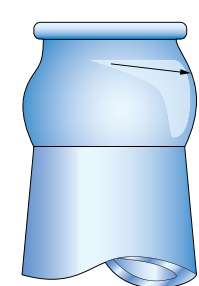


Guide to Container Defects

Finish Defects



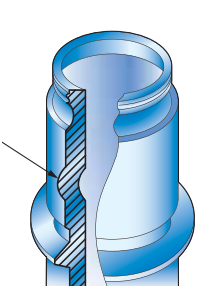
BENT OR CROOKED FINISH
A finish which has a bent or crooked appearance.



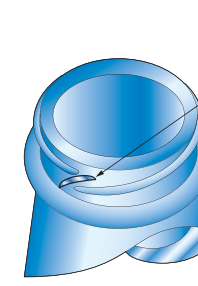
BLISTERS
Large bubbles in the glass.



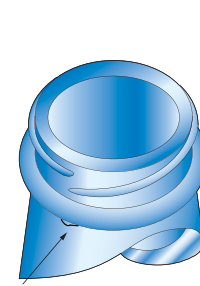
BROKEN FINISH
A finish which has cracks or actual pieces of glass broken out of it.



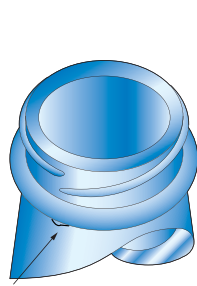
BULGED FINISH
A finish which is bulged out of shape.



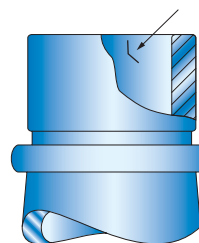
CHECKED FINISH
A finish which has a light surface crack in the threads or in the middle.



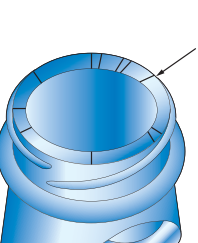
CHIPPED FINISH
A finish from which a small section is broken on the top or side.



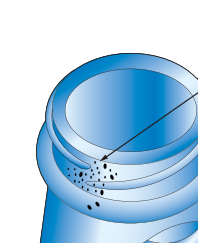
TEAR OR UNDER RING CHECK
Surface cracks which occur on or near the parting line between the neck and the finish.



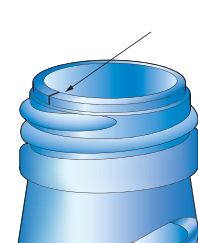
CORKAGE CHECK
A vertical surface crack located in the inside of the finish.



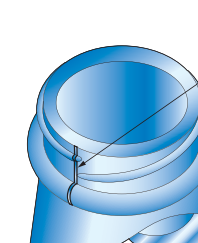
CRIZZLED FINISH
A finish with many fine surface fractures, mainly across the top.



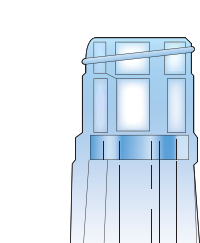
DIRTY OR ROUGH FINISH
A finish which has a scaly appearance and which may even have black spots on it.



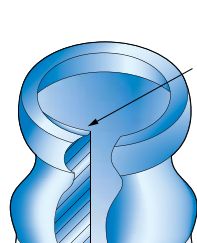
LINE OVER
A superfine groove across the sealing surface that can cause a container to leak after the filling process.



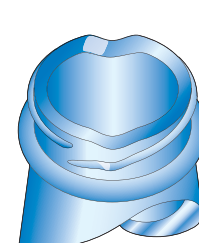
NECK RING SEAM
A protruding seam of glass running vertically up to the finish of the container.



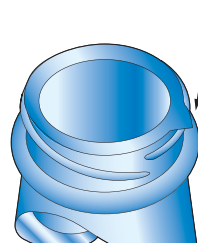
OFFSET FINISH
A finish formed out of alignment, either vertically or horizontally.



OVERPRESS/ WIRE EDGE
A finish which has excessive glass projecting upward from the inside edge of the finish.



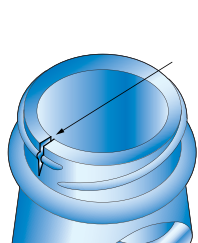
SADDLE FINISH
A gradual slope or dip in the finish that has a saddle-like finish.



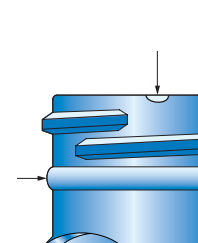
KNOCKOUT
A small glass protrusion caused by a small chip in the mold seam.



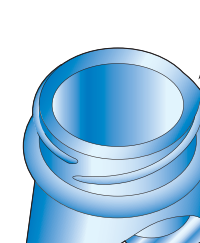
STONES
Small pieces of refractory or unmelted batch materials.



SPLIT FINISH
A finish which has a crack across the top surface—extends from the top of the finish down towards the neck.



UNFILLED FINISH
A finish which is incompletely filled, in the top, the bead, or the thread.



FLANGE
A small ring of glass which is pressed out between the guide and neck ring.

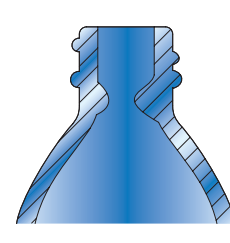


SEEDS
Very small bubbles in the glass.

Neck Defects



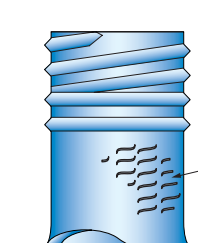
BENT NECK
A neck where the finish is tilted to one side.



CHOKED NECK OR BORE (NARROW NECK)
An obstruction in the bore of the neck.



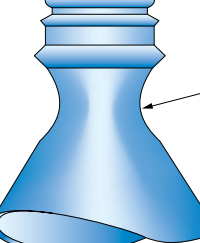
DANNY NECK OR NECK TEAR
A small surface section of glass torn from the neck of the bottle.



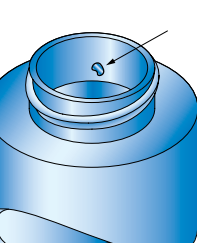
DIRTY NECK
A neck which has a dirty or scaly appearance.



LONG NECK
A neck that has been stretched longer than specified.

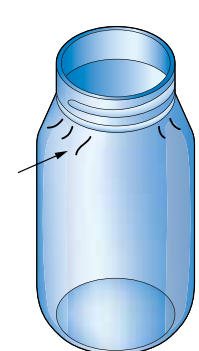


PINCHED NECK
A neck which has been pushed or pinched.

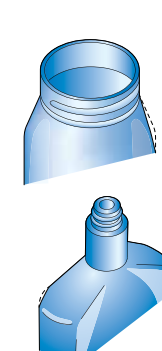


STUCK GLASS PARTICLES
Small glass particles stuck to the inside of the container. Most common in wide mouth ware.

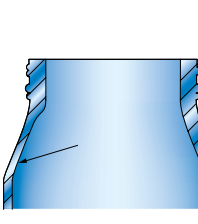
Shoulder Defects



SHOULDER CHECK
Surface cracks on the shoulder of the containers. They are usually wavy in appearance.

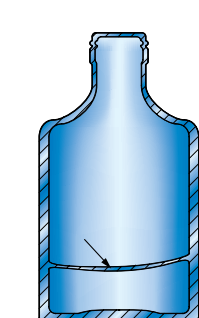


SUNKEN SHOULDERS
A shoulder which is not fully blown up.



THIN SHOULDERS
A shoulder which has a thin section.

Sidewall & Body Defects



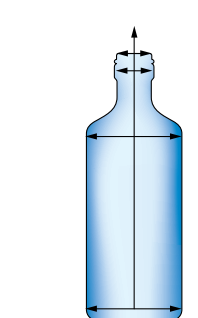
BIRD CAGE (BIRD SWING)
A string of glass expanding across the inside of the container.



BODY CHECKS
A crack or fracture through the wall thickness in the body of the container.



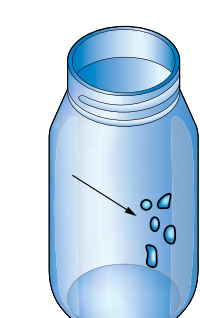
BLANK AND MOLD SEAMS
Relatively large seams extending from the shoulder to the container base. Blank seams tend to veer off from the mold seam.



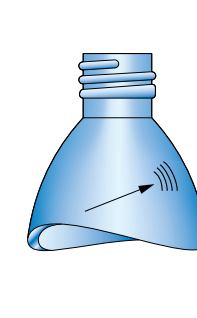
BODY DIMENSIONS
Dimensions out of specification for various diameters and perpendicularity.



BLACK SPOTS
Small black specks in the container.



BLISTERS
Large bubbles in the glass.



BRUSH MARKS
Fine vertical lines in the side or neck of a container.



BULGED SIDES
The sides of a container (usually panel shape) which are pushed out.



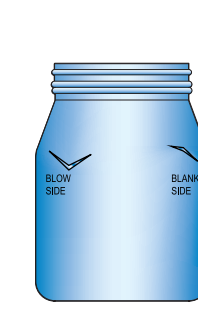
COLD MOLDS
Dappled or wavy appearance in the body of the container.



DIRTY WARE
Ware which has carbon or dirty deposits in it.



DRAG MARKS
A series of fine vertical laps near the shoulder or neck of the container.



HOT OR CHECK PANELS
Cracks through the container body on the edge or side, deep, V-shaped, going through the wall.



LAP MARKS OR WRINKLES
A slight fold on the surface of the glass—usually horizontal (can also be found on the finish).



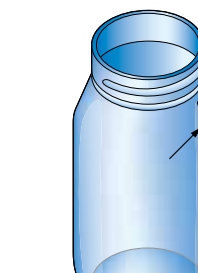
SIDEWALL STRESS
Residual stresses left in the glass after annealing caused by foreign particles or dissimilar threads.



LETTER CHECKS
Small cracks or fissures which occur from any lettering or embossing.



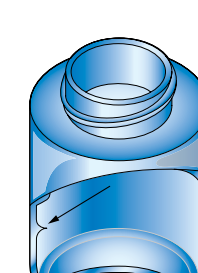
LOADING MARKS
Vertical laps on the surface of the container, may be in the body or neck or both.



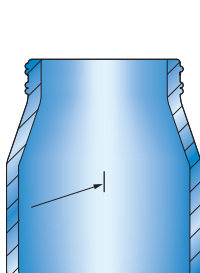
OIL MARKS
Strings of small bubbles in the container.



SEEDS
Very small bubbles in the glass.



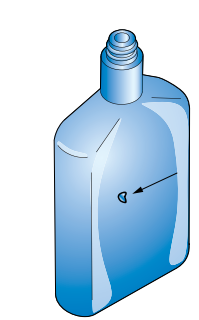
SPIKES
A small projection of glass in the body of the container.



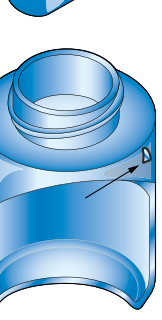
PRESSURE CHECKS
Cracks through the container's wall thickness characterized by thin, vertical cracks appearing at the seam.



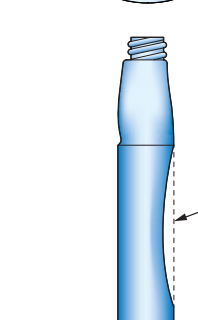
FREAKS
A container so badly formed or squeezed out of shape that it can be seen at almost any distance.



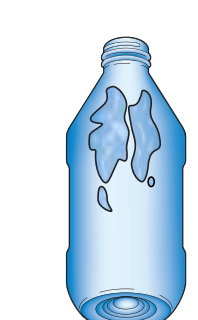
STONES
Small pieces of refractory or unmelted batch materials.



STUCK GLASS PARTICLES
Small glass particles stuck to the inside of the container. Most common in wide mouth ware.



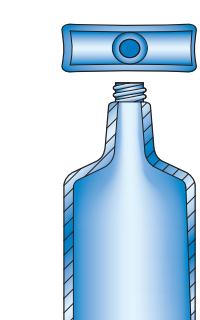
SUNKEN SIDES
The side of a container (usually panel shape) that is not fully blown up or may have sunk after release from the blow mold.



SWAB WARE
Residue left on the container from the IS Machine swabbing process.

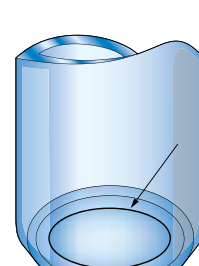


WASH BOARDS
A series of horizontal waves or folds on the side of the container.



LIGHT OR THIN WARE
Thin spots in the container, which are below the minimum acceptable level.

Base Defects



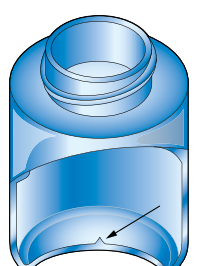
BAFFLE MARKS
A rough or damaged baffle seam on the bottom of the container.



BASE LEANER
A bottom which has sagged so that the container is unstable when placed on a flat surface.



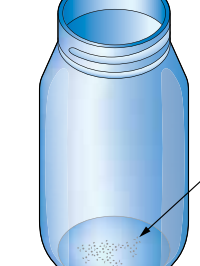
BLACK SPOTS
Small black specks in the container.



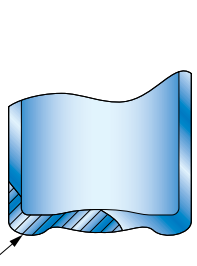
BASE SPIKE
A small projection of glass in the bottom of the container.



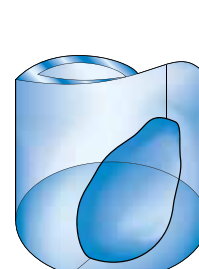
BLISTERS
Large bubbles in the glass.



DIRTY WARE
Ware which has carbon or dirty deposits on it.



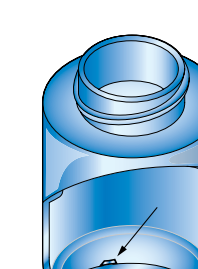
BASE CHECK
Small cracks through the base layer that occur on or near the rounded part of the bottom contact surface.



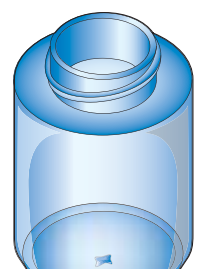
SWUNG BAFFLE
The baffle mark has swung to one side and is not central in the bottom of the container.



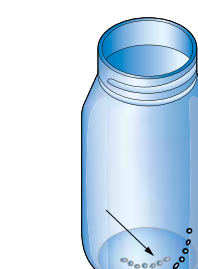
STONES
Small pieces of refractory or unmelted batch materials.



STUCK GLASS PARTICLES
Small glass particles stuck to the inside of the container. Most common in wide mouth ware or tramp glass.



BASE STRESS
Residual stresses left in the glass after annealing caused by foreign particles or dissimilar materials.



OIL MARKS
Strings of small bubbles in the container.

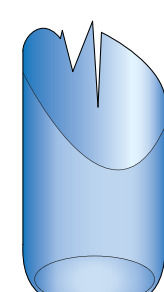


SEEDS
Very small bubbles in the glass.



SWAB WARE
Residue left in the container from the IS Machine swabbing process.

Other Defects



BROKEN WARE
Ware which is cracked or broken into pieces.



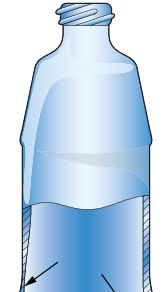
OUT-OF-SHAPE WARE (LEANER)
Containers which are tilted to one side due to bottom not being level.



STRUCTURAL DEFECTS
Internal stresses in the container due to poor annealing.



STUCK WARE
A rough piece of glass on the outside of the container.



UNEVEN OR BAD DISTRIBUTION
Uneven wall thickness.



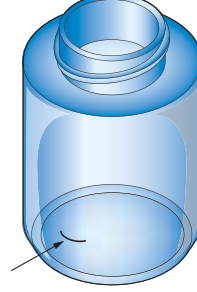
OVER OR UNDER HEIGHT
Height that exceeds or is below specification.



HORIZONTAL TEAR
A rough crack on the glass surface oriented horizontally.



VERTICAL TEAR
A rough crack on the glass surface oriented vertically.



SHEAR MARKS
A C-shaped mark in the glass, attributable to the action of the shears.