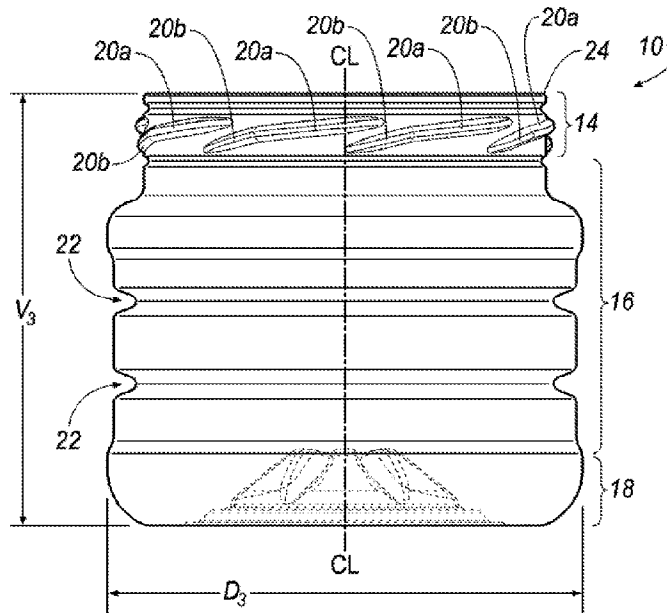




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(54) Titre : RECIPIENT EN PLASTIQUE DOTE D'UNE FINITION DE COL FILETE  
 (54) Title: PLASTIC CONTAINER WITH THREADED NECK FINISH



(57) Abrégé/Abstract:

A plastic container includes a neck portion, a sidewall portion, and a base portion. The neck portion includes a plurality of threads, which may be configured to retain and/or secure a cap or lid. In embodiments, the threads may be blown and/or the neck portion may include a neck rib provided vertically above the threads.

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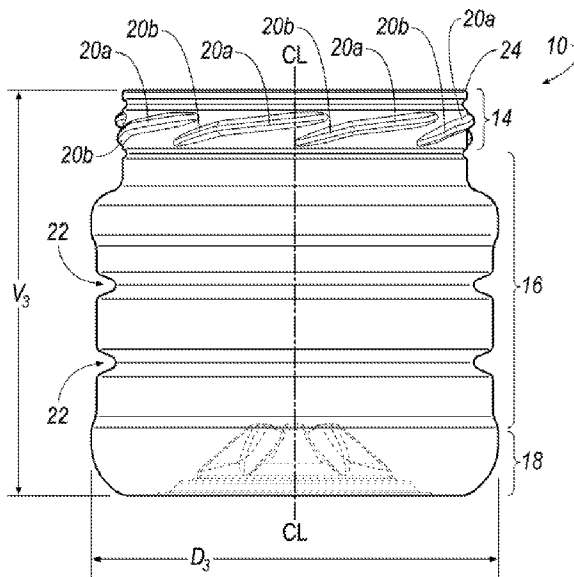


FIG. 2

(57) Abstract: A plastic container in-  
cludes a neck portion, a sidewall portion,  
and a base portion. The neck portion  
includes a plurality of threads,  
which may be configured to retain  
and/or secure a cap or lid. In embodi-  
ments, the threads may be blown and/or  
the neck portion may include a neck rib  
provided vertically above the threads.

# **PLASTIC CONTAINER WITH THREADED NECK FINISH**

## **TECHNICAL FIELD**

**[0002]** The present invention relates to plastic containers, including plastic containers having a threaded neck finish.

## **BACKGROUND**

**[0003]** Plastic containers with threaded neck finishes are known in the art. The technology has advanced to where a neck finish may include threading that is injection molded or blow molded. Moreover, plastic neck finishes may be used for various container applications, including “wide-mouth” and/or hot-fill container applications, as well as those that require the neck finish to hold its shape over an extended period of time and to maintain structural and seal integrity with respect to a closure.

**[0004]** Among other things, it can be desirable to provide a plastic container with a threaded neck finish that can replace glass jars, including “wide-mouth” round jars; accommodate reclosable caps or lids, including metal caps or lids commonly used with glass jars; and/or run on equipment commonly used in connection with glass jar production and handling.

## SUMMARY

**[0005]** A plastic container includes a neck portion, a sidewall portion, and a base portion. The neck portion includes a plurality of threads, which may be configured to retain and/or secure a cap or lid. In embodiments, the threads may be blown and/or the neck portion may include a neck rib provided vertically above the threads. Methods for forming a container are also disclosed.

## BRIEF DESCRIPTION OF THE DRAWINGS

**[0006]** Embodiments of the disclosure will now be described, by way of example, with reference to the accompanying drawings, wherein:

**[0007]** FIG. 1 is a perspective view of a three-dimensional model of an embodiment of a container that incorporates features of the present teachings;

**[0008]** FIG. 2 is a side elevational view of an embodiment of a container incorporating features of the present teachings;

**[0009]** FIG. 3 is a partial side view of a neck finish portion of an embodiment of a container incorporating features of the present teachings;

**[00010]** FIG. 4 is a bottom plan view of an embodiment of container incorporating features of the present teachings;

**[00011]** FIG. 5 is a top plan view of a neck portion of an embodiment of a container incorporating features of the present teachings;

**[00012]** FIGS. 6A and 6B are front and right side views, respectively, of the neck portion shown in FIG. 5;

**[00013]** FIG. 7 is a side cross-sectional view of a neck portion such as generally shown in FIG. 5;

- [00014] FIG. 8 is an enlarged cross-section view of the a portion of the neck portion generally illustrated in FIG. 7;
- [00015] FIG. 9 is a front elevational view of a an embodiment of a container incorporating features of the present teachings; the left, right, and back view being substantially similar in the instant embodiment;
- [00016] FIG. 10 is a top plan view of the embodiment of a container shown in FIG. 9, including portions of the base visible through the container opening;
- [00017] FIG. 11 is a bottom plan view of the embodiment of a container shown in FIG. 9;
- [00018] FIGS. 12, 13, and 14 are various different perspective views of the embodiment of a container shown in FIG. 9;
- [00019] FIGS. 15, 16, and 17 are top plan, bottom plan, and side views of an embodiment of a closure that may be used to engage a neck portion of a container; and
- [00020] FIG. 18 generally illustrates an embodiment of a closure engaged to a container in accordance with teachings of the present disclosure.

### DETAILED DESCRIPTION

[00021] Reference will now be made in detail to embodiments of the present disclosure, examples of which are described herein and illustrated in the accompanying drawings. While the invention will be described in conjunction with embodiments, it will be understood that they are not intended to limit the invention to these embodiments. On the contrary, the invention is intended to cover alternatives, modifications and equivalents, which may be included within the spirit and scope of the invention as defined herein and by appended claims.

[00022] With reference to **FIG. 1**, a three-dimensional model of an embodiment of a container 10 is generally illustrated. The container 10 includes an opening 12, which if desired can be further covered with an optional seal. The opening 12 can serve to fill and/or dispense

container contents. The container 10 includes a neck portion 14, a sidewall portion 16, and a base portion 18.

**[00023]** Embodiments of a container may be formed from various polymers known in the field of container manufacture including, for example and without limitation, polyethylene terephthalate (PET), polyethylene (PE), polypropylene (PP), and combinations and blends of two or more polymers. For embodiments, the container may, for example and without limitation, be produced by an injection stretch blow molding (ISBM) blow-trim process. In an embodiment, an injection molded preform may be stretch blow molded into an intermediate article that includes the general form/configuration of a container with blown threads, such as disclosed herein. An example of such an intermediate article and related process may be generally found in U.S. Patent Publication No. 2005/0163882 and U.S. Patent No. 6,740,284. Thereafter, a portion of the intermediate article provided above the neck portion (including the blown threads), e.g., a moil or a dome, may be trimmed off or otherwise separated to leave a container as shown and described in this disclosure. The container may, if desired, be heat-treated using various processes, including those that can improve the ability of a container to be hot-filled.

**[00024]** FIG. 2 generally illustrates a side elevational view of a container 10 embodying teachings of the present disclosure. The neck portion 14 is shown including a plurality of threads 20, which may also be referred to as “threading formations” or “lugs.” In embodiments, the neck portion, and the threads, may be injection molded or, alternatively, may be blown or blow molded.

**[00025]** As generally illustrated, threads 20 may be provided around, and extend radially outwardly from, an outer surface of the neck portion 14. The illustrated container 10 includes eight threads 20. However, embodiments of the container may include more or less than eight threads. Moreover, successive threads 20 – following around the circumference of the neck portion 14 – may have portions that vertically overlap, but are vertically spaced, from each other. Each thread 20 may be generally provided at a single angle relative to a vertical centerline CL or, as shown in the illustrated embodiment, may include more than one portion – such as first portion 20a and a second portion 20b.

**[00026]** Embodiments having a neck portion 14 such as generally illustrated and described herein may, for example, be used in connection with various wide-mouth plastic containers, including those replacing glass jars and related applications. Such wide-mouth plastic containers may have openings that range, for example and without limitation, from 63mm to 82 mm, and for some applications could be 83 mm or more.

**[00027]** With reference to **FIG. 3**, the neck portion 14 may include a neck rib 24 provided above the threads 20. The inclusion of one or more neck ribs 24 provided above the threads 20 can, among other things, help maintain container hoop strength and/or prevent or reduce ovality associated with the neck portion 14. A neck rib 24 can be helpful for running plastic containers on lines, such as existing glass jar lines, including those that employ a belt system for in-line capping. For some systems, one device (e.g., set of belts) can be configured to turn the jar or container in a first direction, while another device may turn a cap in an opposite rotational direction to engage and seal a container.

**[00028]** The neck portion 14 may further include a first portion 20a and a second portion 20b of a thread 20 may be generally provided at different angles relative to the center line **CL** of the container 10. As generally illustrated, the angle (relative to the center line **CL**) of the first portion 20a may be greater (and even visually perceptibly greater) than the angle of the second portion 20b. That is, and with respect to a different perspective, if a plane of a support surface upon which the container may rest is viewed as being flat at 0 degrees, the angle associated with the first portion 20a (relative to the support surface) may be lesser/less steep (and even visually/perceptively less steep) than the angle associated with the second portion 20b. Additionally, for embodiments, a portion of the second portion 20b may extend in a vertical direction (and at a continued angle) below a secured cap or lid, and such portion may be at least partially visible when the cap or lid is secured to the container.

**[00029]** With embodiments, the vertical distance **V1** of the neck portion 14 may be significantly less than the outer diameter **D1** of the neck portion 14. In an embodiment of the container, the neck finish of the container may comprise, for example, an 82 mm or an 83 mm blown finish. For example, and without limitation, with embodiments the diameter **D1** of the neck portion 14 may be about five times (or even more for some embodiments) greater than the

vertical distance **V1** of the neck portion 14. Additionally, the uppermost portion of the threads 20 may be offset from the top or uppermost portion of the container 10 by a vertical distance **V2**. For some embodiments, the offset distance, illustrated in the embodiment as vertical distance **V2**, may be about one-third of vertical distance **V1**. For example, and without limitation, **V2** for an 82 mm or 83 mm blown finish container may be about 0.206 in. (5.24 mm), while **V1** may be about 0.630 in. (16.002 mm).

**[00030]** Further, for some embodiments, the total height, or vertical distance **V3** of the container 10, may be substantially the same as the greatest diameter **D3** of the container 10. For other embodiments, the difference between vertical distance **V3** and the greatest diameter **D3** may be within about one percent (1%) of each other. For other embodiments, the difference between vertical distance **V3** and the greatest diameter **D3** may be within about five percent (5%) of each other.

**[00031]** As generally illustrated in **FIG. 2**, embodiments of the sidewall portion 16 of a container 10 may include one or more horizontal straps 22, grooves, and/or other formations. Such straps 22, grooves, or other formations may provide additional structure and/or support to the sidewall portion 16. With embodiments, the sidewall portion 16 may be configured to help maintain hoop strength. For example, and without limitation, some embodiments, such as those disclosed in U.S. Patent 6,857,531 and U.S. Patent Application Publication 2012/0061410, may include various ribs or formations. The sidewall portion is generally illustrated as being circular in nature; although, other shapes and/or formations may be associated with or included in the sidewall portion 14.

**[00032]** For some embodiments, the container may include one or more barrier materials. For example, an oxygen scavenging barrier material (such as commercially available under the trade name DiamondClear) may be employed. Such materials can, among other things, help to keep oxygen away from container contents. Some examples of such materials are, without limitation, generally disclosed in U.S. Patent 7,691,290; U.S. Patent Application Publication 2011/0172335; U.S. Patent Application 2011/0171405.

**[00033]** With reference to **FIG. 4**, the base portion 18 may include formations, such as a plurality of ribs 26 arranged radially about the center line **CL** of the container. The formations can strengthen/reinforce the base portion 18 so that the container can handle pressures and/or temperatures for given applications, such as hot-fill applications, without retort or unacceptable ovalization. Without limitation, an example of a base portion that includes structural formations to increase the rigidity of a base portion is disclosed in U.S. Patent 7,732,035.

**[00034]** **FIG. 5** illustrates a top view of an embodiment of a neck portion 14 embodying features of the present teaching. **FIGS. 6A and 6B** generally depict an embodiment of a neck portion with a plurality of threads 20 shown from a front and right side, respectively.

**[00035]** **FIG. 7** illustrates a partial cross-sectional view of a neck portion embodying features of the present teachings. **FIG. 8** illustrates an enlarged cross-section view of a portion of the neck portion generally depicted in **FIG. 7**. In the illustrated embodiment, the thread 20 is shown extending (radially) outwardly relative to other portions/segments of the neck portion, and a recess 28 is shown included on the inside (inner radial) wall of the thread. With embodiments, the recess 28 may be generally in the form of a symmetrical curve. As generally illustrated the thread 20, when viewed in cross-section as shown, may include at least three segments – i.e., 30a, 30b, and 30c. Segments 30a and 30c may be generally provided at an angle (viewed in cross section) from the horizontal. In the illustrated embodiment the angle for the segments is about 30 degrees (relative to a base/horizontal plane; i.e., 60 degrees relative to the center line **CL** of the container). For other embodiments, the angle may be about  $30 \pm 15$  degrees. Segment 30b may include a portion that is substantially closer to a vertical line (e.g., parallel to a center line **CL** of the container).

**[00036]** Further, the shape of the threads may not necessarily be “symmetrical” (viewed in cross section) for some embodiments. In embodiments, several segments of the thread 20 may include different radiuses associated with curvature. The embodiment of a thread 20 illustrated in **FIG. 8** includes and identifies several specific radii – i.e. **R1**, **R2**, **R3**, and **R4**. For example and without limitation, **R1** may be 0.040 in. (1.02 mm), **R2** may be 0.035 in (0.90 mm), **R3** may be 0.023 in. (0.59 mm), and **R4** may be 0.025 in. (0.64 mm). In this embodiment, the relative

measurements of **R1** and **R2** are larger (compared to **R3** and **R4**) and are fairly close to one another (i.e., within 0.005 in.). At the same time, **R3** and **R4** are comparatively smaller relative measurements (relative to **R1** and **R2**), and are fairly close to each other (i.e., within 0.002 in.). Such radii can provide a thread shape that is desirable for a cap or lid closure application.

**[00037]** FIGS. 9-14 generally illustrate embodiments of a container 10 embodying features of the present teachings, with the container shown from different standard and perspective views.

**[00038]** FIGS. 15-17 generally illustrate top plan, bottom plan, and side views of an embodiment of a closure 40 that may be used to engage a neck portion of a container. As generally illustrated in FIG. 16, the closure 40 may include a plurality of bent or radially inwardly extending portions 42 that can be configured to engage threads 20 – such as when a closure is screwed (e.g., clockwise) onto the neck portion of a container. While eight bent or radially inwardly extending portions are generally illustrated in FIG. 16, the present disclosure is not limited to that number, and embodiments of closures may have different sizing and/or shapes, and may include more or less such features. FIG. 18 generally illustrates an embodiment of a closure 40 engaged to a container 10 in accordance with teachings of the present disclosure.

**[00039]** While not necessarily desirable for all applications, such as where relatively higher heats are associated with contents (e.g., some food contents), some embodiments may employ a base portion that provides a degree of intended flexibility. An example of a base structure with a measure of flexibility that may be employed for some applications is disclosed in U.S. Patent 8,596,029.

**[00040]** A potential benefit of providing containers with neck portions as taught and described in the instant disclosure is that such containers may be able to be run on existing glass container lines, as well as potentially utilizing lids commonly employed with glass containers. Moreover, containers embodying features of the present teachings have been sufficiently strong to maintain vacuum and provide full functionality in connection with tamper-evident metal closures (such as those in which one can listen for a “pop” or “click”) to help ensure product safety.

**[00041]** The foregoing descriptions of specific embodiments of the present invention have been presented for purposes of illustration and description. They are not intended to be exhaustive or to limit the invention to the precise forms disclosed, and various modifications and variations are possible in light of the above teaching. The embodiments were chosen and described in order to explain the principles of the invention and its practical application, to thereby enable others skilled in the art to utilize the invention and various embodiments with various modifications as are suited to the particular use contemplated. It is intended that the scope of the invention be defined by the claims and their equivalents.

## CLAIMS:

1. A plastic container comprising:

a neck portion, the neck portion including an opening and a plurality of threads disposed vertically below the opening;

a sidewall portion extending below the neck portion; and

a base portion extending below the sidewall portion;

wherein each of the plurality of threads include a first portion and a second portion, the first portion is provided at a first angle relative to a centerline of the plastic container, the second portion is provided at a second angle relative to the centerline of the container, the first angle and second angle are different, first portions of each of the plurality of threads vertically overlap and are vertically spaced above a second portion of a successive thread, the plurality of threads extend in succession around the entire circumference of the neck portion, and each thread extends around less than one-quarter of the entire circumference of the neck portion, and the spacing of portions of successive threads of the neck portion is configured to receive more than four bent or radially extending portions of a screw-on closure.

2. The plastic container of claim 1, wherein the plurality of threads are blow molded.

3. The plastic container of claim 1, wherein the plurality of threads are injection molded.

4. The plastic container of any one of claims 1 to 3, wherein the plastic container is comprised of at least one of polyethylene terephthalate (PET), polyethylene (PE), and polypropylene (PP).

5. The plastic container of any one of claims 1 to 4, wherein the plastic container is comprised of a blend of two or more polymers.

6. The plastic container of any one of claims 1 to 5, wherein the first angle is greater than the second angle.

7. The plastic container of any one of claims 1 to 6, wherein the second portion extends vertically downward to an extent that a portion of the second portion is visible when a cap or lid is secured to the container by the plurality of threads.

8. The plastic container of any one of claims 1 to 7, wherein an outer diameter of the neck portion is at least about five times greater than a distance of the neck portion.

9. The plastic container of any one of claims 1 to 8, wherein an uppermost portion of the first portion of the threads is offset from an uppermost portion of the container by a vertical distance that is about one-third of a total vertical distance of the neck portion.

10. The plastic container of any one of claims 1 to 8, wherein an uppermost portion of the first portion of the threads is offset from an uppermost portion of the container by a vertical distance of about 5.24 mm.

11. The plastic container of any one of claims 1 to 10, wherein a total height of the container is the same or within one percent of a greatest diameter of the container.

12. The plastic container of any one of claims 1 to 11, wherein the total height of the container is within three percent of the greatest diameter of the container.

13. The plastic container of any one of claims 1 to 11, wherein the total height of the container is within five percent of the greatest diameter of the container.

14. The plastic container of any one of claims 1 to 13, including one or more horizontally extending straps or grooves.

15. The plastic container of any one of claims 1 to 14, wherein the container is heat treated or heat set.

16. The plastic container of any one of claims 1 to 15, wherein the container includes one or more barrier materials.

17. The plastic container of claim 16, wherein the one or more barrier materials comprises an oxygen scavenging material.

18. The plastic container of any one of claims 1 to 17, wherein the base portion includes a plurality of radially extending ribs.

19. The plastic container of any one of claims 1 to 18, wherein the neck portion includes a recess provided with respect to an inside wall of at least one of the plurality of threads.

20. The plastic container of claim 19, wherein, viewed in cross-section, the recess is generally a symmetrical curve.

21. The plastic container of any one of claims 1 to 20, wherein, when viewed in cross-section, each of the plurality of threads comprises a first segment, a second segment, and a third segment, with each segment having a different curvature.

22. The plastic container of claim 21, wherein the first segment and third segment are generally provided at an angle of about 60 degrees relative to a center line of the container.

23. The plastic container of claim 21, wherein the first segment and third segment are generally provided at an angle of about  $30 \pm 15$  degrees relative to a center line of the container.

24. The plastic container of any one of claims 21 to 23, wherein the second segment includes a portion that is substantially parallel to the center line of the container.

25. The plastic container of any one of claims 1 to 24, wherein a cross-sectional shape of each of the plurality of threads is not symmetrical.

26. The plastic container of any one of claims 1 to 25, wherein several segments of each of the plurality of threads includes different radii of curvature.

27. The plastic container of any one of claims 1 to 26, wherein the plurality of threads comprise eight threads, and the spacing of portions of successive threads of the neck portion is configured to receive eight bent or radially extending portions of said screw-on closure.

28. The plastic container of any one of claims 1 to 26, wherein the plurality of threads comprise more than eight threads.

29. The plastic container of any one of claims 1 to 28, wherein the neck portion includes a neck rib provided above the plurality of threads.

30. The plastic container of any one of claims 1 to 29, wherein the opening has a diameter between about 63 mm to about 82 mm.

31. The plastic container of any one of claims 1 to 29, wherein the opening has a diameter greater than 82 mm.

32. A method for making a plastic container, comprising:

providing a plastic preform;

blow molding the preform into an intermediate article that includes a neck portion with a plurality of blown threads, wherein each of the plurality of blown threads include a first portion and a second portion, the first portion is provided at a first angle relative to a centerline of the intermediate article, the second portion is provided at a second angle relative to the centerline of the intermediate article, the first angle and second angle are different, first portions of each of the plurality of blown threads vertically overlap and are vertically spaced above a second portion of a successive thread, the plurality of blown threads extend in succession around the entire circumference of the neck portion, and each thread extends around less than one-quarter of the entire circumference of the neck portion; and

removing an upper portion of the intermediate article.

33. The method of claim 32, including heat treating the plastic container.

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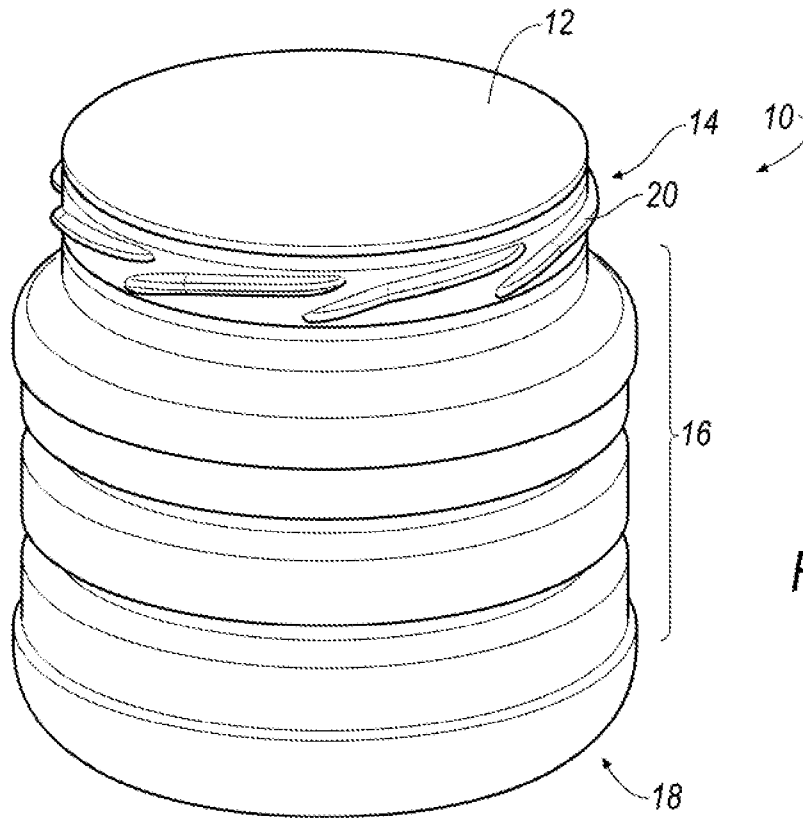


FIG. 1

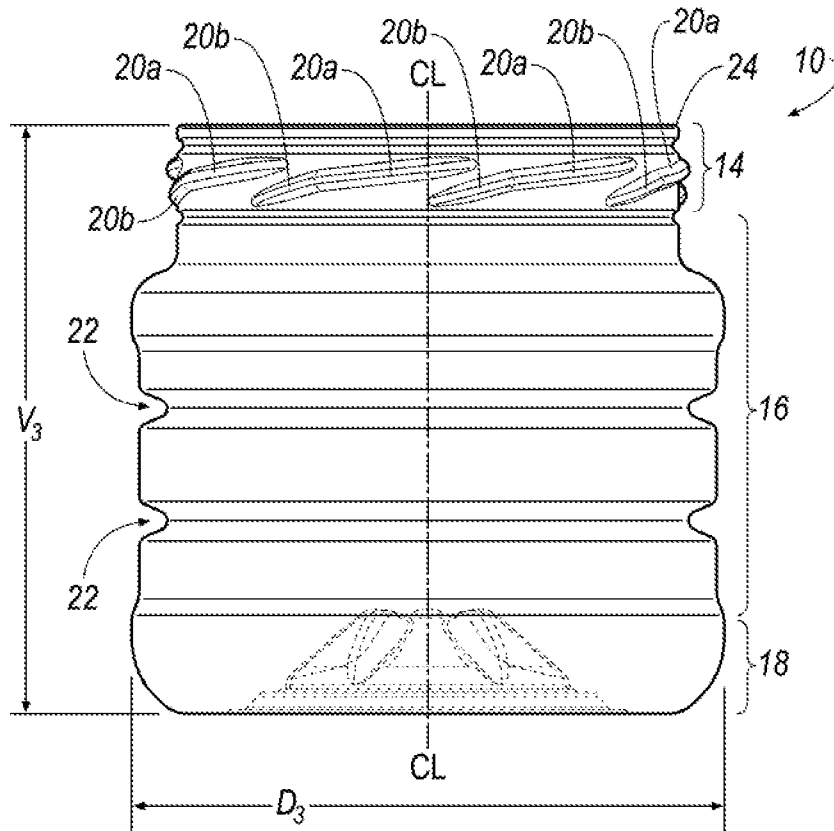
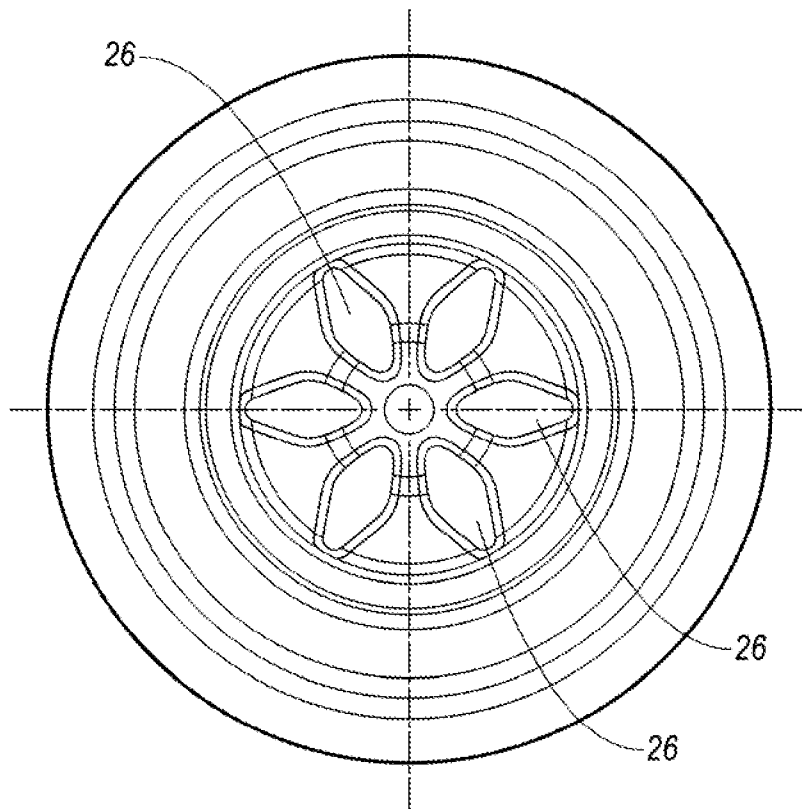
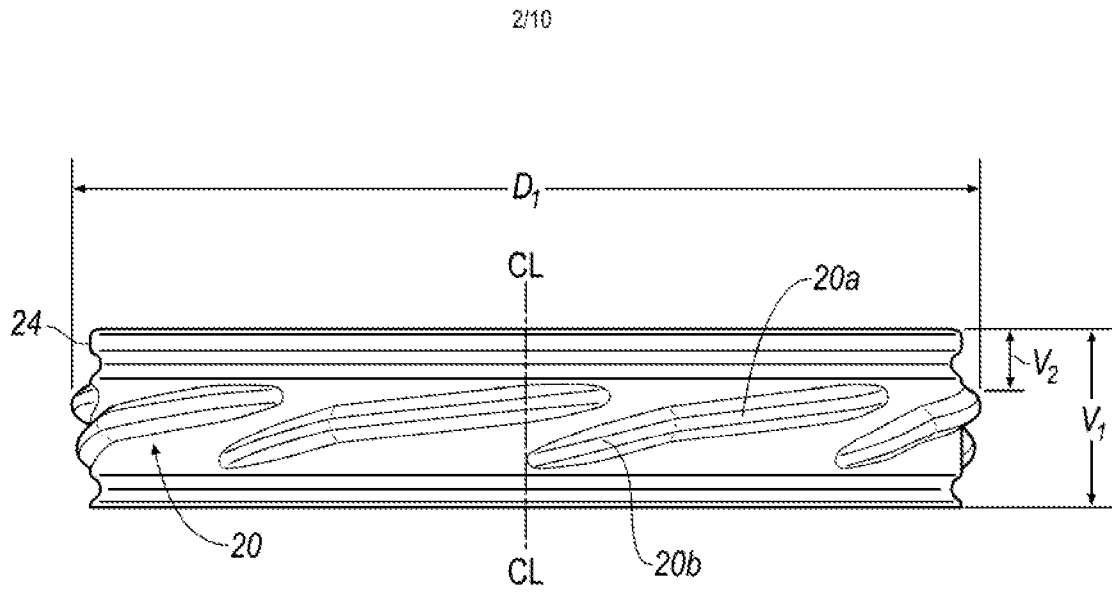


FIG. 2



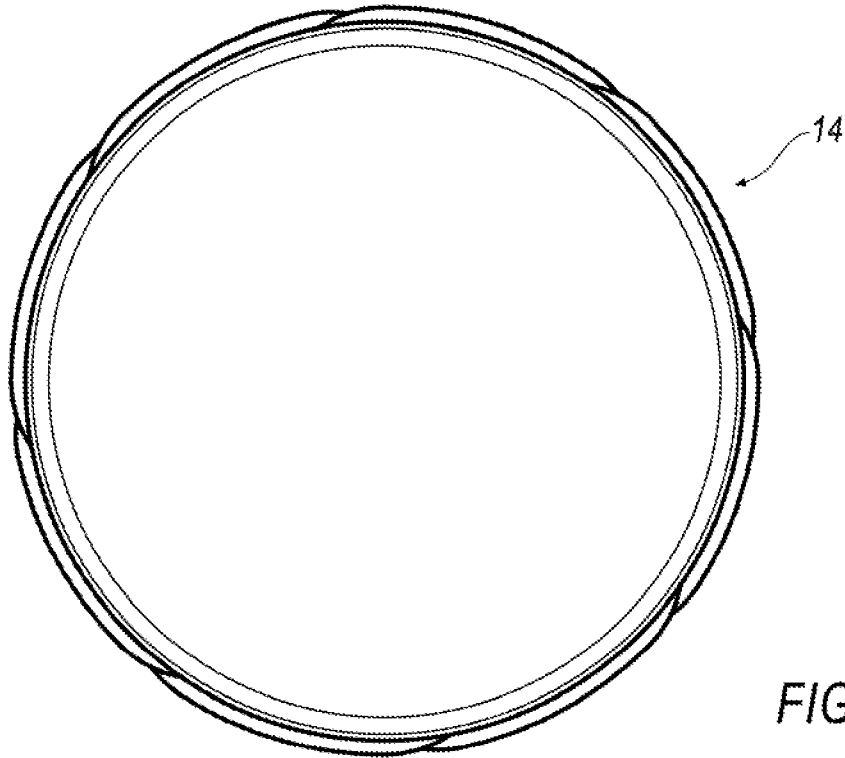


FIG. 5

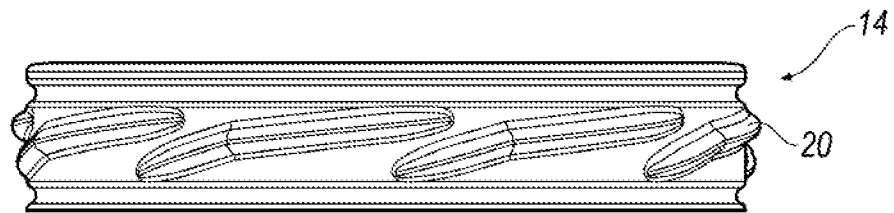


FIG. 6A

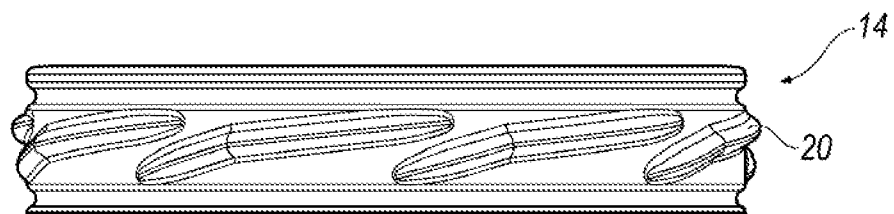


FIG. 6B

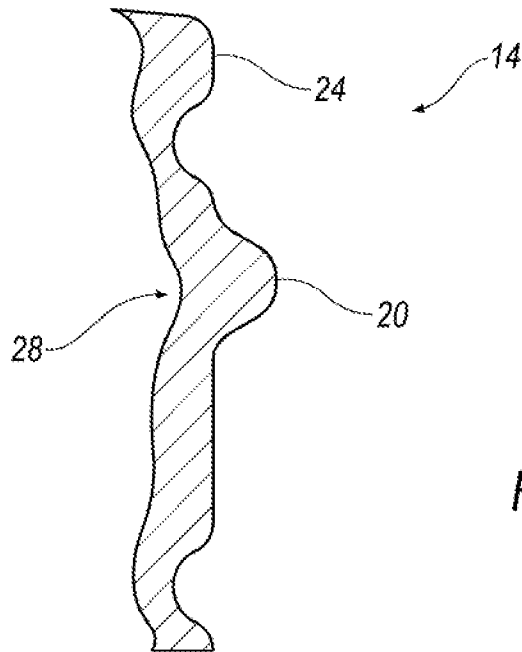


FIG. 7

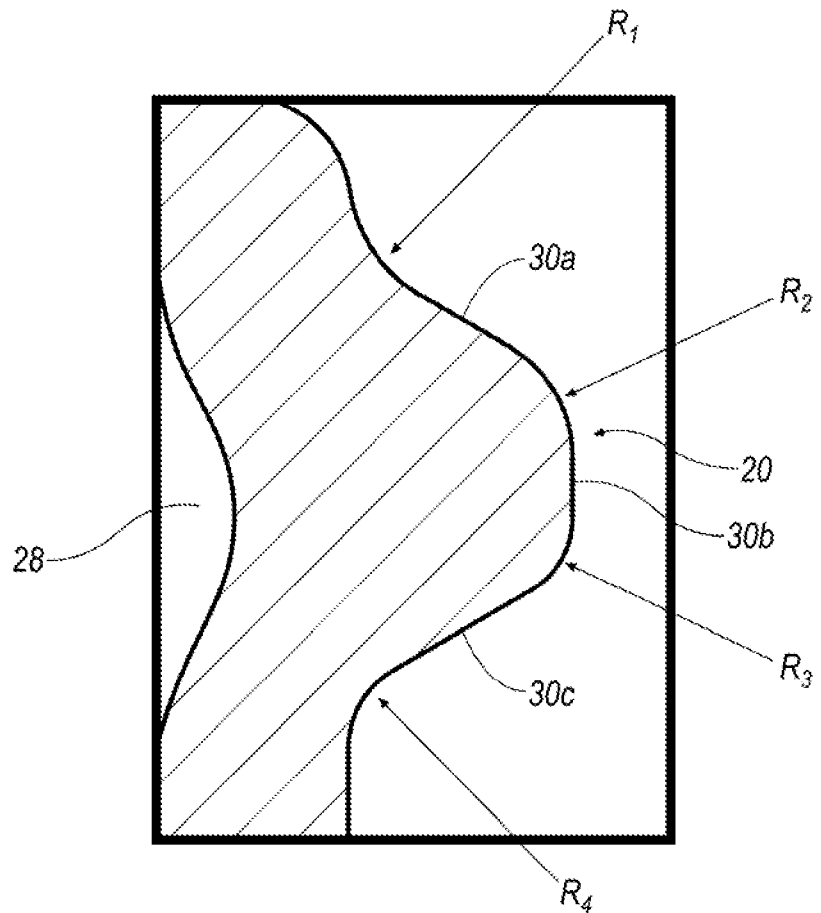


FIG. 8

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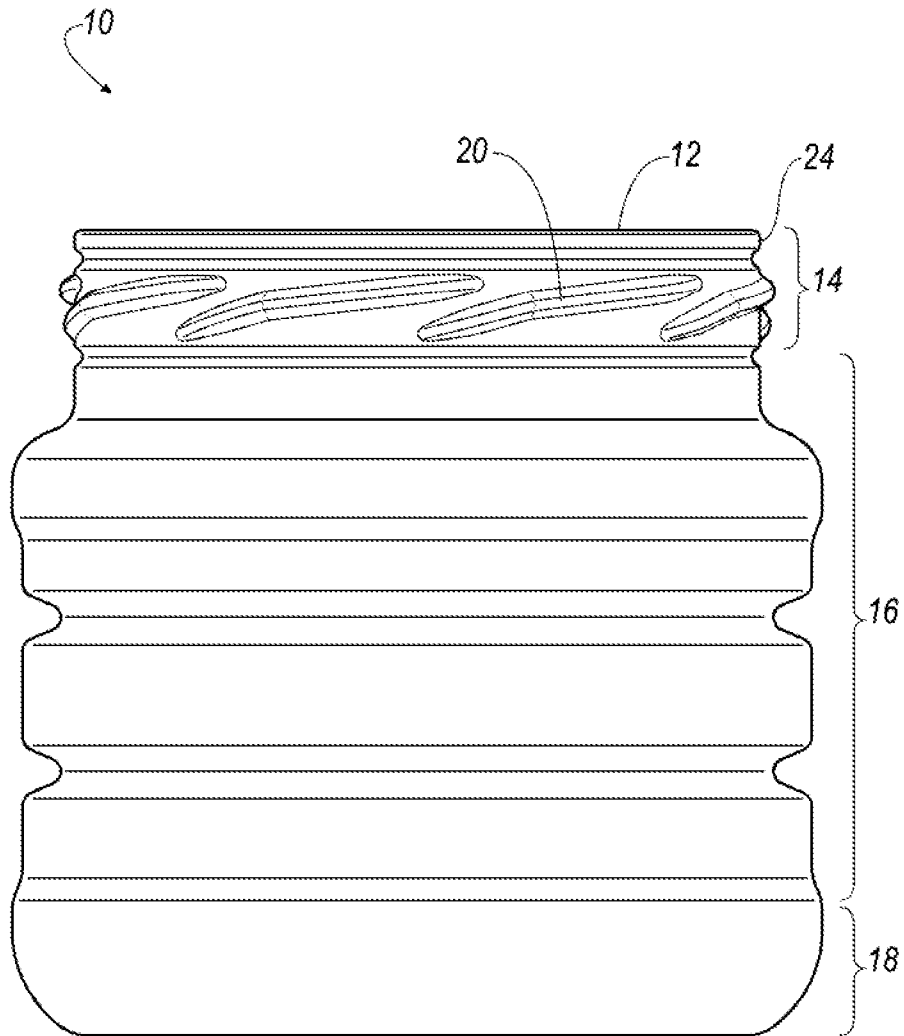


FIG. 9

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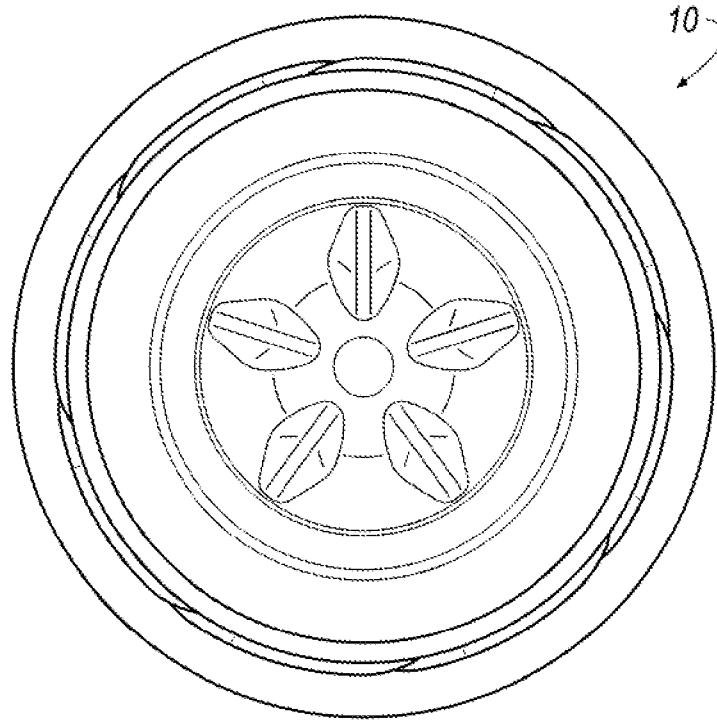


FIG. 10

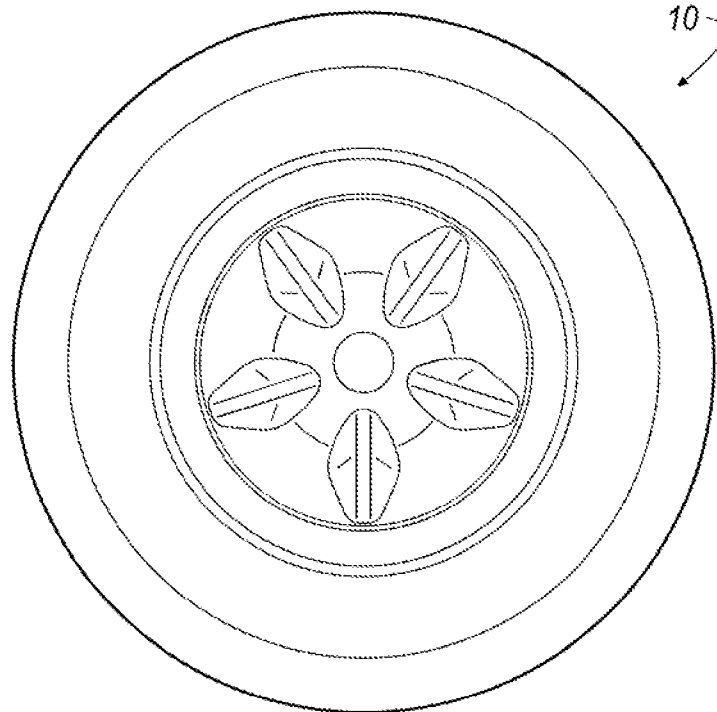


FIG. 11

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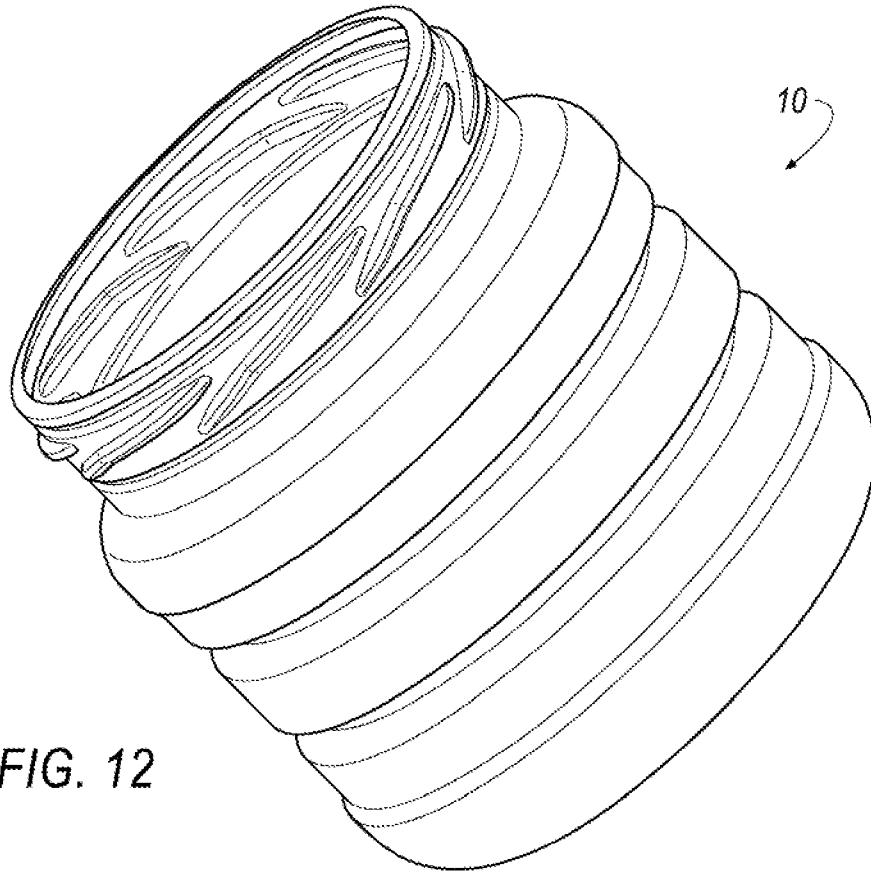


FIG. 12

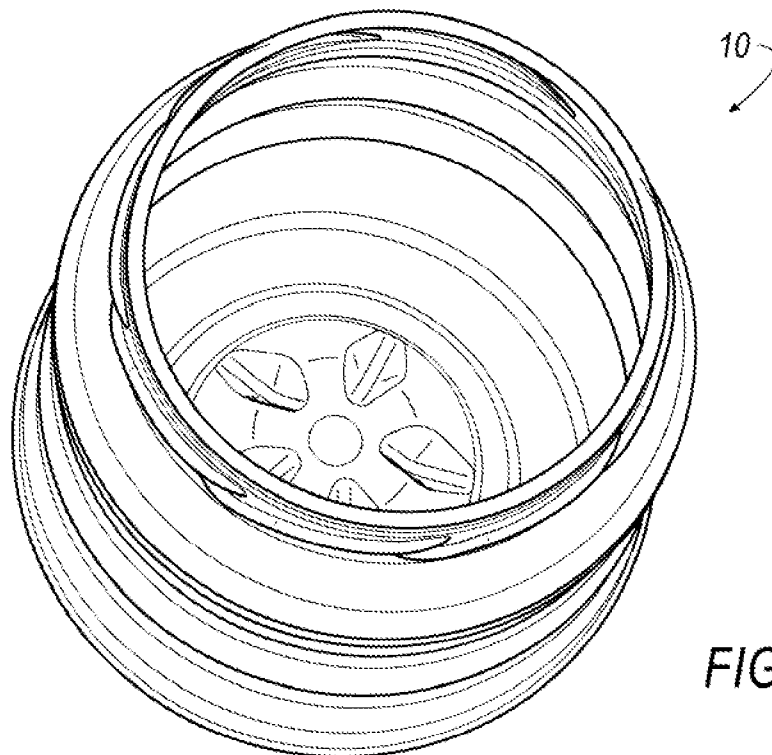


FIG. 13

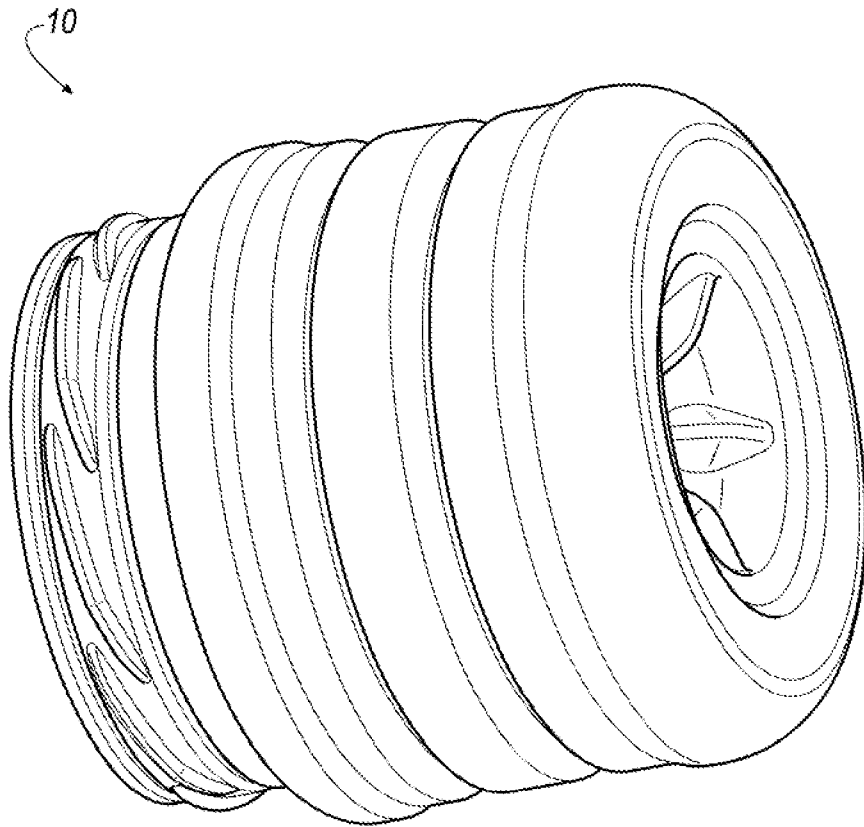


FIG. 14

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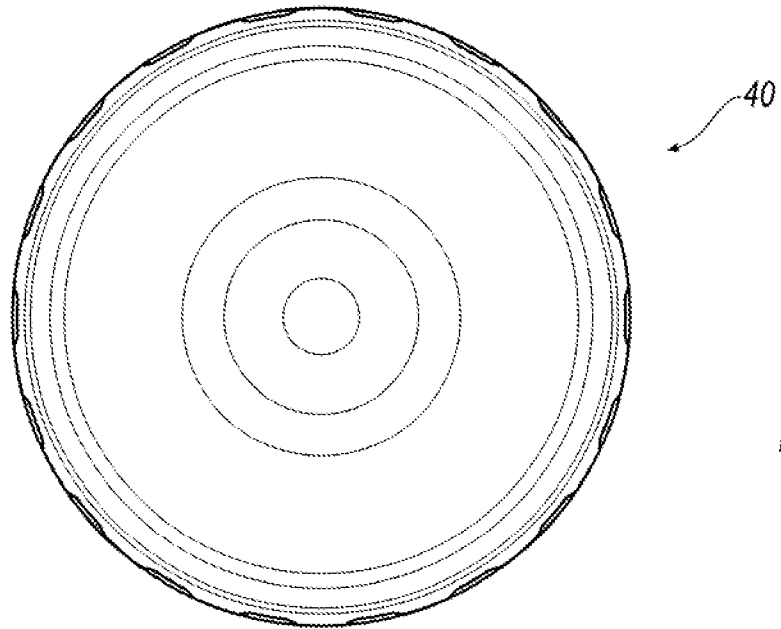


FIG. 15

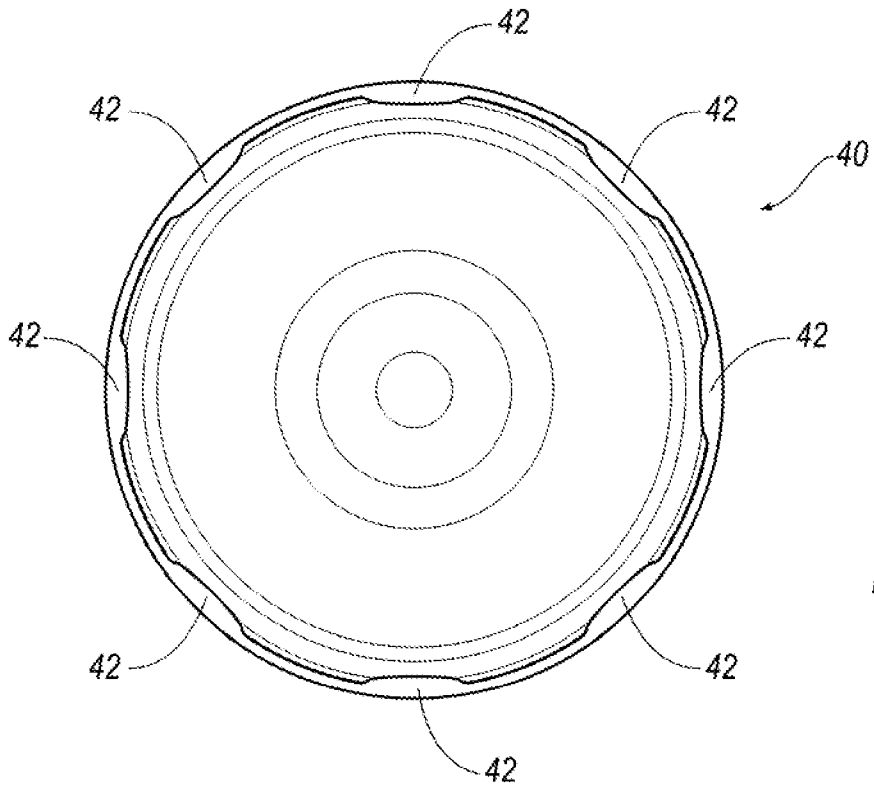


FIG. 16

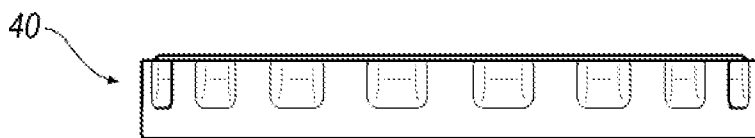


FIG. 17

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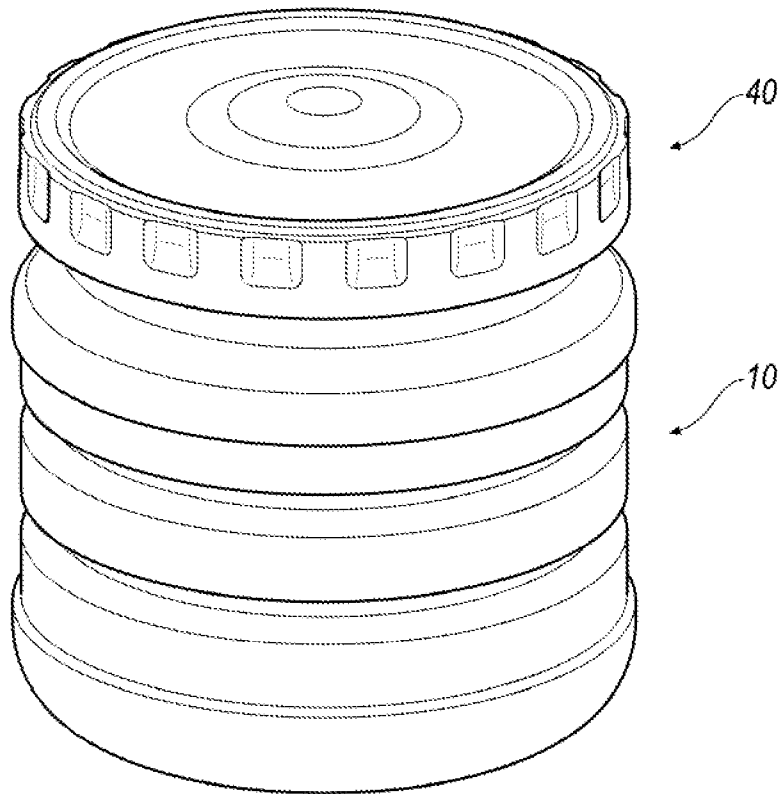


FIG. 18

