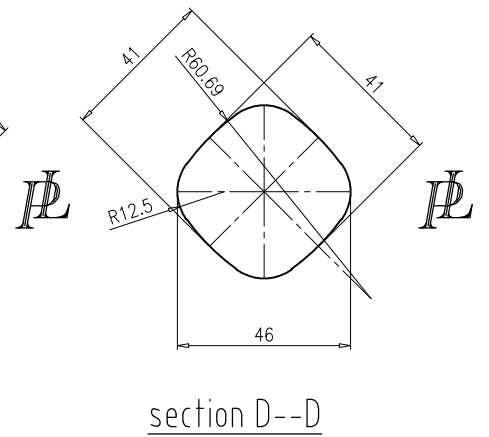
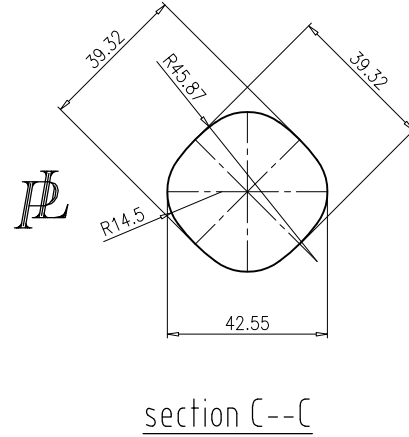
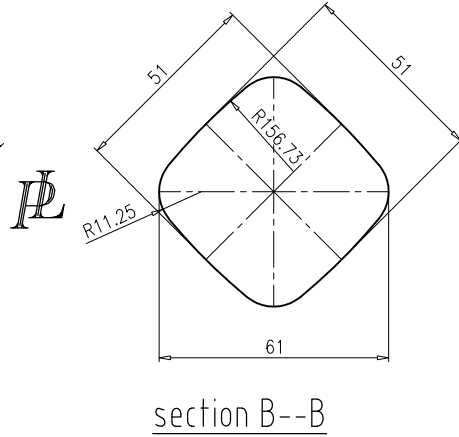
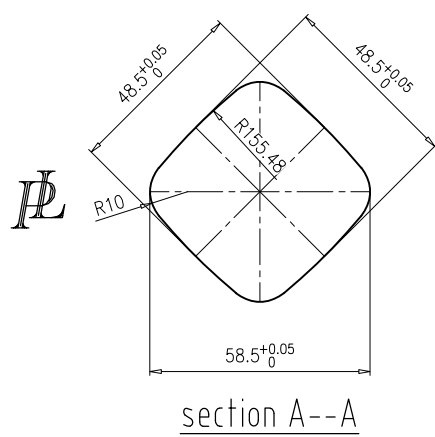
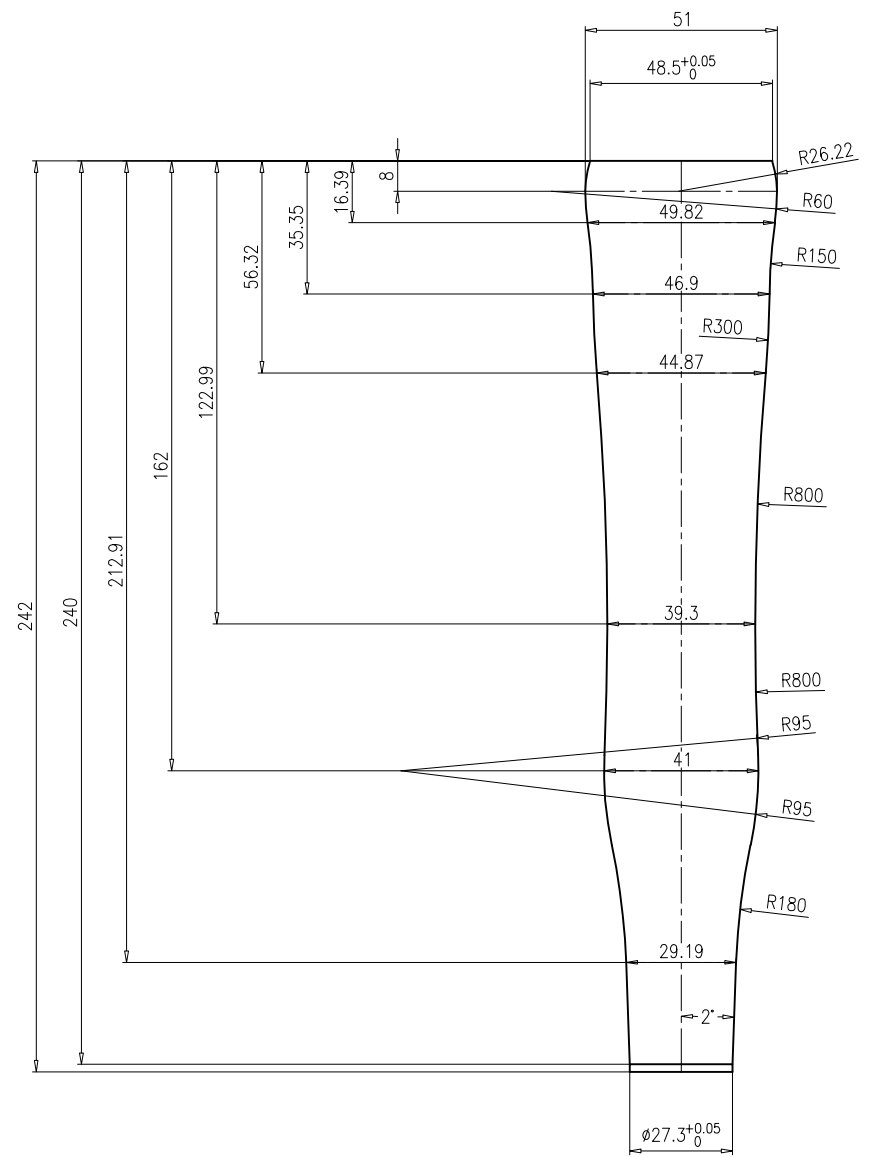
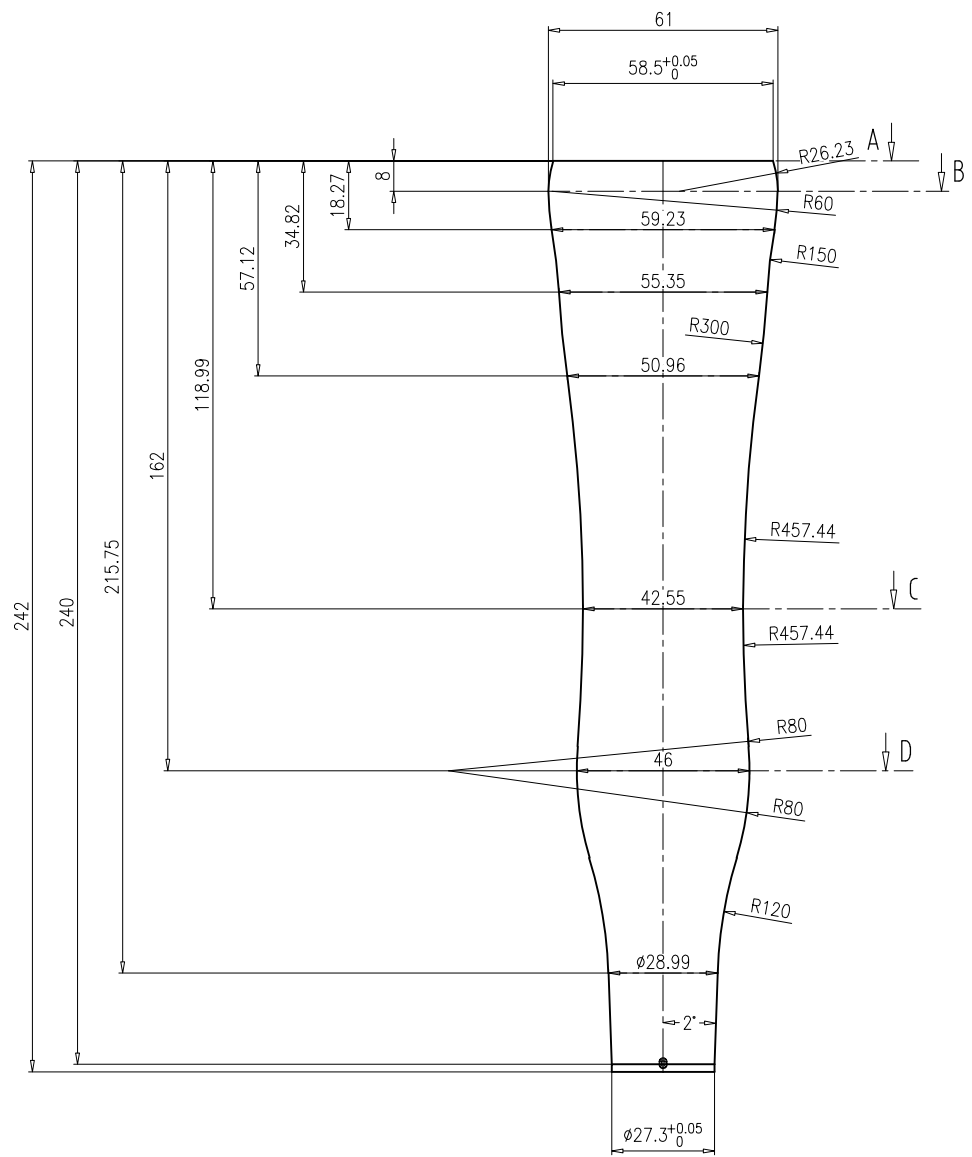
BOTTOM VIEW

slot must be half & half & 90° to pl  
mill slot tangential to this surface


All undimensioned chamfers 1x45° All undimensioned radii R1.0mm  
Free dimension tolerance 0.0: ±0.10 Free dimension tolerance 0.00: ±0.05  
Angle: ±0.5° Profile ±0.05

CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-BLK-3
DRN	DATE	17-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY

MATERIAL	CAST IRON + METAL	PART NAME	BLANK MOULD
MACHINE TYPE	IS 5" SG B&B	JOB NAME	1000ml Square Marasca
CUSTOMER			

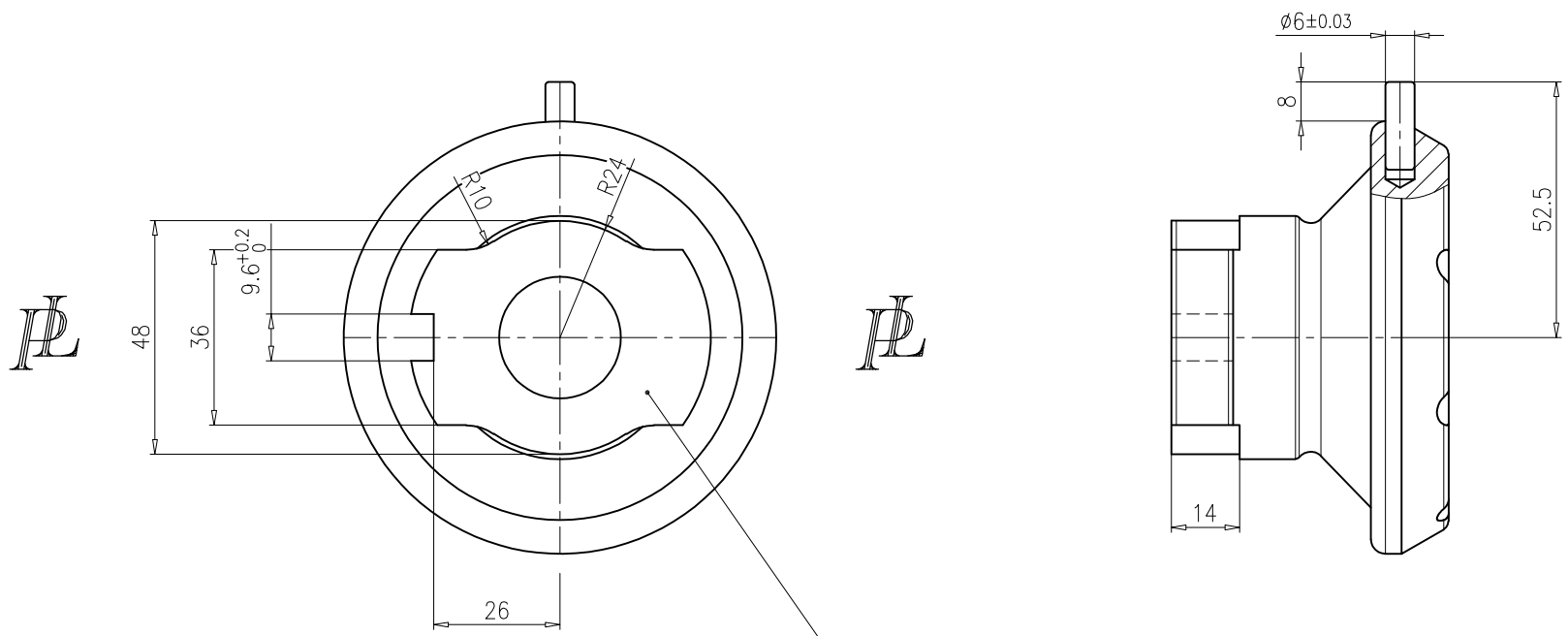


TOTAL = 350.2 ± 1.0 ml  
 BLANK = 344.3 ml    BAFFLE = 5.9 ml

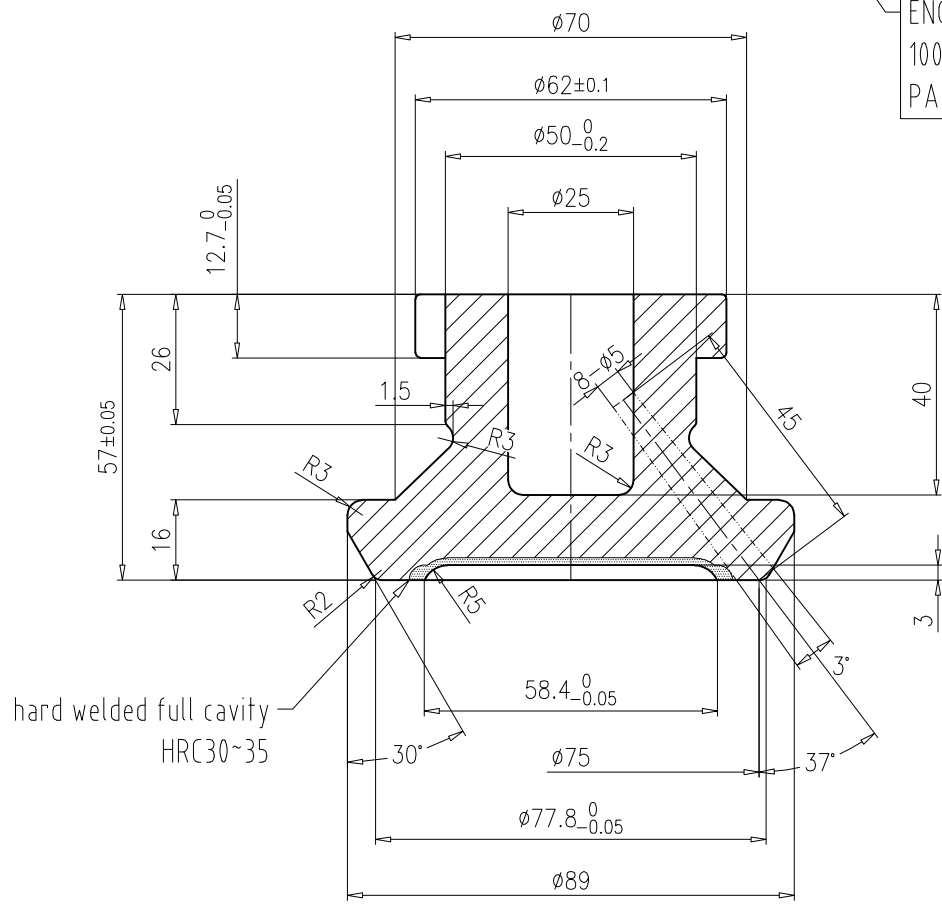
CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-BLC-1
DRN	DATE	17-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY
PART NAME	BLANK PROFILE		
JOB NAME	1000ml Square Marasca		
 Brother Glass Mould MFG Co.,Ltd			

MATERIAL	
MACHINE TYPE	IS 5" SG B&B
CUSTOMER	

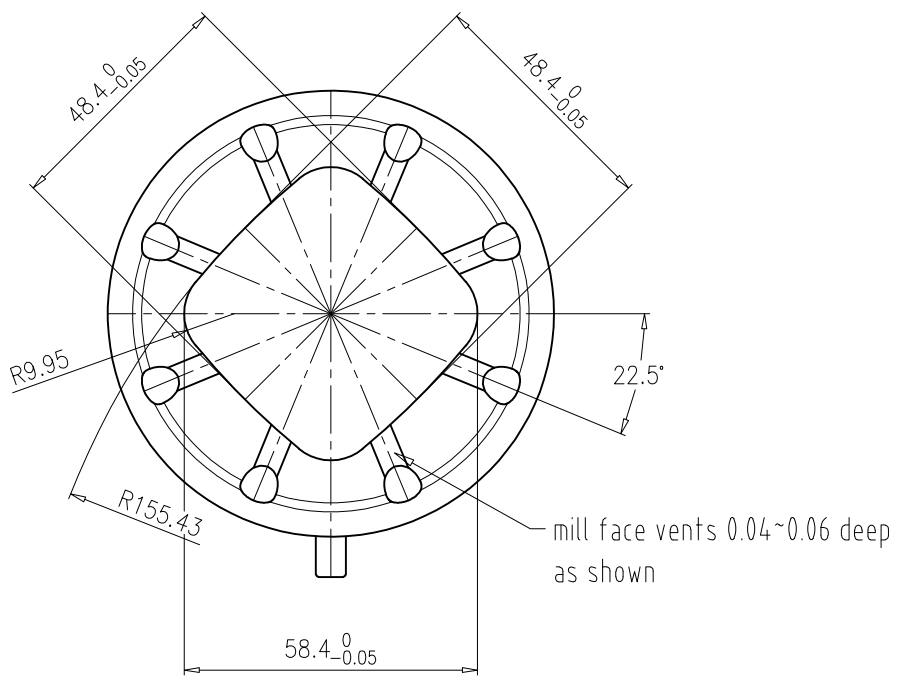
TOP VIEW



ENGRAVE  
 1000ml Square Marasca 2003228  
 PART NO. 1&UP MONTH/YEAR




hard welded full cavity  
 HRC30-35

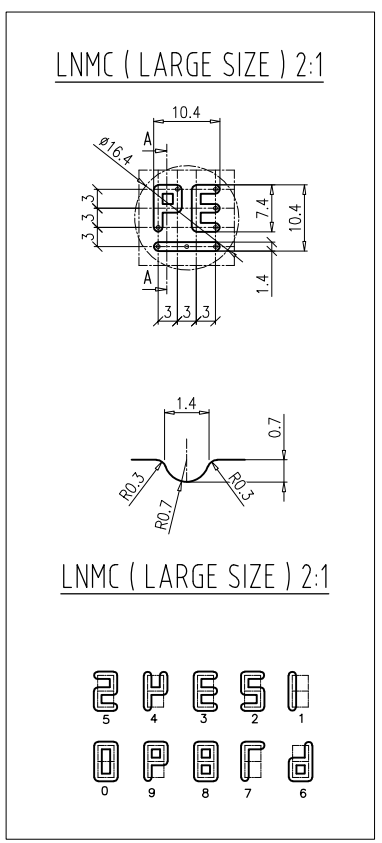
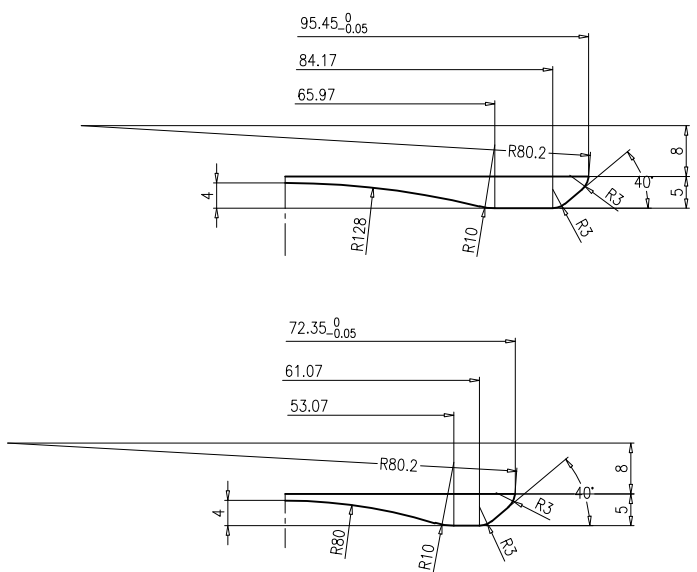
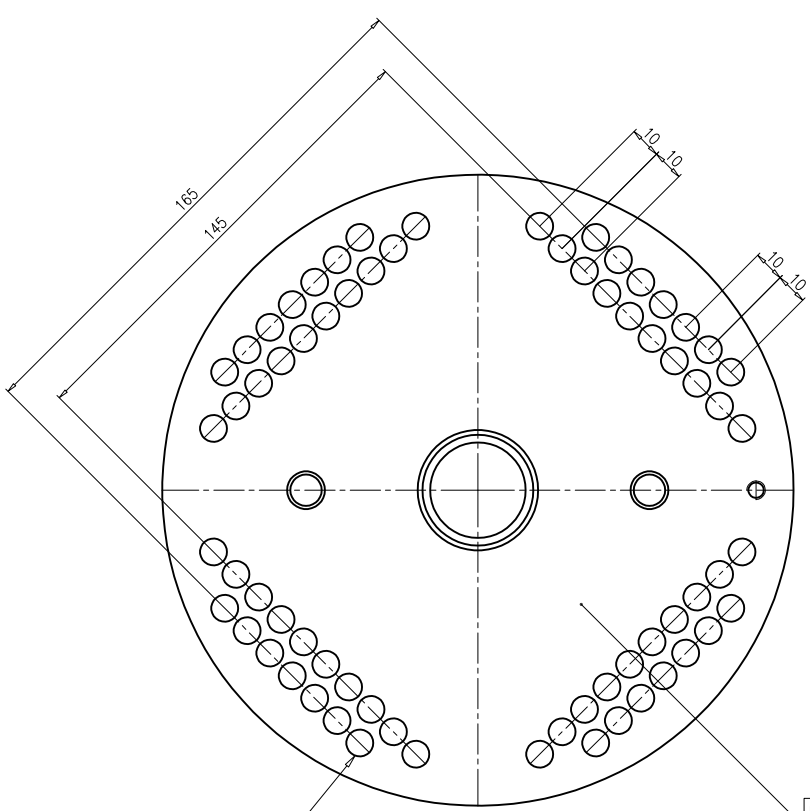
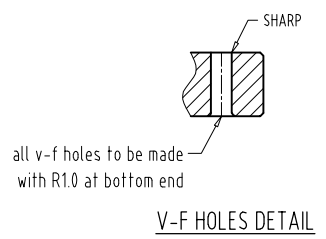
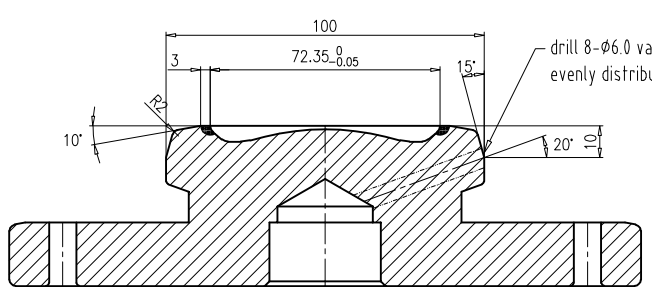
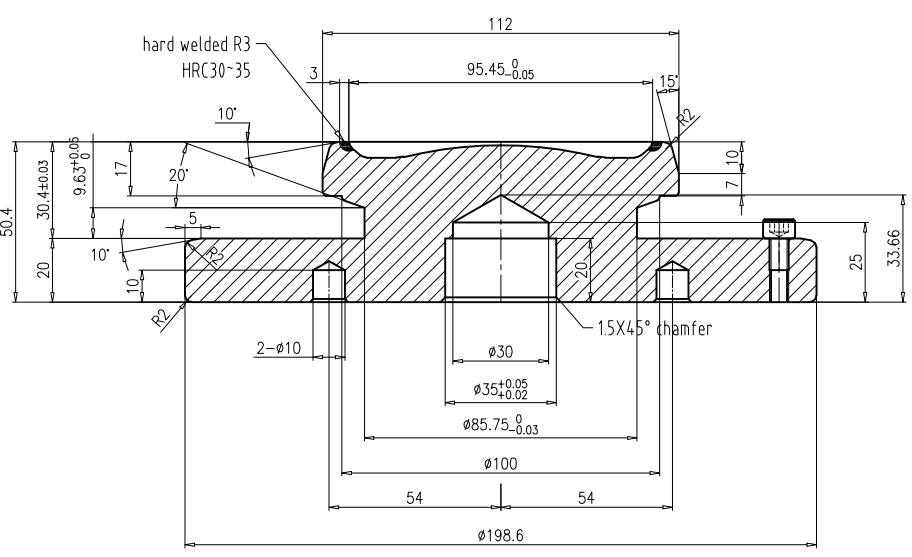
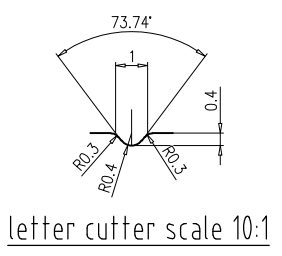
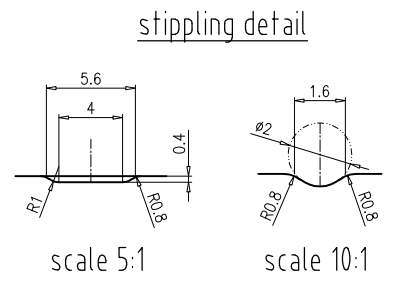
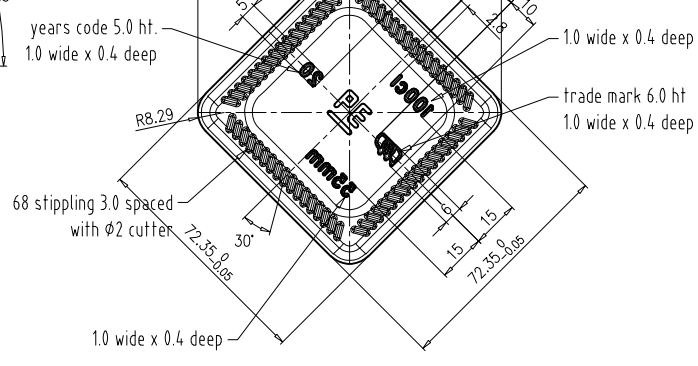
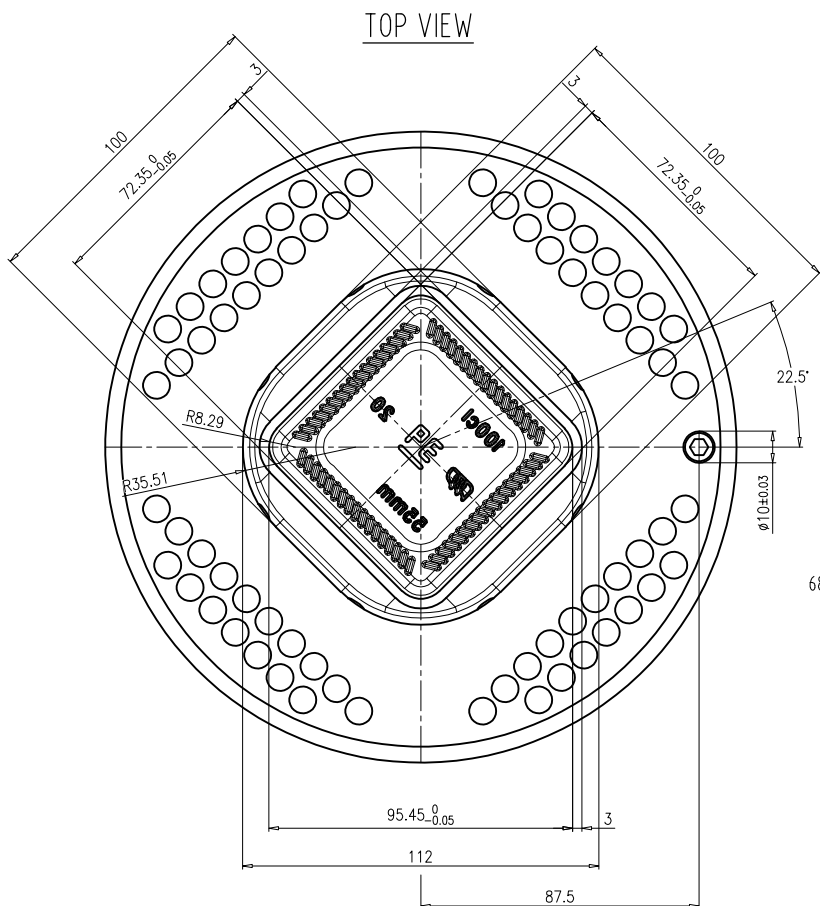


BOTTOM VIEW

CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-BF-2
DRN	DATE	17-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY

MATERIAL	CAST IRON + METAL FULL CAVITY
MACHINE TYPE	IS 5" SG B&B
CUSTOMER	

PART NAME	BAFFLE
JOB NAME	1000ml Square Marasca
 Brother Glass Mould MFG Co.,Ltd	



ENGRAVE  
1000ml Square Marasca 2003228  
PART NO. 1&UP MONTH/YEAR

CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-BP-1
DRN	DATE	04-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY

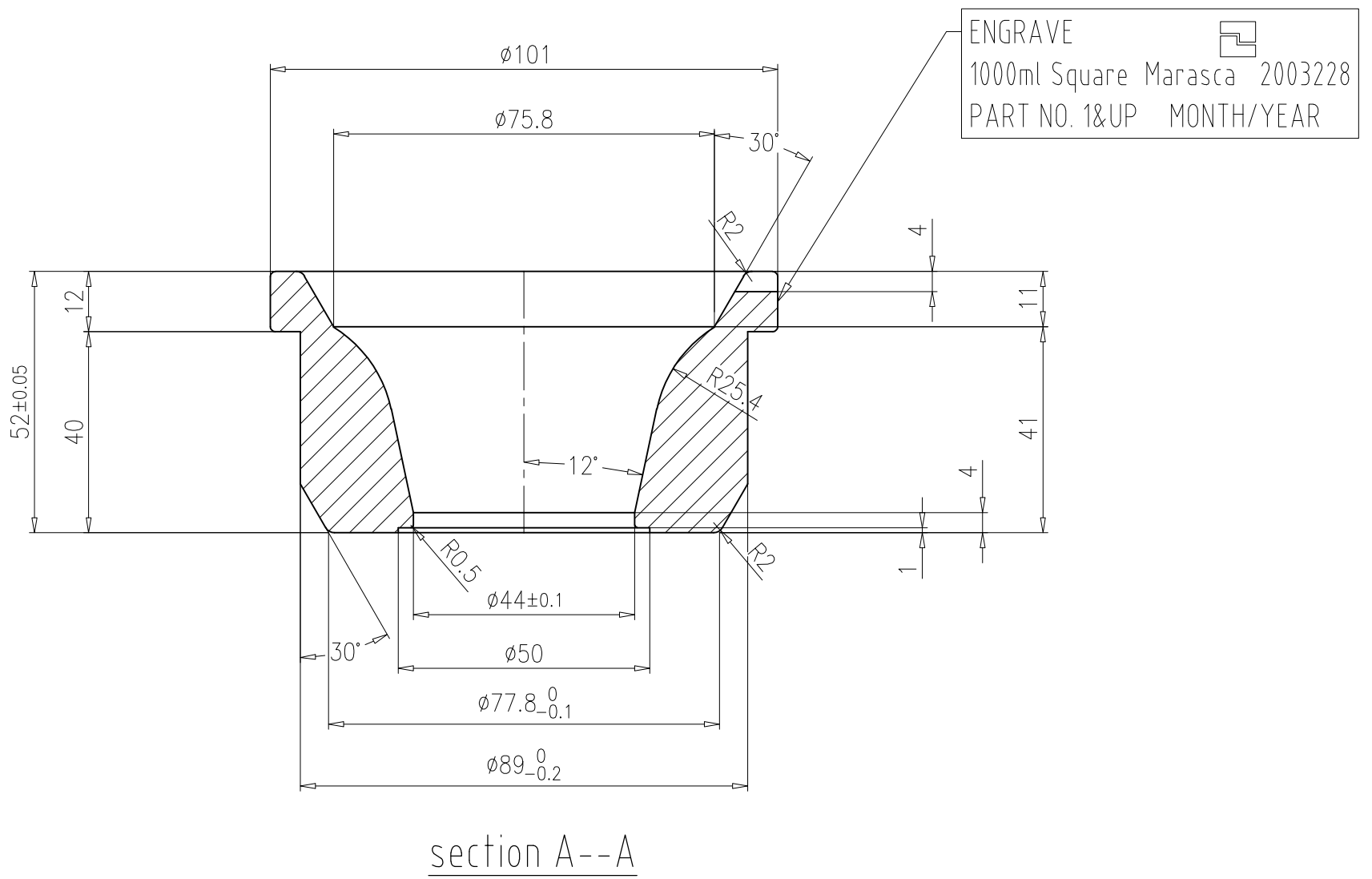
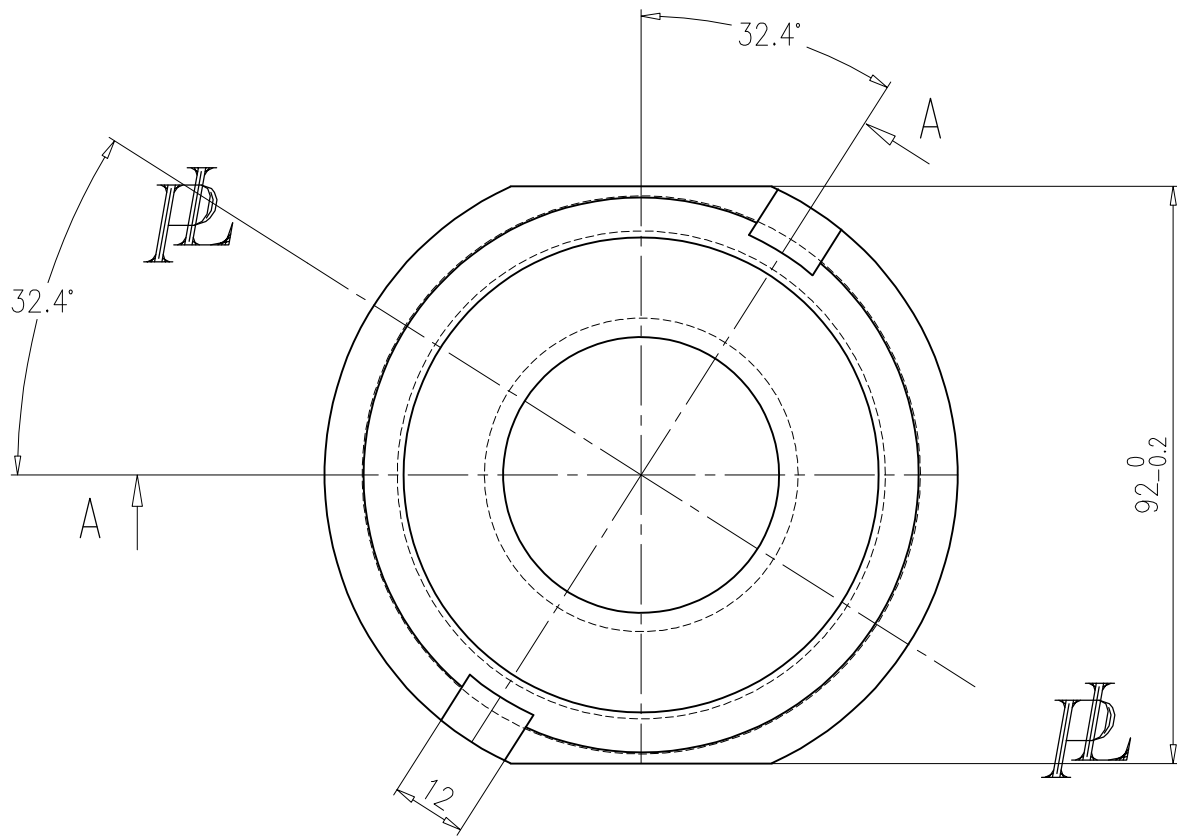
MATERIAL	CAST IRON + METAL	PART NAME	MOULD PROFILE
MACHINE TYPE	IS 5" SG B&B	JOB NAME	1000ml Square Marasca
CUSTOMER		Brother Glass Mould MFG Co.,Ltd	

All undimensioned chamfers 1x45°  
Free dimension tolerance 0.0: ±0.10  
Angle: ±0.5°

All undimensioned radii R1.0mm  
Free dimension tolerance 0.00: ±0.05  
Profile ±0.05




TOP VIEW



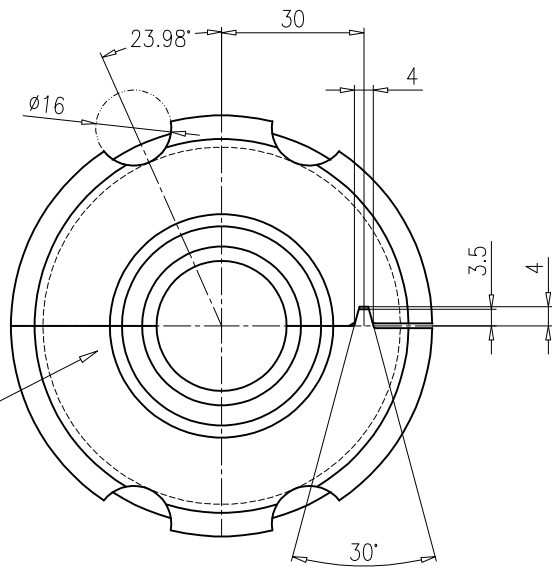
section A--A

CAPACITY <sup>(OF)</sup>	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-FN-1
DRN	DATE	02-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY

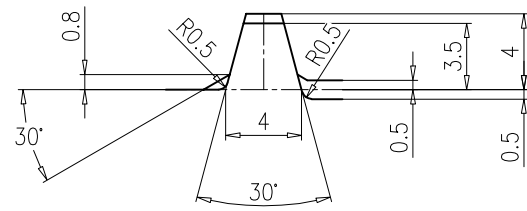
MATERIAL	STEEL
MACHINE TYPE	IS 5" SG B&B
CUSTOMER	

PART NAME	FUNNELS
JOB NAME	1000ml Square Marasca
 Brother Glass Mould MFG Co.,Ltd <small>BROTHER</small>	

TOP VIEW

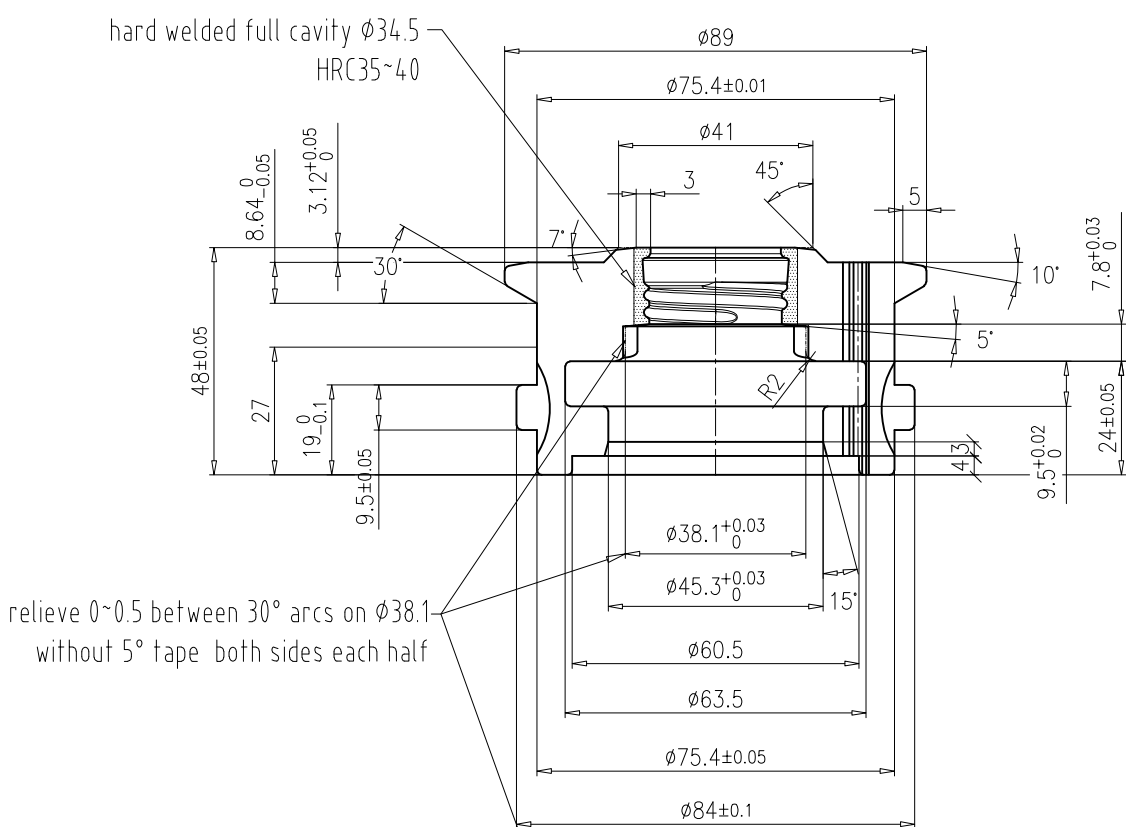


each half engrave  
1000ml Square Marasca 2003228  
part no. 1&up month/year(one half)



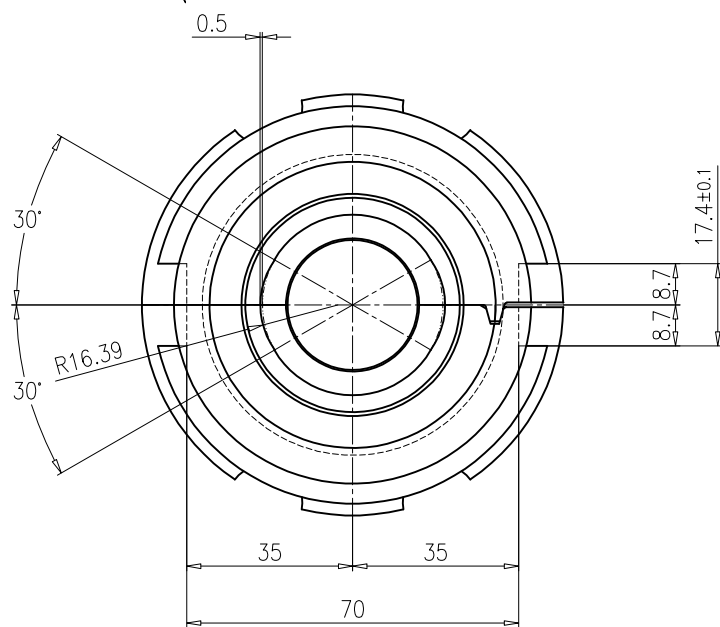
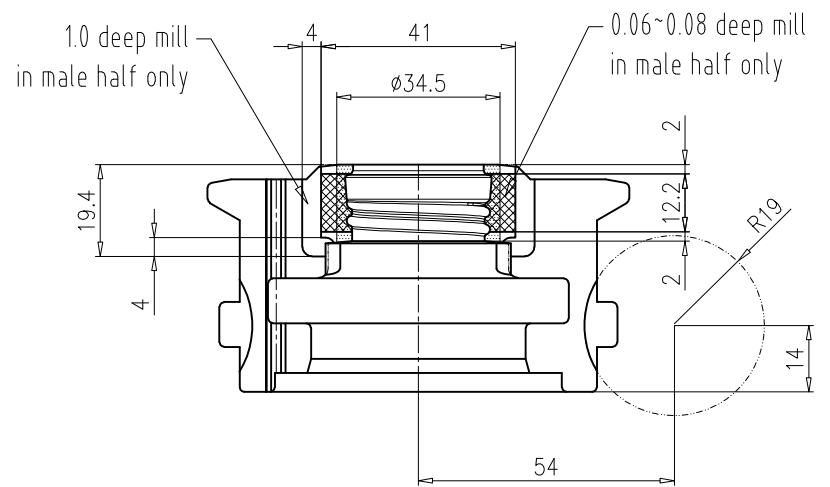
tongue and groove scale 4:1

FEMALE HALF



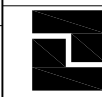
relieve 0~0.5 between 30° arcs on  $\phi 38.1$   
without 5° tape both sides each half

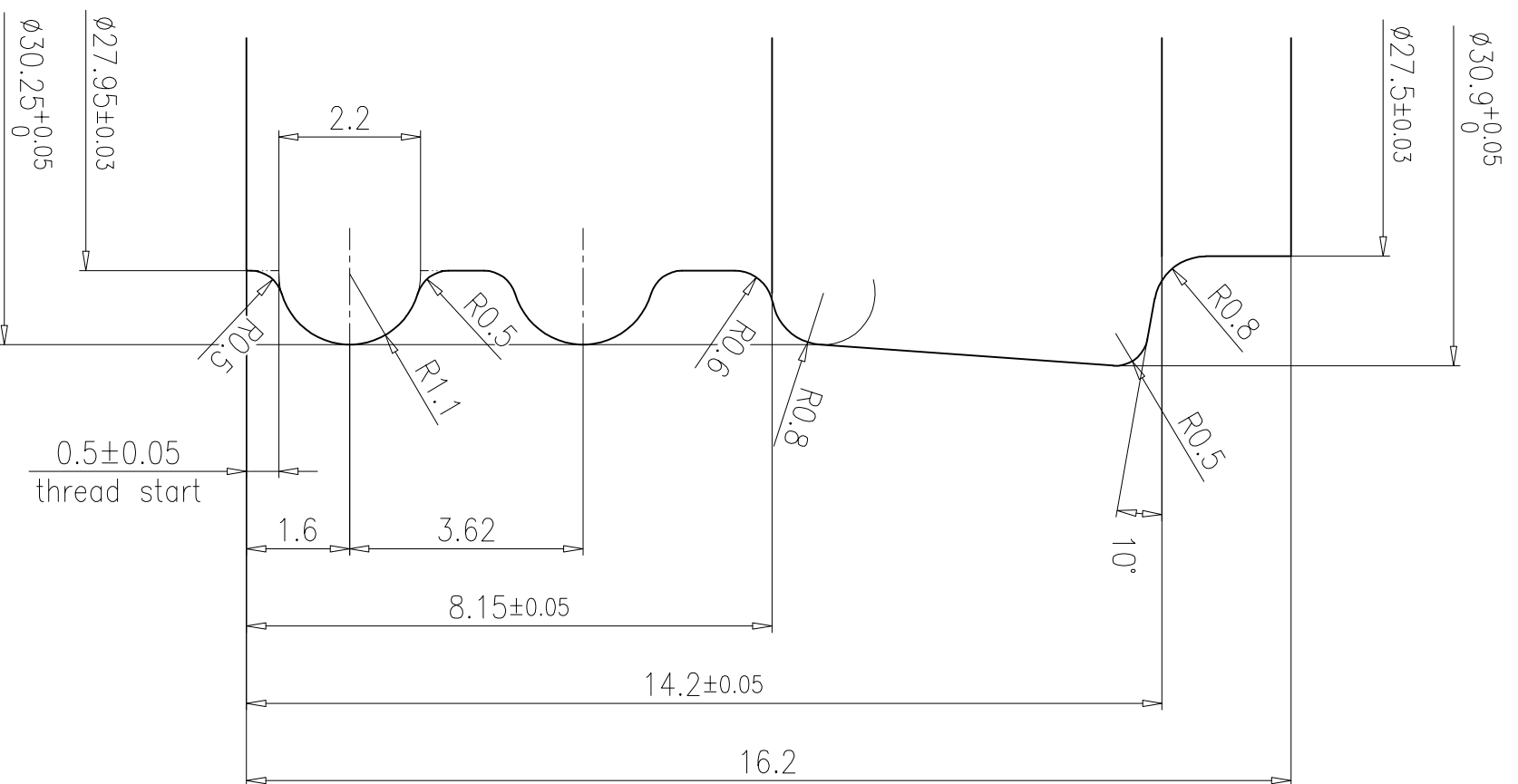
MALE HALF



BOTTOM VIEW

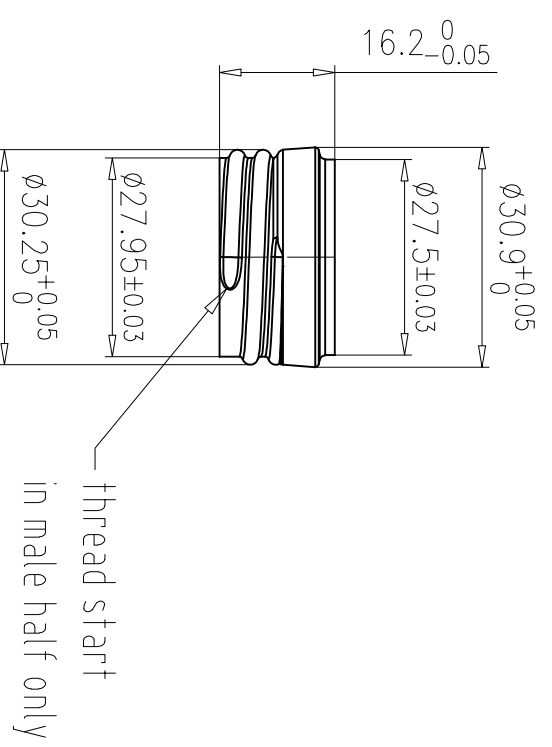
All undimensioned chamfers 1x45° All undimensioned radii R1.0mm  
Free dimension tolerance 0.0: ±0.10 Free dimension tolerance 0.00: ±0.05  
Angle: ±0.5° Profile ±0.05

CAPACITY <sup>(OF)</sup>	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-NR-1
DRN	DATE	04-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY
MATERIAL	CAST IRON + METAL	PART NAME	NECK RING
MACHINE TYPE	IS 5" SG B&B	JOB NAME	1000ml Square Marasca
CUSTOMER		 Brother Glass Mould MFG Co.,Ltd	

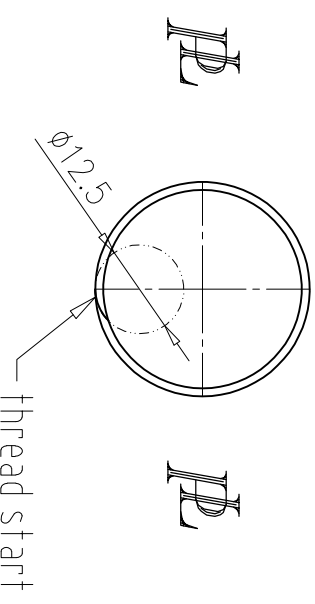
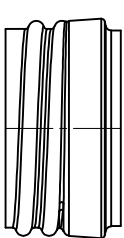


thread start scale 10:1

FEMALE HALF



MALE HALF



bottom view

thread to start @ 90° to parting line  
 thread to run into backing.  
 last 1/4 trun of thread that runs into backing  
 is to be reduced so that it is 0.20 smaller than  
 thread dia. by gradually "pulling in" cutter

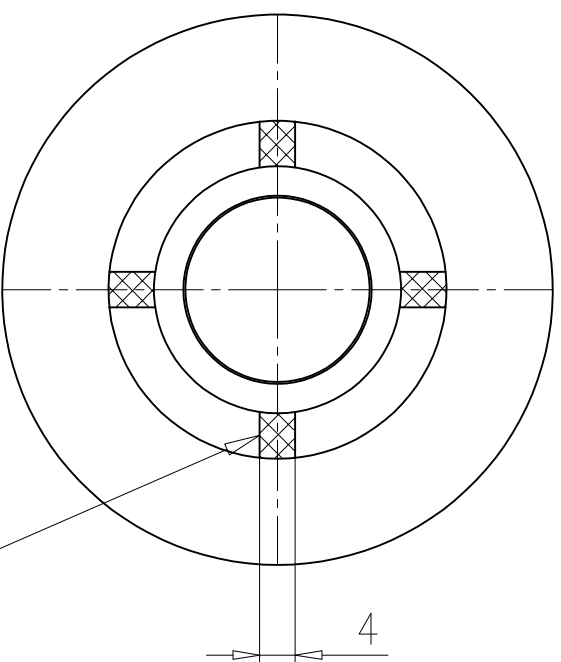
DIN 6094 PP31.5STD  
 pitch = 3.62mm  
 cutter dia = 12.5mm  
 helix angle = 2°16'  
 cutter angle = 2°16'

MATERIAL	
MACHINE TYPE	IS 5" SG B&B
CUSTOMER	

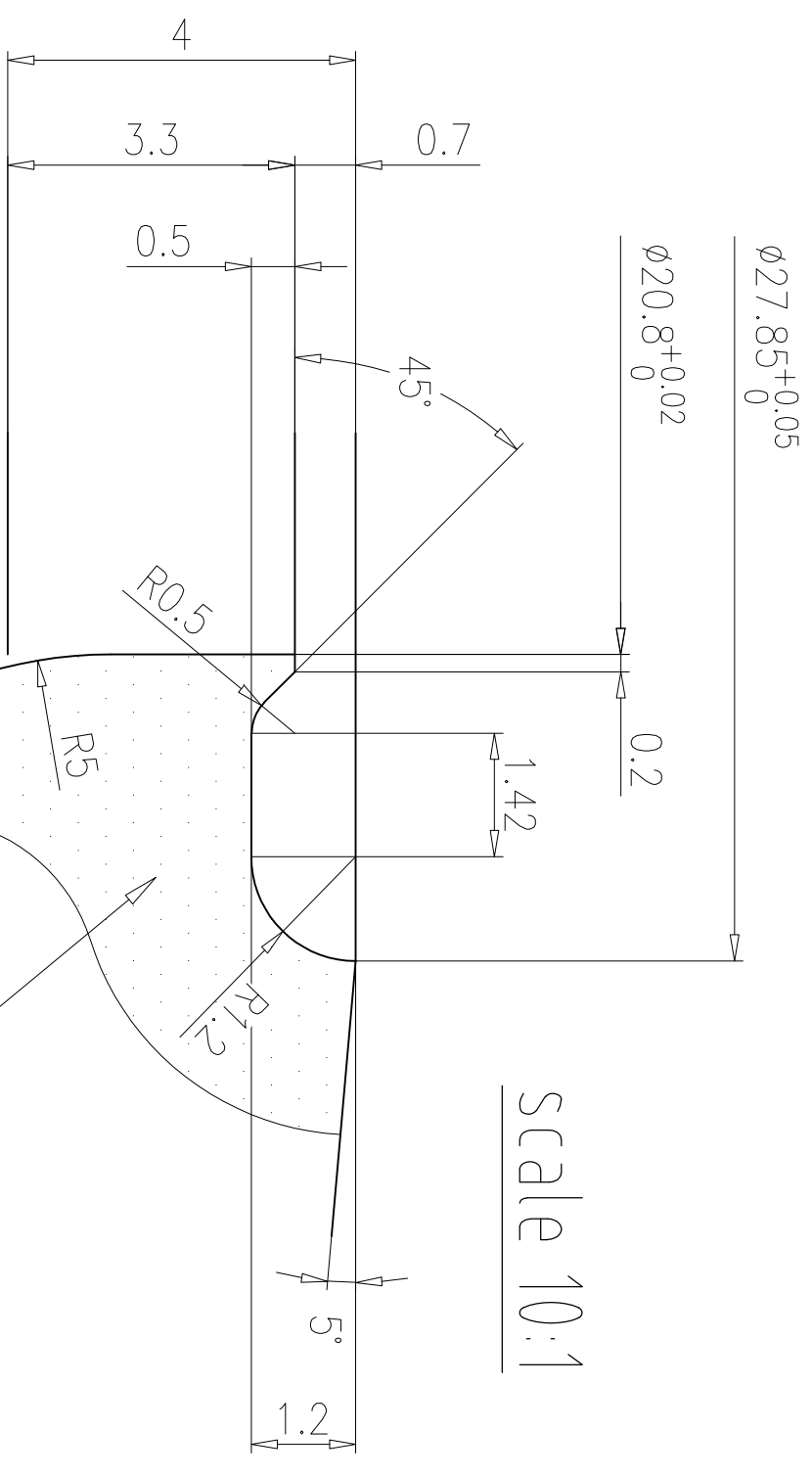
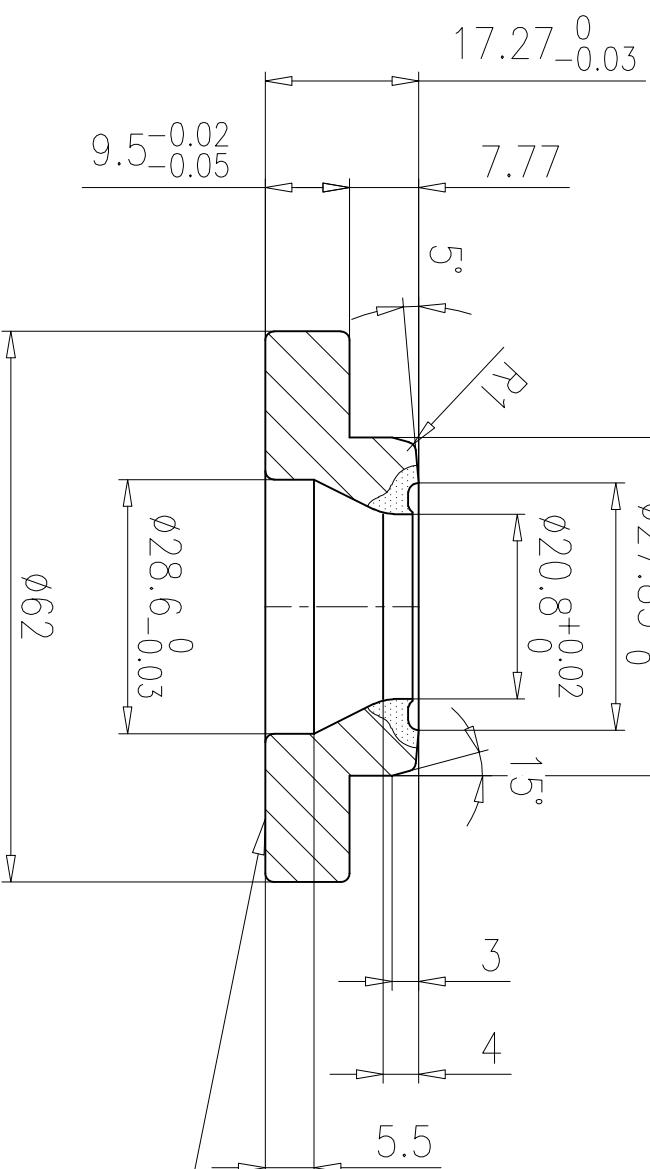
CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG. NO	2003228-NRC-1
DRN	DATE	04-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY
PART NAME	NECK PROFILE		
JOB NAME	1000ml Square Marasca		



# TOP VIEW



mill 4 slots 0.05 deep



Scale 10:1

hard welded 1.5 deep  
HRC30~35

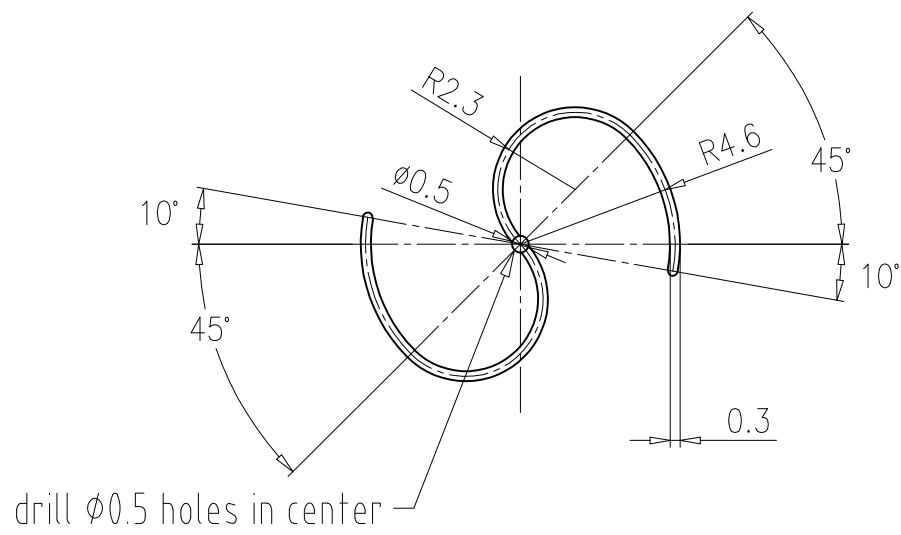
engrave  
1000ml Square Marasca 2003228  
part no. 18up month/year

All undimensioned chamfers 1x45°  
Free dimension tolerance 0.0: ±0.10  
Angle: ±0.5°  
All undimensioned radii R1.0mm  
Free dimension tolerance 0.00: ±0.05  
Profile ±0.05

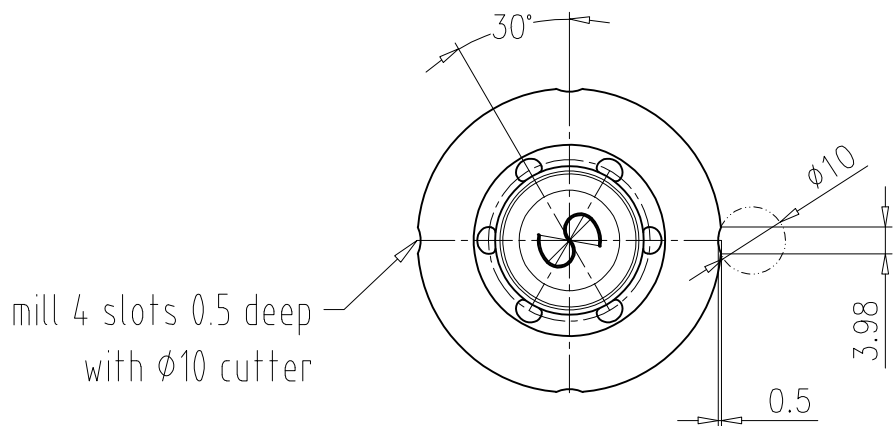
MATERIAL	CAST IRON + METAL
MACHINE TYPE	IS 5" SG B&B
CUSTOMER	

CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-GP-1
DRN	DATE	04-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY
PART NAME	GUIDE RING PLATE		
JOB NAME	1000ml Square Marasca		

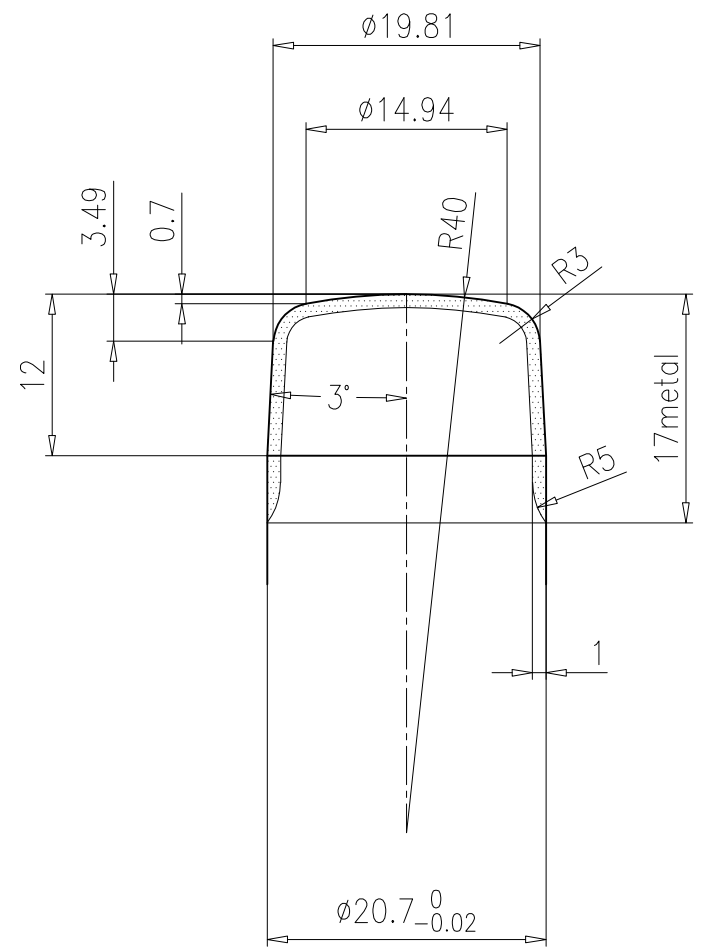
wire cut profile scale 5:1



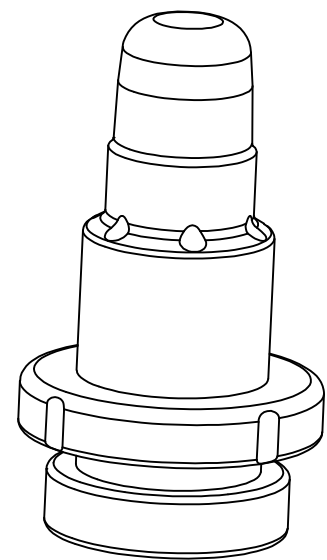
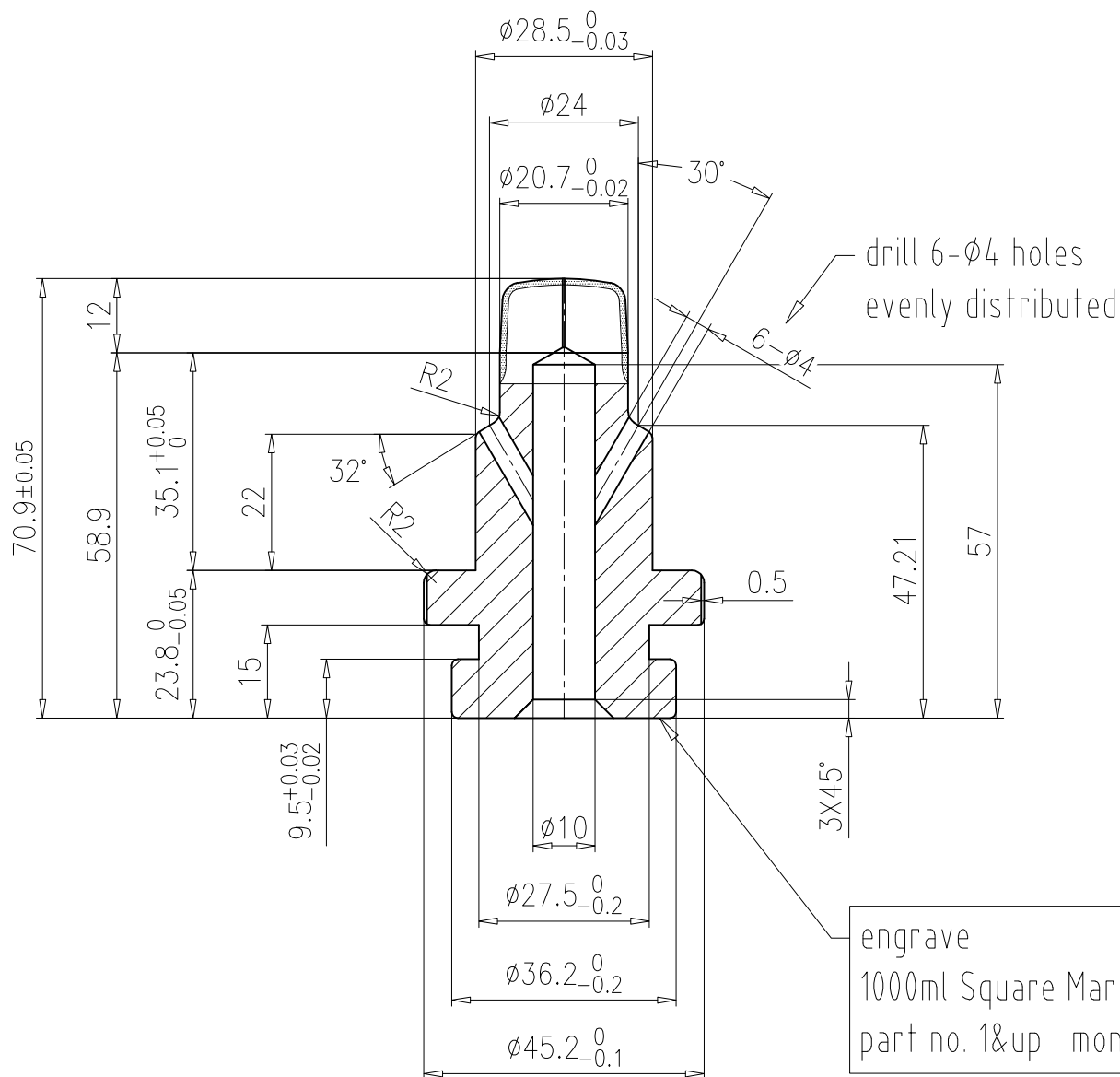
TOP VIEW



hard welded plunger tip 1.0 mm deep



scale 2:1

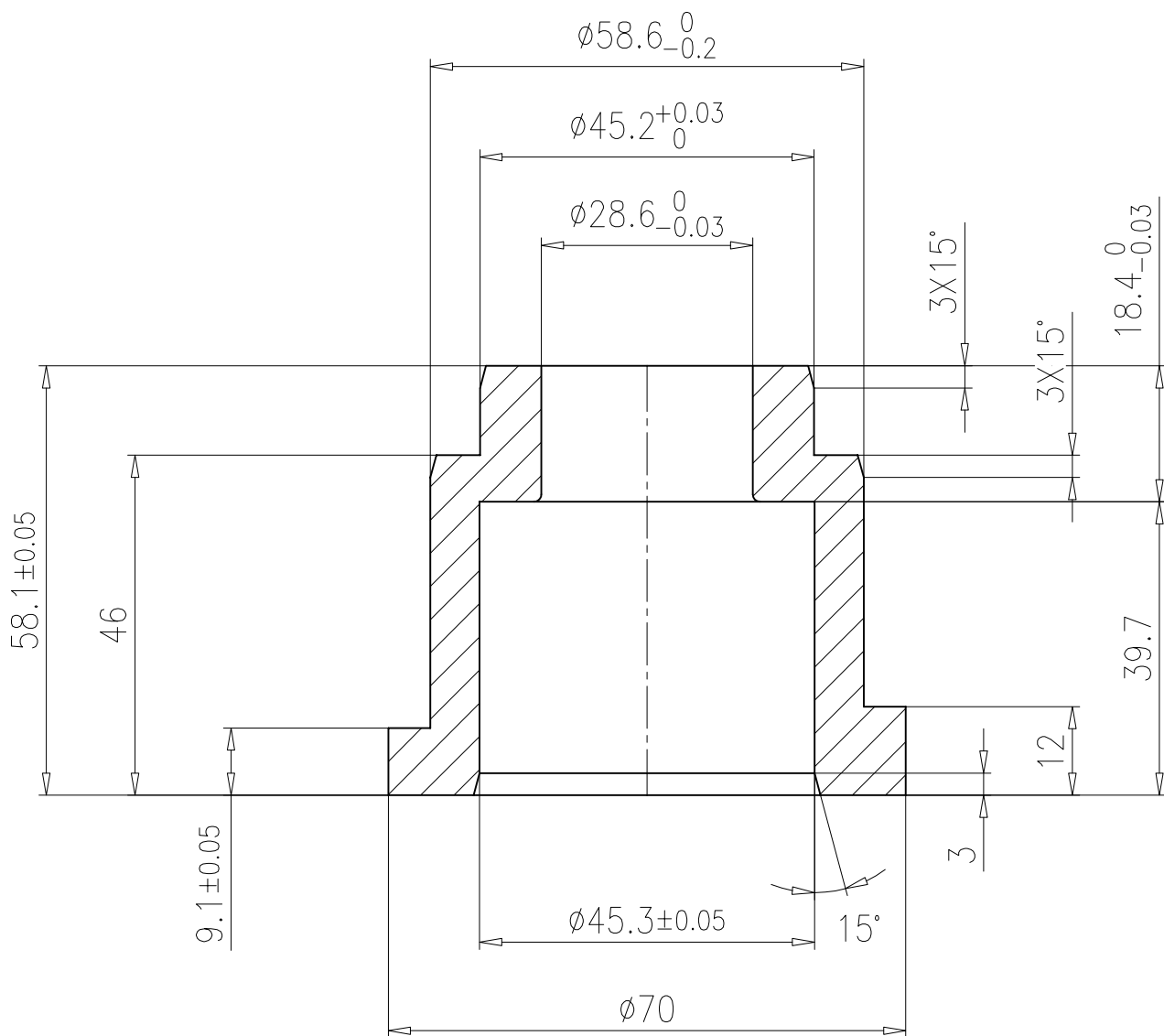
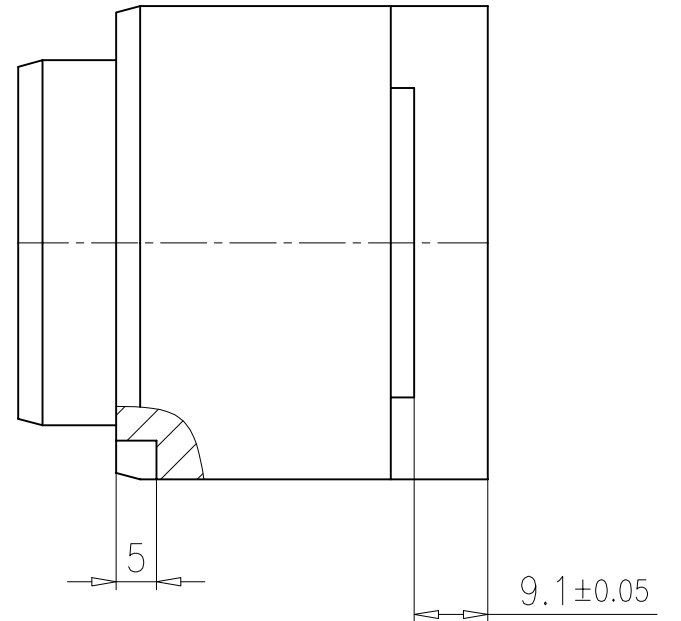
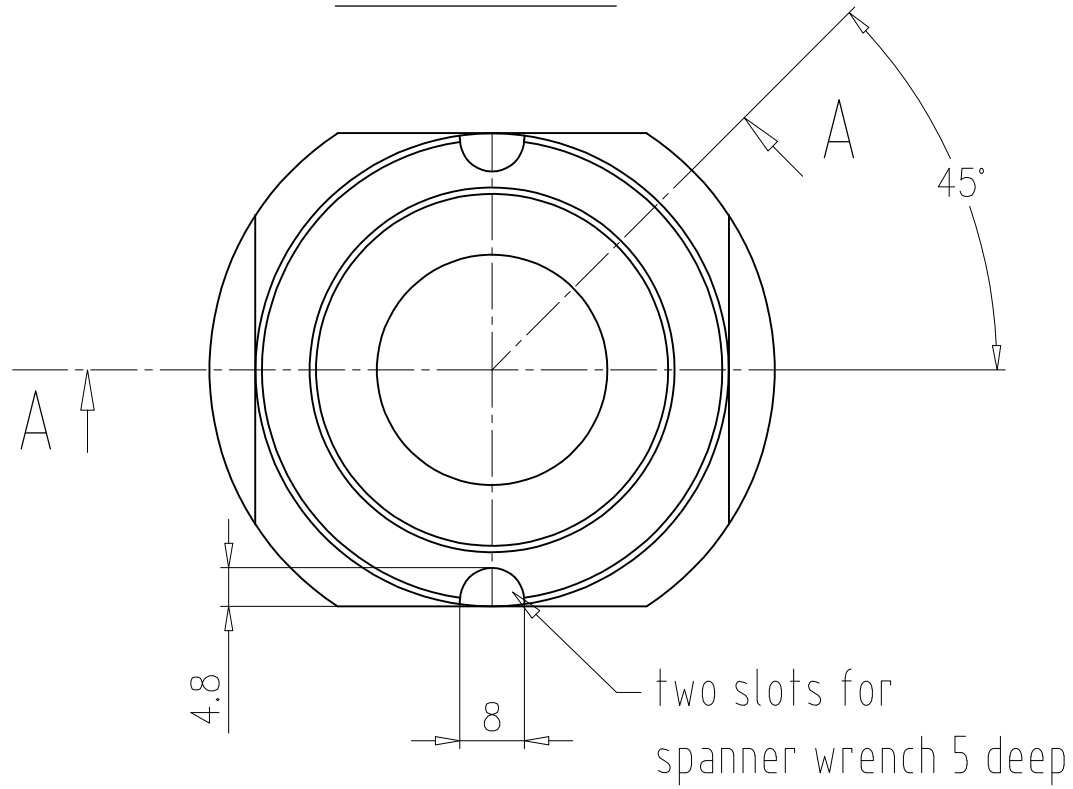


All undimensioned chamfers 1x45° All undimensioned radii R1.0mm  
 Free dimension tolerance 0.0: ±0.10 Free dimension tolerance 0.00: ±0.05  
 Angle: ±0.5° Profile ±0.05

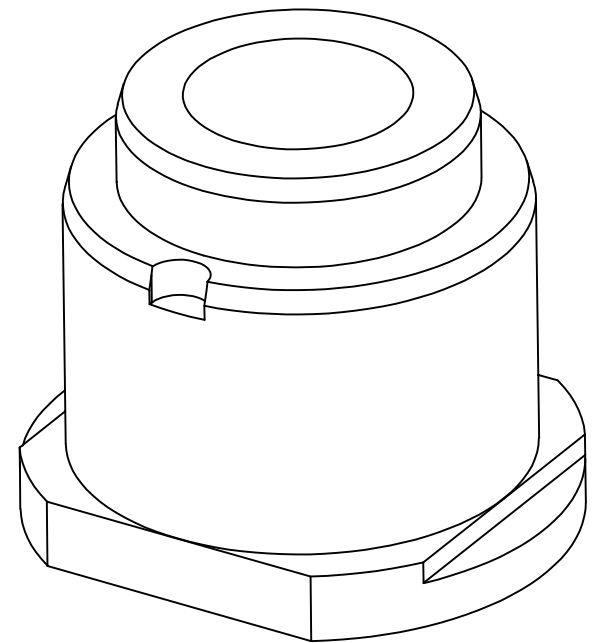
MATERIAL	STEEL + METAL	PART NAME	PLUNGER
MACHINE TYPE	IS 5" SG B&B	JOB NAME	1000ml Square Marasca
CUSTOMER		Brother Glass Mould MFG Co.,Ltd	

CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-PL-1
DRN	DATE	04-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY

TOP VIEW




section A--A

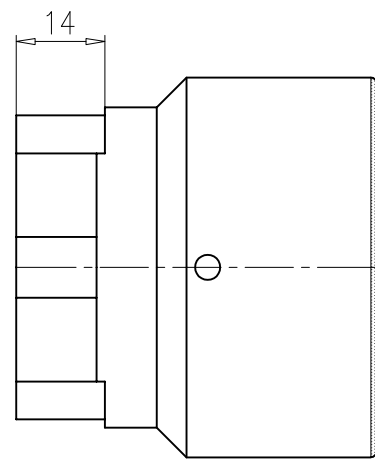
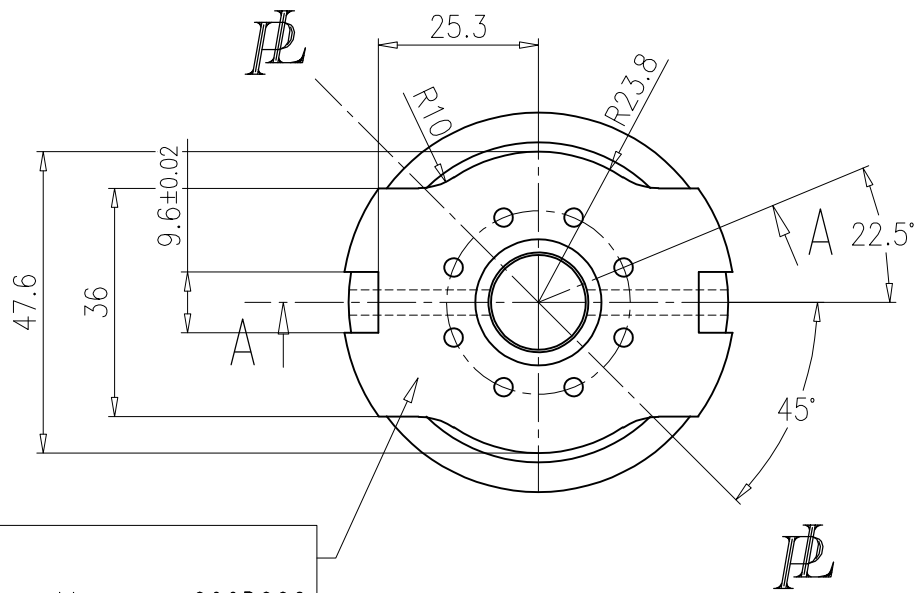


All undimensioned chamfers 1x45°      All undimensioned radii R1.0mm  
 Free dimension tolerance 0.0: ±0.10      Free dimension tolerance 0.00: ±0.05  
 Angle: ±0.5°      Profile ±0.05

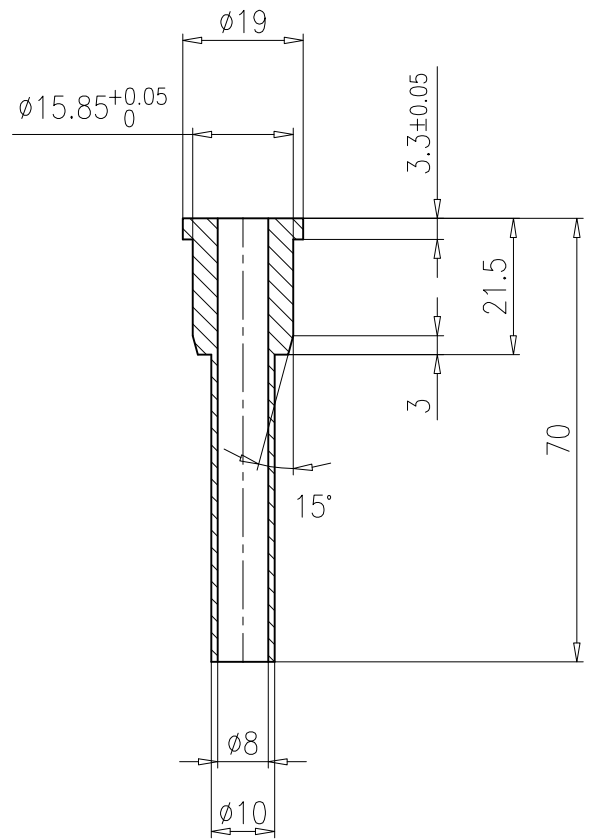
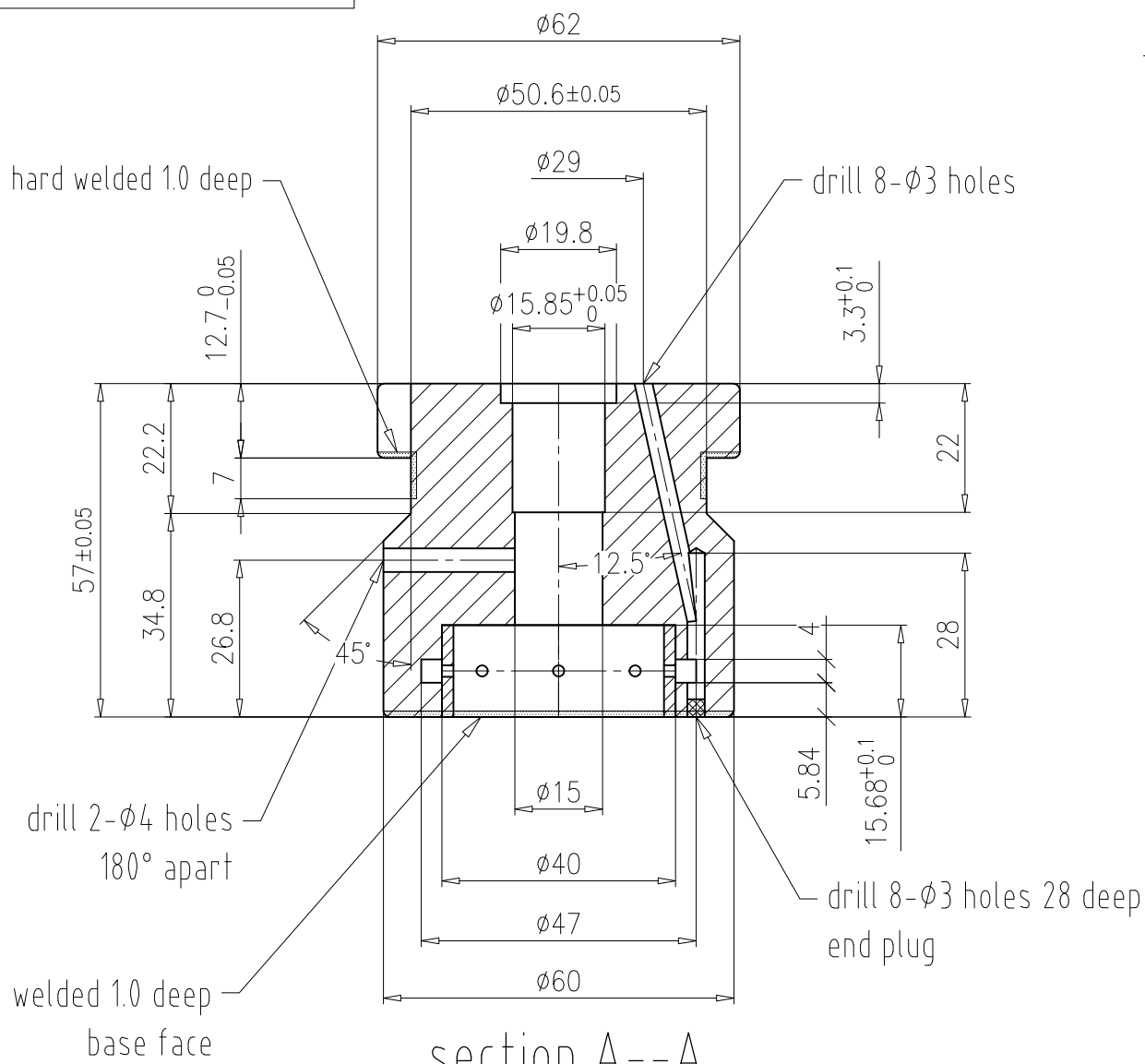
MATERIAL	STEEL
MACHINE TYPE	IS 5" SG B&B
CUSTOMER	

CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-TH-0
DRN	DATE	08-04-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY
PART NAME	THIMBLE		
JOB NAME	1000ml Square Marasca		
 Brother Glass Mould MFG Co.,Ltd			

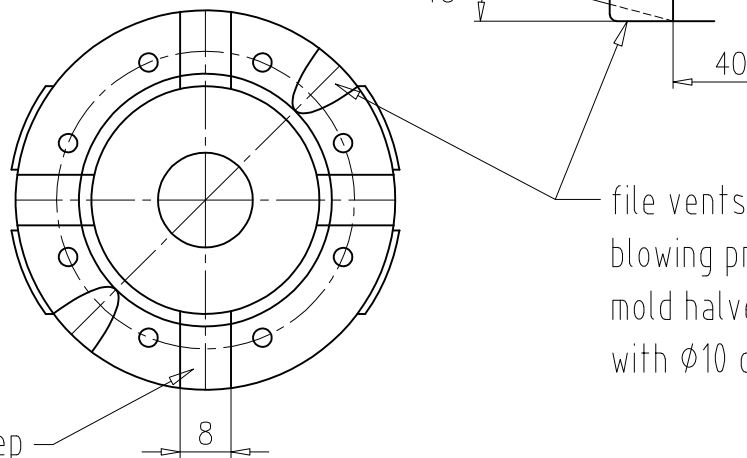
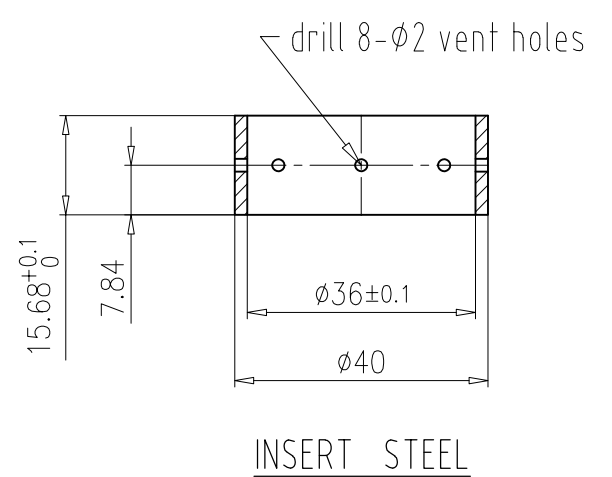
top view



engrave  
1000ml Square Marasca 2003228  
part no. 1&up month/year



tube steel



bottom view

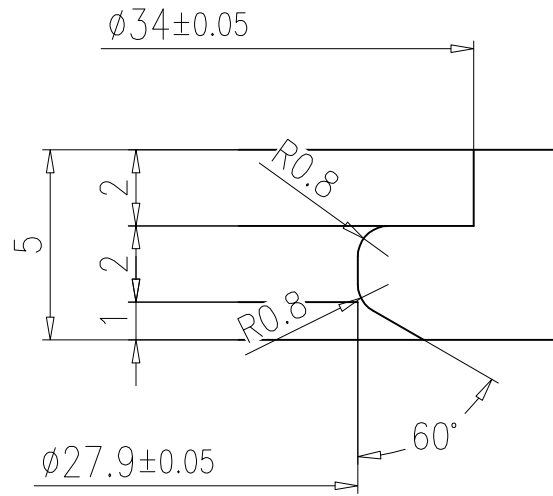
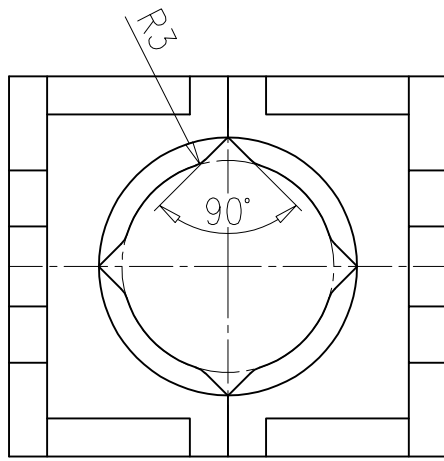
file vents as shown to relieve blowing pressure between mold halves over shoulder of bottle with φ10 cutter

All undimensioned chamfers 1x45°  
Free dimension tolerance 0.0: ±0.10  
Angle: ±0.5°  
All undimensioned radii R1.0mm  
Free dimension tolerance 0.00: ±0.05  
Profile ±0.05

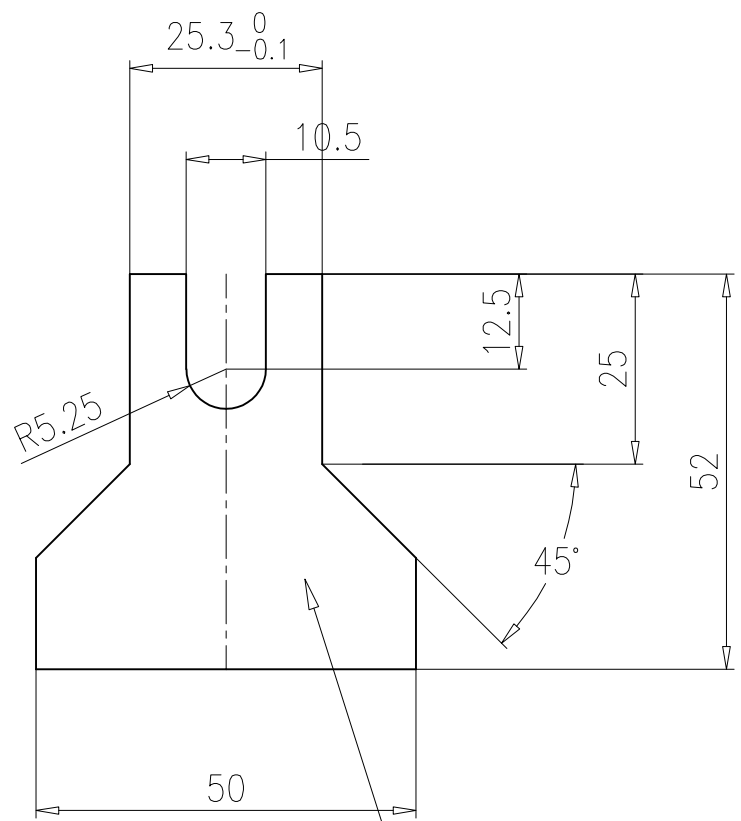
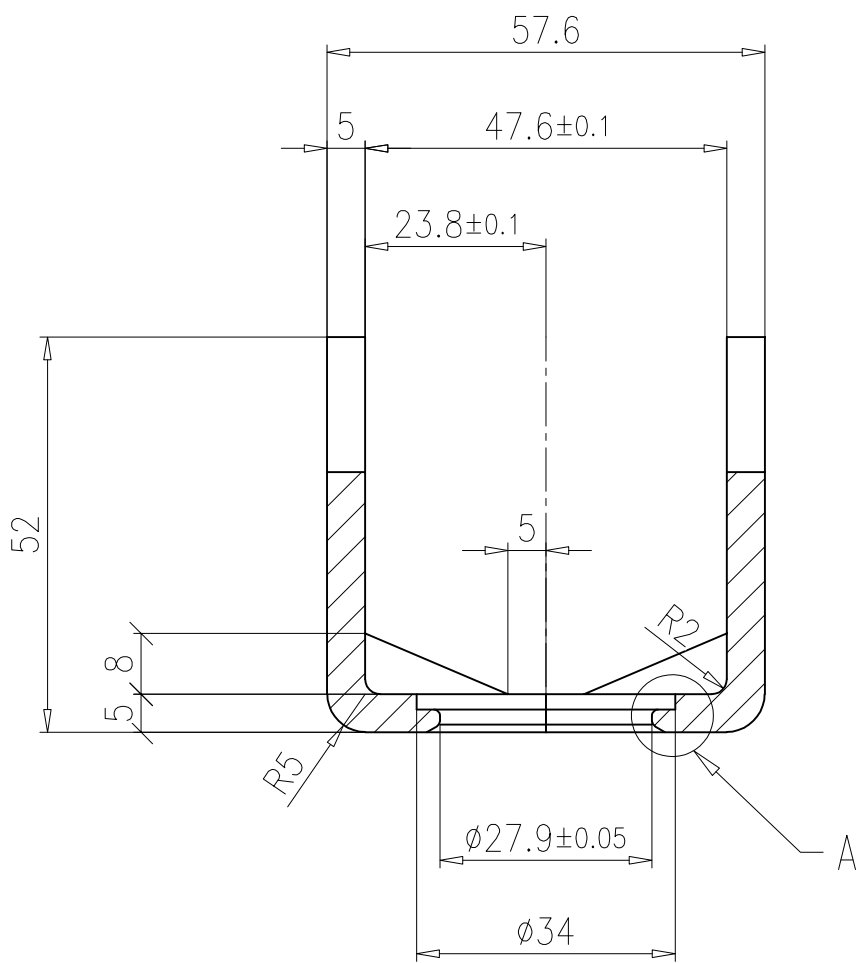
MATERIAL	STEEL + METAL	PART NAME	BLOW HEARD
MACHINE TYPE	IS 5" SG B&B	JOB NAME	1000ml Square Marasca
CUSTOMER		Brother Glass Mould MFG Co.,Ltd	

CAPACITY (OF)	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-BH-1
DRN	DATE	04-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY

# TOP VIEW




# A DETAIL M5:1



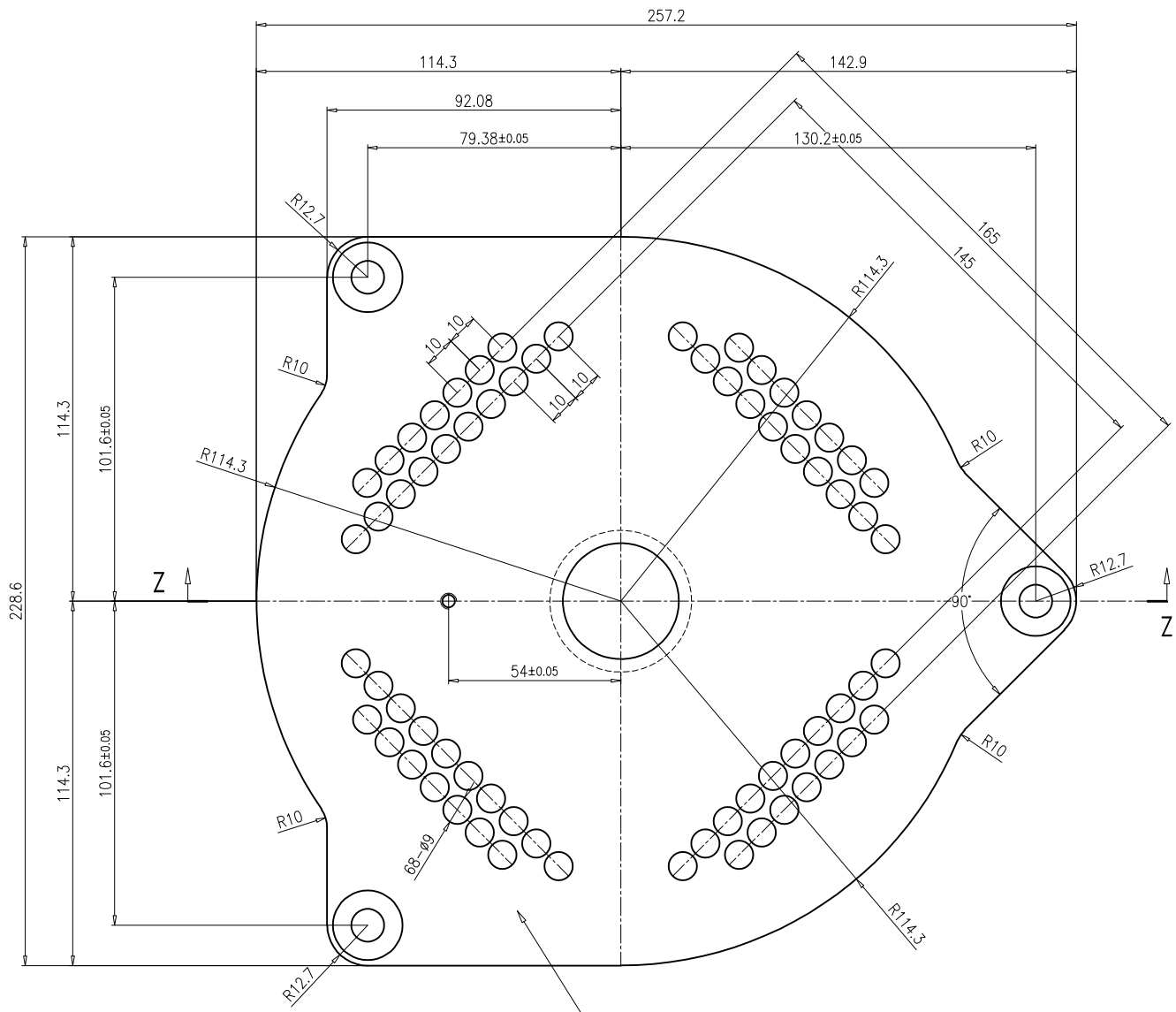
engrave  
1000ml Square Marasca 2003228  
part no. 1&up month/year

All undimensioned chamfers 1x45°  
All undimensioned radii R1.0mm  
Free dimension tolerance 0.0: ±0.10  
Free dimension tolerance 0.00: ±0.05  
Angle: ±0.5°  
Profile ±0.05

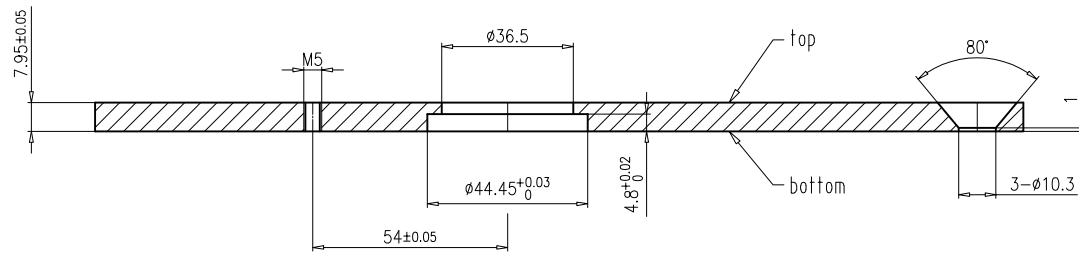
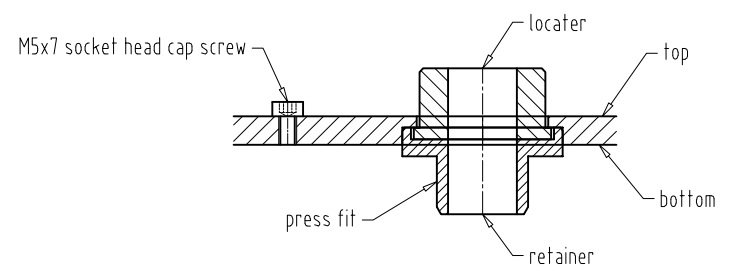
MATERIAL	BRONZE
MACHINE TYPE	IS 5" SG B&B
CUSTOMER	

CAPACITY <sup>(OF)</sup>	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-TT-0
DRN	DATE	08-04-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY
PART NAME	TAKEOUT TONG		
JOB NAME	1000ml Square Marasca		
 Brother Glass Mould MFG Co.,Ltd BROTHER			

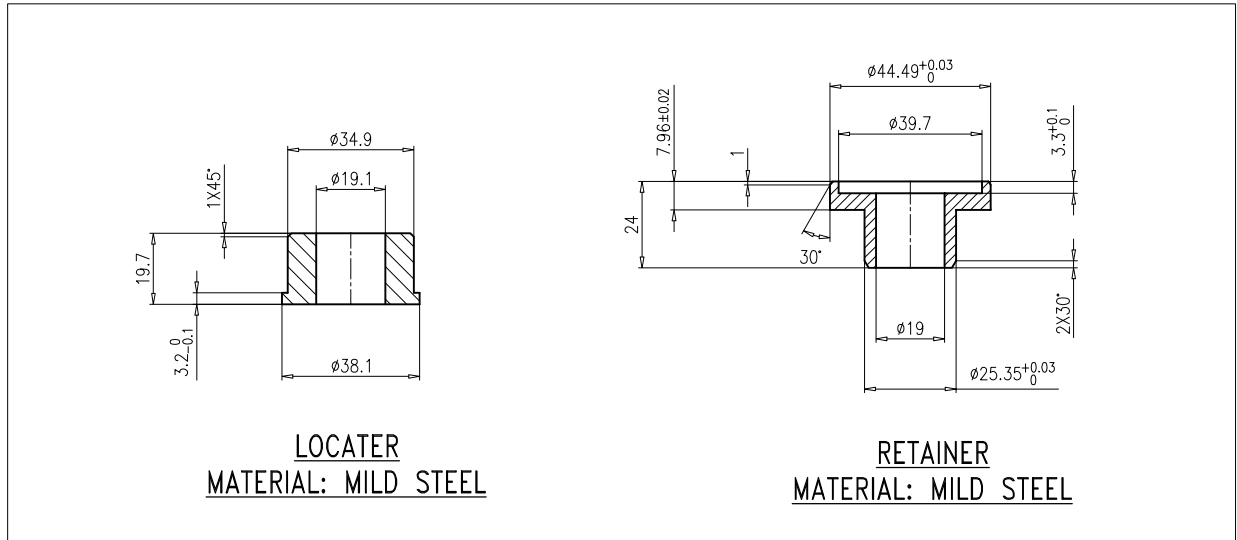




engrave  
 1000ml Square Marasca 2003228  
 part no. 1&up month/year

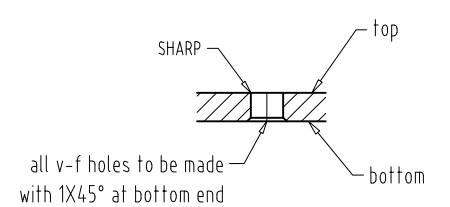


SECTION Z--Z



LOCATER  
 MATERIAL: MILD STEEL

RETAINER  
 MATERIAL: MILD STEEL




all v-f holes to be made  
 with 1x45° at bottom end

V-F HOLES DETAIL

All undimensioned chamfers 1x45° All undimensioned radii R1.0mm  
 Free dimension tolerance 0.0: ±0.10 Free dimension tolerance 0.00: ±0.05  
 Angle: ±0.5° Profile ±0.05

MATERIAL	St 52-3
MACHINE TYPE	IS 5" SG
CUSTOMER	

CAPACITY <sup>(OF)</sup>	ml	WEIGHT	g
SCALE	1:1	DWG.NO	2003228-DIP-1
DRN	DATE	04-05-2020	D-M-Y /BY L.T.
REVISION	DATE		D-M-Y /BY
APPROVE	DATE		D-M-Y /BY
PART NAME	DISTRIBUTOR PLATE		
JOB NAME	1000ml Square Marasca		
 Brother Glass Mould MFG Co.,Ltd			