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(54) **BABY BOTTLE WITH FLEXIBLE NIPPLE REGIONS**

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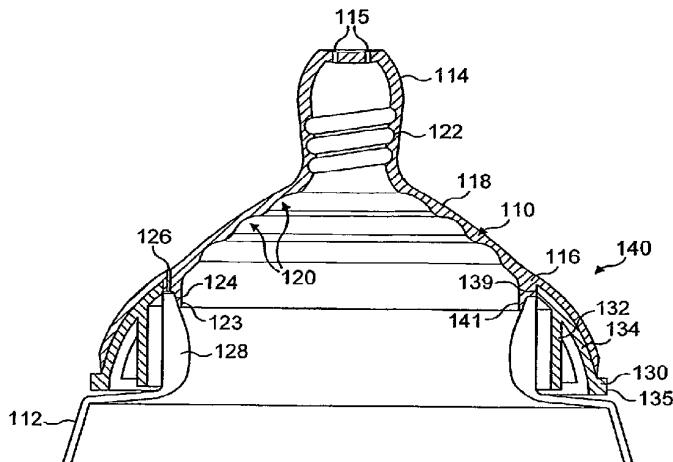
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(57) **ABSTRACT**

According to a first embodiment, a feeding bottle comprises a vessel, collar, and nipple. The nipple comprises a base portion, a teat portion, an areola portion allowing movement of the teat portion towards and away from the base portion. According to a second embodiment, a feeding bottle comprises a vessel, collar, nipple and handle portion removeably secured to the vessel by the collar. The invention includes a flexible region or regions to provide a more natural feeding by closely mimicking the human breast.

31 Claims, 6 Drawing Sheets



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continuation of application No. 13/364,557, filed on Feb. 2, 2012, now Pat. No. 8,910,810, which is a continuation of application No. 11/630,864, filed as application No. PCT/GB2005/002532 on Jun. 29, 2005, now Pat. No. 8,181,800.

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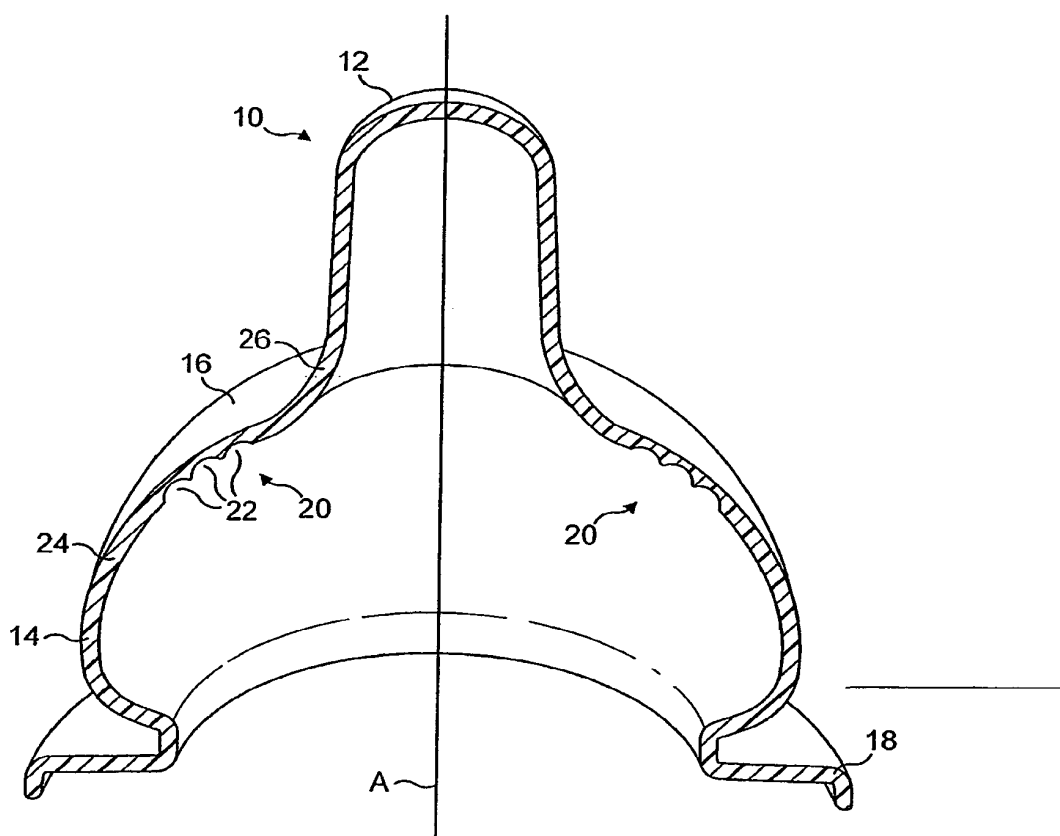


FIG. 1

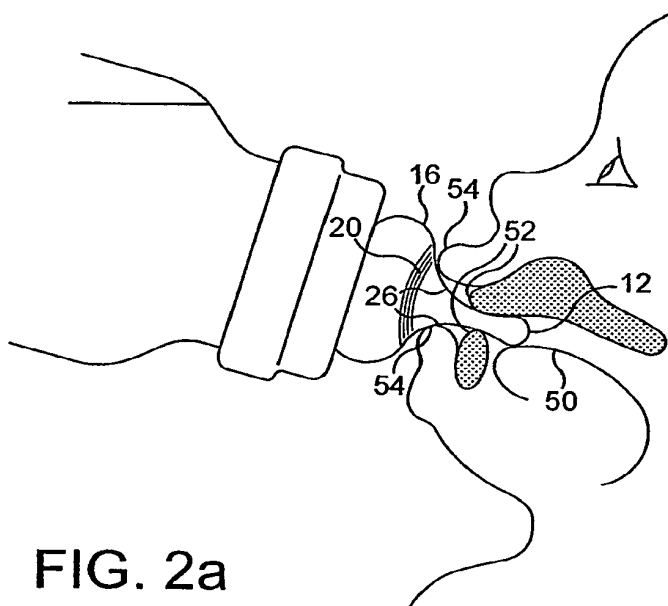


FIG. 2a

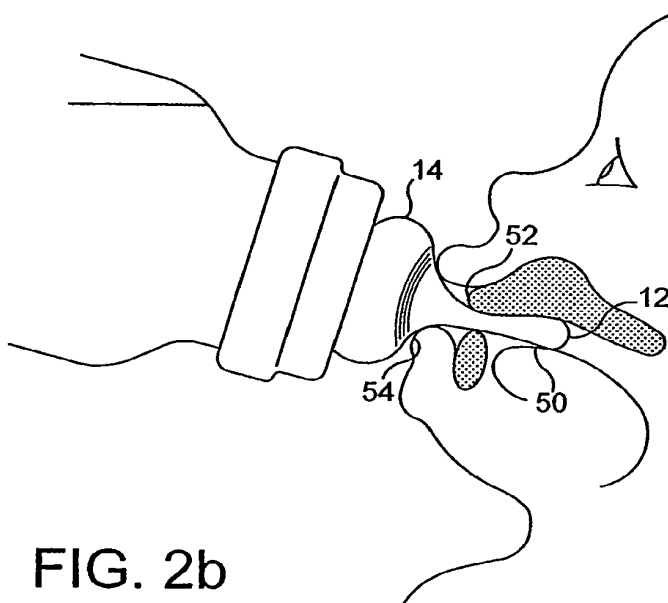


FIG. 2b

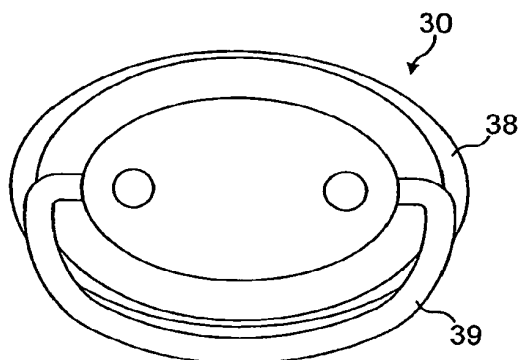


FIG. 3a

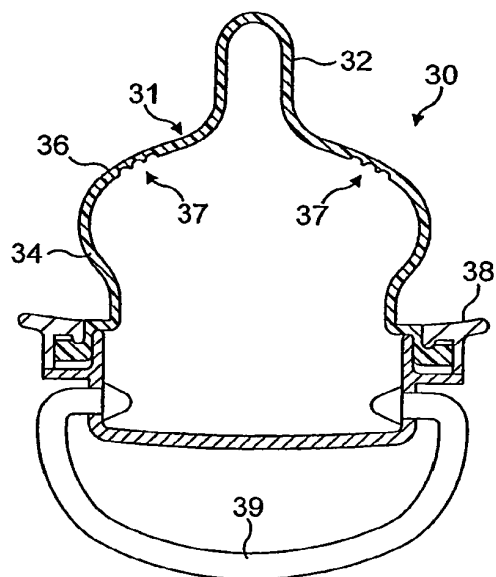


FIG. 3b

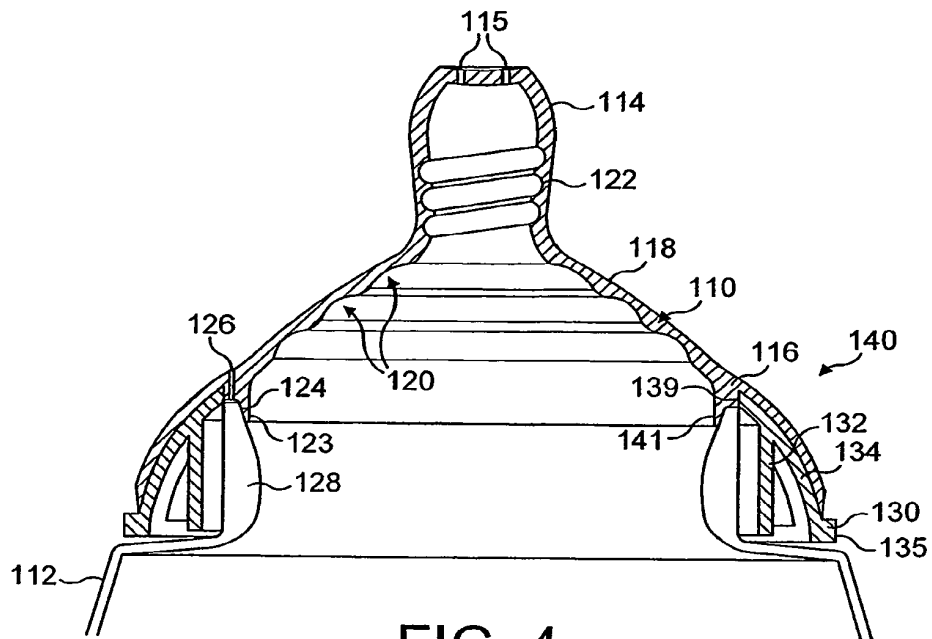


FIG. 4

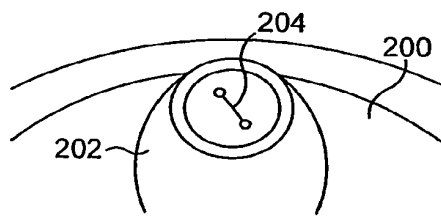


FIG. 5a

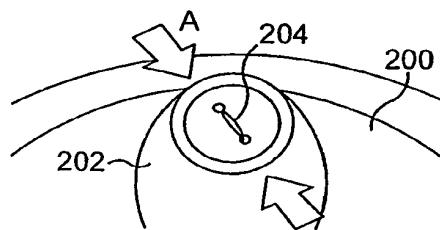


FIG. 5b

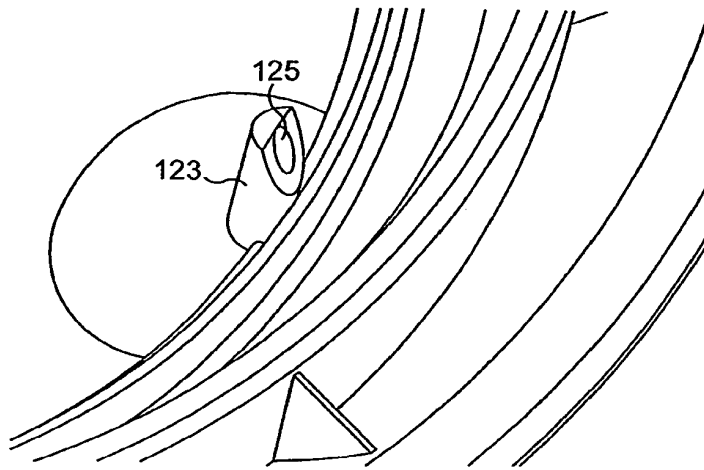


FIG. 6

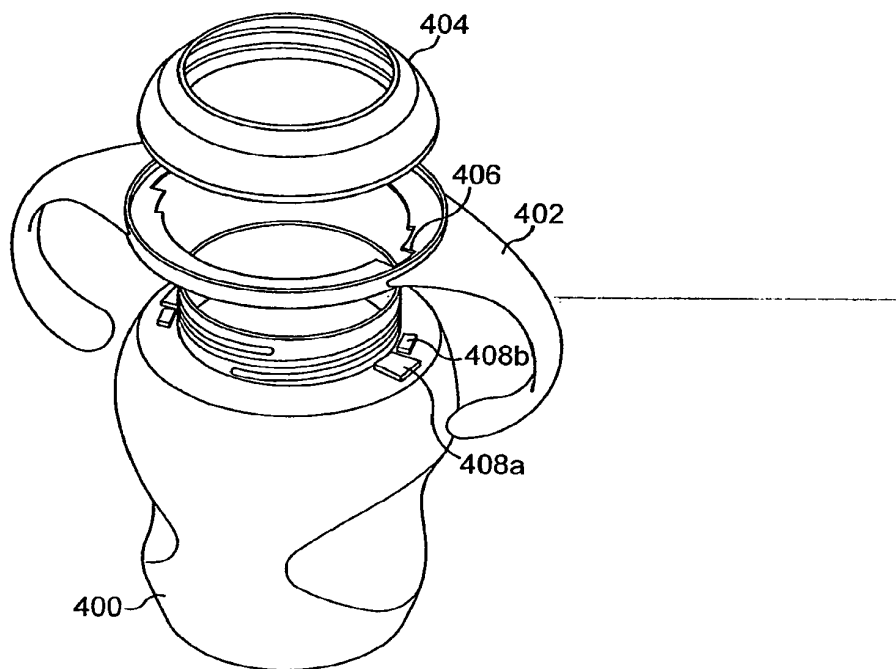


FIG. 7a

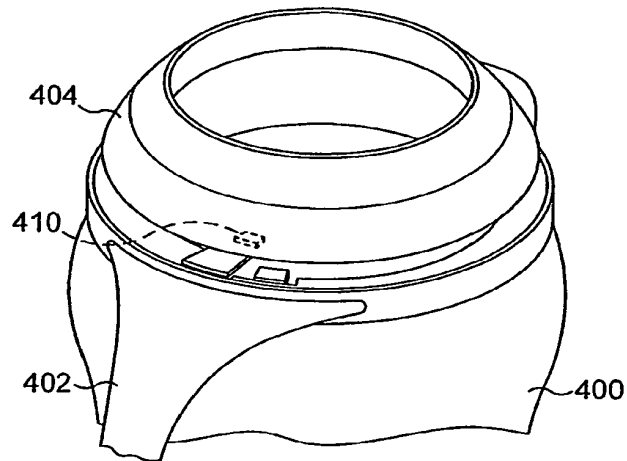


FIG. 7b

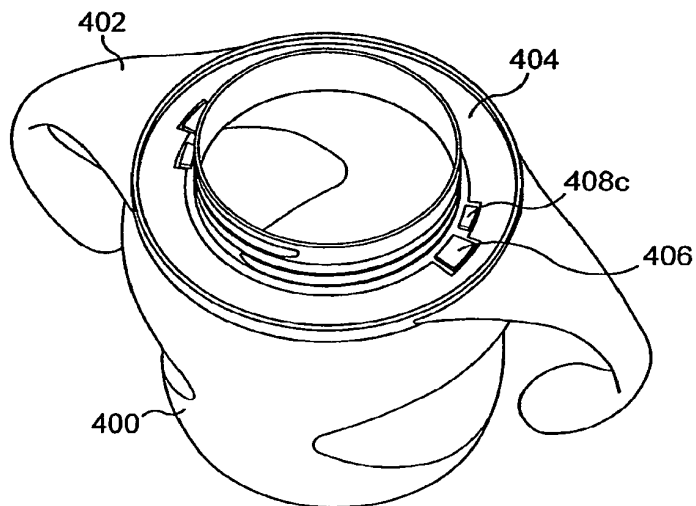


FIG. 7c

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BABY BOTTLE WITH FLEXIBLE NIPPLE REGIONS

CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a continuation of pending U.S. application Ser. No. 14/551,783 filed on Nov. 24, 2014, which is a continuation of pending U.S. application Ser. No. 13/364,557 filed on Feb. 2, 2012, which was a continuation of U.S. application Ser. No. 11/630,864 filed on Dec. 22, 2006, which was a national filing under § 371 of International Application PCT/GB2005/002532, with an international filing date of Jun. 29, 2005, claiming priority from Great Britain Application No. GB2004/14560.3, with a filing date of Jun. 29, 2004, now abandoned, and Great Britain Application No. GB2005/02599.4, with a filing date of Feb. 8, 2005, now abandoned, all of which are herein incorporated by reference.

TECHNICAL FIELD

The invention relates to a drinking vessel with a nipple, in particular a baby bottle having a nipple of increased flexibility and functionality.

BACKGROUND OF THE INVENTION

Various known teats have been designed to mimic the human breast in operation. One known teat is described in U.S. Pat. No. 6,645,228 and includes a stem and a base. The base has a bulbous region and an areola region from which the stem projects. The bulbous region has an upper region with a progressively thinning wall which acts as a spring element such that as an infant sucks on the teat the areola and stem move back and forth relative to the bulbous region.

Various problems arise with this arrangement. Movement of the areola region and stem relative to the bulbous region does not closely mimic the movement of the human breast during sucking. Furthermore because flexibility is provided upon a progressively thinning wall region, the amount of flexing and the point at which flexing takes place is undefined and unpredictable.

A second known teat is described in U.S. Pat. No. 6,745,912 B2 (Pigeon) including a series of parallel annular grooves on the inner surface of the nipple which allows stretching of the nipple but only in a constrained direction, and with the risk of flow blockage if the nipple collapses.

In addition, efforts are continuing to provide valved feeding bottles, in particular to allow air ingress to the teat. It is believed that this reduces the risk of colic which can otherwise occur as a result of negative pressure building up in the feeding bottle. Various known arrangements include slit valves of various types, however these are frail and difficult to machine. In another approach described in German patent DE19716535 a teat is provided with an inner annular resilient flange at its base which rests on a bottle rim when screwed down by a collar. Upon a negative pressure building up inside the drinking vessel the flange lifts from the vessel rim and air passes up through the collar and between the flange and the vessel rim.

In a similar arrangement described in European patent application EP151862 a teat includes a downwardly depending cylindrical flange at its base which seals against the inner top face of a vessel neck when deformed by being screwed down by a collar. Again a negative pressure inside the vessel lifts the flange away from the vessel neck so that air flows

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through the collar and between the neck and the flange into the vessel to relieve the pressure differential. Such arrangements rely on the correct amount of screw pressure being applied by the user on fixing the teat which can give rise to varied levels of valving between uses. Furthermore the introduction of a circumferential flange increases material costs.

SUMMARY OF THE INVENTION

The invention is set out in the claims. According to a first embodiment, because the flex region is provided in the areola portion allowing the teat portion and/or areola portion to move towards and away from one another a more natural feeding action is provided. Furthermore, because of the inclusion of a plurality of flex channels the point of flexure is clearly defined. According to a second embodiment, because of the provision of a helical flow formation on the inner face of the teat, continuous flow of liquid is allowed even when the teat collapses via the helical flow path while allowing extension of the teat and in particular a rotational or torsional extension. It will be understood that each of the terms “teat” and “nipple” embraces feeding bottle teats and nipples as well as soother teats and nipples, sometimes known as “baglets”.

Embodiments of the invention will now be described by way of example with reference to the drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a cross-sectional side view of a teat according to the present invention;

FIG. 2a is a side view of the teat of FIG. 1 in use in a first flexed position;

FIG. 2b is a side view of the teat of FIG. 1 in use in a second flexed position;

FIGS. 3a and 3b are end and side views respectively of a soother incorporating the teat of the present invention;

FIG. 4 is a cross-sectional side view of a teat and vessel according to another aspect of the present invention;

FIG. 5a is a perspective view showing a teat valve in a first, closed configuration;

FIG. 5b is a perspective view showing a teat valve in a second, open configuration;

FIG. 6 is a partial perspective view of the underside of the teat, showing a lip valve;

FIG. 7a is an exploded perspective view showing assembly steps for a drinking vessel according to the invention;

FIG. 7b is a perspective view showing a first detail of an assembled vessel according to the present invention; and

FIG. 7c is a perspective view showing a second detail of an assembled vessel according to the present invention.

DETAILED DESCRIPTION OF THE INVENTION

Referring firstly to FIG. 1 a teat 10 for use with a feeding bottle includes a teat portion 12, a base portion 14 and an areola portion 16 therebetween. A flange 18 extends from the base of the base portion to allow fixing to a feeding bottle (not shown) in any appropriate known manner. The base portion may also include a one-way air-inlet valve of any appropriate type for example an integrally moulded duck-bill valve (not shown). The teat has circular symmetry around an axis A running through the center of the teat.

The areola portion 16 includes a flex region 20 comprising three grooves or flex channels 22 extending around an

inner surface of the areola portion effectively forming circular thinned regions parallel/concentric with each other about the axis A and hence surrounding the teat portion. The flex region **20** is generally provided between a transition region **24** separating the base portion **14** and the areola portion **16** and a transition region **26** separating the areola portion **16** and the teat portion **12**. The flex region **20** allows flexing of the teat as described in more detail below.

The teat can be formed in any appropriate manner, for example compression or injection moulding and formed of any appropriate elastic material such as silicone, latex or thermoplastic elastomer (TPE). Injection moulded silicone provides a particularly desirable degree of elasticity in the teat portion. The teat portion **12** is preferably thinner in cross-section than the remainder of the teat or is co-moulded with a more flexible material to allow additional flexing of the teat portion relative to the teat as a whole. The teat can have a texture such as a skin-like texture moulded or otherwise patterned on to its surface.

As shown in FIGS. **2a** and **2b**, in operation an infant drinks from the teat mounted on a bottle, the infant's tongue **50** contacting the teat portion **12**, the infant's teeth or gums **52** contacting the transition portion **26** and the infant's lips **54** contacting the areola portion **16** generally at the flex region **20**. As a result, as the infant sucks on the teat, the teat portion and areola portion flex towards and away from one another by virtue of respective collapsing and extending of the flex region around the flexed channels **22**. In particular, as can be seen in FIG. **2a**, reduced suction on the teat portion **12** towards the base portion **14** relaxes the flexible reduced suction whereas, as shown in FIG. **2b**, suction on the teat portion **12** away from the base portion **14** collapses the flexible region **20** extending the teat portion and areola portion away from one another.

The back and forth motion of the teat portion **12** mimics very closely the natural movement of the human breast during suckling or sucking of the infant by effectively allowing the teat to move and stretch as skin moves and stretches. The grooves or channels further visually define an areola area and are placed at an area of the teat which is also a non-bite area. The flexible portion also provides a pumping action on liquid in the bottle as the teat portion oscillates or reciprocates back and forth.

FIGS. **3a** and **3b** show a soother **30** employing a teat or baglet **31** according to the first embodiment of the present invention. The teat **31** includes a teat portion **32**, a base portion **34** and an areola portion **36** therebetween. The teat **31** is generally hollow and is secured at the base portion **34** to a shield **38**, having a ring or handle **39**, with the areola portion **36** forming a non-bite portion of the teat **31**. A flex region **37**, is situated at the non-bite areola portion **36**, and comprises grooves or channels extending around the inner surface of the teat **31** at the areola portion **36**. As an infant sucks on the teat **31**, the teat portion **32** flexes back and forth as a result of the respective collapsing and extending of the flex region **37** grooves. As before, this back and forth movement mimics the movement of a human breast during suckling, but with the flex region in a non-bite area.

Referring to FIG. **4**, it will be seen that according to another aspect a teat assembly **140** is mounted on an infant drinking vessel **112**. The teat assembly **140** includes a teat **110** having a teat portion **114** forming a nipple having drink apertures **115** at its upper end, a base portion **116** mountable to the drinking vessel and an areola region **118** therebetween. The teat **110** is textured and shaped to mimic the human breast and can, for example have skin-like texture varying between the teat portion, areola region and base

portion, similar to the human breast. The teat can indeed be coloured to mirror human skin colour including ethnic skin colours. The shape of the teat is also similar to the human breast, the base portion **116** being shaped like a breast and having a wide, domed configuration. The areola portion **118** rises from the base portion **116** to the teat portion **114** at an angle to the horizontal, that is to say, with a component of inclination parallel to the teat portion **114**, allowing better pursing by the infant so that they can close their lips effectively around the teat, and again mimicking the human breast such that the experience of the infant is as similar as possible to the natural experience of breast feeding.

The teat **110** is formed from an elastomer with walls of decreasing thickness from the base portion **116** through to the teat **114** providing a more realistic flexing characteristic. The areola portion **118** further includes undulating grooves **120** forming, in cross-section, a wavy profile on the inner surface of the areola portion **118** and extending circumferentially. In the embodiments shown three such grooves are formed adjacent one another providing a bellows action as well as flexing in a direction perpendicular to the flow direction and increasing the flexibility especially in conjunction with the decreasing wall thickness providing a more natural stretching characteristic and sensory feedback to the infant. Yet further, the teat can be textured on its outer and/or inner surface to enhance operation or realism of the teat as appropriate.

The teat portion **114** projects generally perpendicular to the mouth of the vessel **112** and is elongate for example of length 20 mm, again to mimic the extension of the human nipple during breast feeding. The teat portion has a generally rectangular cross-section with wall thickness 1.8 mm and diameter 13 mm. A tight pitch helical groove **122** of groove depth 0.9 mm (half the wall thickness) having for example three turns and 3 mm pitch is moulded or otherwise formed around the inner cylindrical vertical surface of the teat portion **114** to form a flow passage even when the teat portion is collapsed, for example under biting pressure from an infant. In addition the helical groove allows rotational or torsional compression and extension of the teat portion in the range of 5-6 mm and flexing parallel perpendicular to the flow direction, again more closely mimicking the human breast.

At the tip of the teat portion the apertures **115** comprise a variable flow valve, where the flow can either be selected by choosing a teat with appropriate apertures or a two or three crossed slit configuration can be provided allowing the infant to regulate flow. For example referring to FIGS. **5a** and **5b**, a teat **200** includes a teat portion **202** with a slit valve **204**. As can be seen from FIG. **5b** when pressure is applied in the longitudinal direction of the slit, for example bite pressure, the slit valve opens allowing fluid flow by application of compression and distortion pressure.

The teat assembly **140** is formed in a two-shot moulding process with elastomer forming the teat **110** and polypropylene forming a screw collar **130** which is integrally formed with the teat **110**. As a result a resilient, cheaply and easily manufactured integral assembly is provided.

The screw collar **130** includes an internally threaded cylindrical portion **132** and a downwardly domed peripheral portion **134** surrounding it and extending from an upper end of the cylindrical portion **132**. The domed portion **134** includes a horizontal outward annular flange **135** of thicker cross-section at its base. The teat **110** is over-moulded onto the screw collar **130** and the domed portion **134** terminates at a central circular orifice corresponding with an outer face of the neck **128** of the vessel **112**, the over-moulded portion

of the teat extending inwardly slightly from this position and terminating in a downwardly depending cylindrical flange 141.

As a result the screw collar provides structural strength and a strong screw fit, but the resilient material of the teat portion 140 provides sealing. In particular the threaded cylindrical portion 132 of the screw collar screws on to the outwardly threaded neck 128 of the vessel 112 and the top, innermost edge of the domed portion 134 abuts the outer face of the neck 128. Because the teat material 110 overhangs the inner edge 139 of the domed portion 134, when the teat assembly 140 is screwed down, the overhanging portion seals against the top rim of the neck 128 and the downward cylindrical flange 141 forms an elastomer sealing ring sealing against the top inner face of the vessel neck 128. The teat 110 includes a vent passage 126 through the elastomer material and substantially at the periphery. A discontinuous flap or lip valve portion 123 projects down from the flange 141 in a portion of the periphery only in the vicinity of the vent passage 126.

Because of the resilience of the flange portion, when an infant sucks on the teat, reducing pressure within the vessel, the lip valve 123 will flex away from the neck 128 of the vessel 112. In the region of the vent 126 in the teat 110, this allows venting between the interior of the vessel and atmosphere through the teat. Referring to FIG. 6 the lip valve 123 can be seen viewed from the underside. In the embodiment shown it will be seen that a passage 125 actually passes through the lip valve, communicating with the vent passage 126. In that case the aperture to the passage 125 will seal against the inner face of the vessel in the sealed configuration and unseal to provide a passage.

Alternatively a slit valve 124 can comprise a flap which flexes away from the interior surface to allow communication with a vent passage as described above.

The teat assembly 140 also has a positive engagement stop providing tactile feedback to ensure that the teat assembly is correctly tightened on the vessel and allows the lip valve to seal effectively. Referring to FIGS. 7a to 7c, for example, it will be seen that a vessel 400 receives a handle portion 402 and a teat screw collar 404, corresponding to the screw collar 130 described above but with the elastomer teat 10 removed for the purposes of clarity of understanding.

The handle portion 402 includes a cut-out portion 406 which cooperates with projections 408a, 408b on the vessel to locate the handle portion in a predetermined position. The handle portion is placed over the vessel and located in the desired orientation and then the collar 404, including an internal thread portion allowing mounting on the vessel 400 is screwed into position as described above, securing the handle portion 402 in place.

As can best be seen in FIG. 7b, the collar portion 404 includes an internal lug 410 which projects inwardly from the inner face and engages against a stop feature on the screw threaded portion of the vessel 400 formed by the projections 408a, 408b such that the teat 110 "clicks" into a desired position. As a result a controlled compression on the lip valve 123 is obtained such that a consistent and repeatable valving action is obtained on each use. In particular the projections 408a, 408b are separated by a recess, 408c best seen in FIG. 7c. When the collar 404 is screwed into place the lug 410 passes over the projection 408b which has a ramp towards the recess 408c. After the lug 410 has ridden up the ramp it drops into the recess 408c and is obstructed from further movement by the planar face of the projection 408a. The lug 410 further prevents the collar 404 from being unscrewed by virtue of its engagement with the abutting face

of the projection 408b. However the lug 410 and projection 408b have chamfered or radiused abutting faces such that, on application of sufficient unscrewing pressure, the lug 410 rides over the chamfered face of the projection 408b and then down the ramp allowing the collar to be fully unscrewed.

In operation the vessel is filled with drinking liquid and the teat assembly 140 is screwed on until positive engagement is detected (for example a discernable "click") meaning that it is correctly fitted. When the infant then drinks from the vessel the pressure difference pulls the lip valve 123 away from the inner face of the neck 128 of the vessel 112 allowing venting through vent passage 126 and hence reducing the risk of colic. Because of the provision of the lip valve there is no requirement for providing slits and a natural, robust and resilient valve assembly is provided. Furthermore, the valve is formed during the moulding operation and requires no secondary operation for its formation providing commercial and manufacturing benefits. Yet further as a single vent passage is provided at one point on the teat, the risk of leakage is reduced, especially as the vent passes through the teat rather than around the vessel neck.

It will be appreciated that the teat can be formed of any material and can be any appropriate shape which may be, for example, non-symmetrical such as a shaped or orthodontic teat or even more closely mimicking the shape of the human breast. Different teat configurations can be provided to grow with different ages of infant. For example the teat portion can be made progressively longer as the age of the infant who will be using the teat increases and/or the texture can be made less prominent, for example ranging from coarse for new-borns through fine to gloss.

In the teat of the first embodiment, the flex channels in the flex region can be of any appropriate profile for example square, semi-circular or triangular in cross-section and can be provided on the inner or outer surface of the teat and in any appropriate number. Instead of providing thinned regions the flexed channels can be formed by a concertina or bellows configurations moulded into the teat or any other appropriate hinge or fold mechanism. Furthermore features of either the first or second embodiment can be interchanged or juxtaposed with one another or implemented in other types of drinking vessel cover as appropriate. For example the lip valve can be implemented in a trainer cup cover, a sports bottle or other vessel closures capable of forming a partial vacuum in a vessel in use.

It will be appreciated that whilst the Figures show a soother comprising a teat of the first embodiment, the invention also encompasses a soother comprising a teat of the second embodiment. The soother comprising the teat and shield/ring components can be formed from any appropriate material. For example, the teat can be formed from silicone, latex or Thermoplastic Elastomer (TPE), whilst the shield and ring can be formed from thermoplastic materials such as polypropylene PP, polycarbonate PC or similar material blends as appropriate. Furthermore, the soother can be manufactured by any appropriate moulding method.

What is claimed is:

1. A feeding vessel, comprising:

a container comprising:

- i. a threaded upper portion with an opening into the interior of the container,
- ii. a middle portion below the upper portion, and
- iii. a bottom portion below the middle portion, wherein the middle portion is tapered inward; and

an assembly configured to mount over the opening of the container, the assembly comprising:

- i. a nipple having a base, a teat portion with an aperture, an areola portion between the teat portion and the base, and a flange depending from the base defining the nipple circumference furthest from the aperture, wherein the teat portion defines a bite region and the areola portion defines a flex region configured to allow the teat portion to flex towards and away from the areola portion, and
- ii. a collar configured to removably couple to the nipple to seal the container; and

wherein the collar and the base of the nipple together define a downward domed shape that extends outwardly and downwardly between the flex region of the nipple and a widest circumferential edge of the collar.

2. The feeding vessel of claim 1, wherein the container is a baby bottle container.

3. The feeding vessel of claim 1, wherein the internal circumference of the container below the upper portion increases towards the opening.

4. The feeding vessel of claim 1, wherein the assembly comprises removable handles.

5. The feeding vessel of claim 1, wherein the collar comprises threads configured to couple to corresponding threads of the container.

6. The feeding vessel of claim 1, wherein a largest outer diameter of the domed shape is greater than a diameter of the opening of the container.

7. The feeding vessel of claim 1, wherein the flex region comprises a plurality of grooves in an inward facing surface of the nipple configured to enable the teat portion and areola portion to flex towards and away from one another by respective collapsing and extending of the flex region in the grooves.

8. The feeding vessel of claim 7, wherein the grooves are circumferential.

9. The feeding vessel of claim 7, wherein the flex region further comprises a thinned circumferential region in the inward facing surface of the nipple.

10. The feeding vessel of claim 1, wherein the nipple comprises an air vent apart from the aperture.

11. The feeding vessel of claim 10, wherein the air vent is located in the lower portion of the nipple.

12. The feeding vessel of claim 11, wherein the air vent is located proximate the collar when the collar is coupled to the nipple.

13. The feeding vessel of claim 10, wherein the air vent is an integrally molded duck-bill valve.

14. The feeding vessel of claim 10, wherein the air vent projects into the interior of the container.

15. The feeding vessel of claim 1, wherein teat portion has circular symmetry around a central axis.

16. The feeding vessel of claim 1, wherein the domed shape is continuous.

17. The feeding vessel of claim 1, wherein an exterior of the teat portion is textured.

18. The feeding vessel of claim 1, wherein a circumference of the nipple base is greater than the container opening and configured to overlap the opening and provide an air tight seal.

19. The feeding vessel of claim 1, wherein the middle portion of the container comprises two indentations.

20. The feeding vessel of claim 1, wherein the flange comprises a downwardly extending skirt around its circumference.

21. A drinking vessel comprising:

a container comprising a varying internal circumference and an opening into the container; and

a cover assembly configured to couple to the container over the opening, the cover assembly comprising:

- i. a nipple comprising a mouthpiece configured to allow liquid flow through the nipple to an aperture, a flex region configured to allow flex of the mouthpiece towards and away from a lower portion of the nipple, the mouthpiece defining a bite region, and a flange depending from the lower portion of the nipple defining the nipple circumference furthest from the aperture; and

- ii. a collar configured to removably couple to the nipple to seal over the opening of the container; and

wherein the collar and the lower portion of the nipple together define a downward domed shape that extends outwardly and downwardly from the flex region of the nipple towards a widest circumferential edge of the collar.

22. The drinking vessel of claim 21, wherein the container is a trainer cup.

23. The drinking vessel of claim 21, wherein the container comprises a material more rigid than the nipple material.

24. The drinking vessel of claim 21, wherein the cover assembly further comprises an air vent apart from the mouthpiece.

25. The drinking vessel of claim 21, wherein the cover assembly further comprises removable handles.

26. The drinking vessel of claim 21, wherein the mouthpiece is located in the center of the nipple.

27. The drinking vessel of claim 21, wherein the teat portion comprises a resilient material.

28. The drinking vessel of claim 21, wherein the bite region comprises a groove in an inward facing surface of the nipple configured to pass fluid through the bite region when the bite region is collapsed.

29. The drinking vessel of claim 21, wherein the bite region further comprises a thinned region in the inward facing surface of the nipple.

30. A feeding vessel, comprising:

a container comprising:

- i. a threaded neck portion with an opening into the interior of the container,
- ii. a body portion having
 1. an upper body portion,
 2. a middle body portion below the upper body portion, and
 3. a bottom body portion below the middle body portion, wherein the middle body portion has a smaller horizontal cross-section than a horizontal cross-section of both the upper body portion and the bottom body portion; and

an assembly configured to mount over and surround the threaded neck portion, the assembly comprising:

- i. a nipple having a teat portion with an aperture, an areola portion with an outer surface extending downwardly and outwardly from the teat portion, and a flange depending from the base defining the nipple circumference furthest from the aperture, wherein the teat portion defines a bite region and the areola portion defines a flex region configured to allow the teat portion to flex towards and away from the areola portion, and

- ii. a base portion positioned below said areola portion and comprising a threaded collar adapted to threadably engage with said threaded neck portion and

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removably couple to the nipple to seal over the opening of the container; and
 wherein the nipple has an outer surface of elastomeric material that extends from the teat portion to a portion below said areola portion and that is substantially rotationally symmetric about the central vertical axis of said assembly and has a circumference that continuously and smoothly decreases from a position on said outer surface that is below the areola portion and has a substantially vertical slope to at least a position on said teat portion that has a substantially vertical slope.

31. A feeding vessel, comprising:

a container comprising:

- i. a threaded neck portion with an opening into the interior of the container,
- ii. a body portion having
 1. an upper body portion,
 2. a middle body portion below the upper body portion, and
 3. a bottom body portion below the middle body portion,

wherein the middle body portion has a smaller horizontal cross-section than horizontal cross-section of both the upper body portion and the bottom body portion; and

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an assembly configured to mount over and surround the threaded neck portion, the assembly comprising:

- i. a nipple having a teat portion with an aperture, and an areola portion with an outer surface extending downwardly and outwardly from the teat portion, and a flange depending from the base defining the nipple circumference furthest from the aperture, wherein the teat portion defines a bite region and the areola portion defines a flex region configured to allow the teat portion to flex towards and away from the areola portion, and
- ii. a base portion positioned below said areola portion and comprising a screw collar adapted to threadably engage with said threaded neck portion and removably couple to the nipple to seal over the opening of the container; and

wherein the assembly has an outer surface extending from the teat portion to the base portion that is substantially rotationally symmetric about the central vertical axis of said assembly and has a circumference that continuously and smoothly decreases from a position on said base portion having a substantially vertical slope to a position on said teat portion having a substantially vertical slope.

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