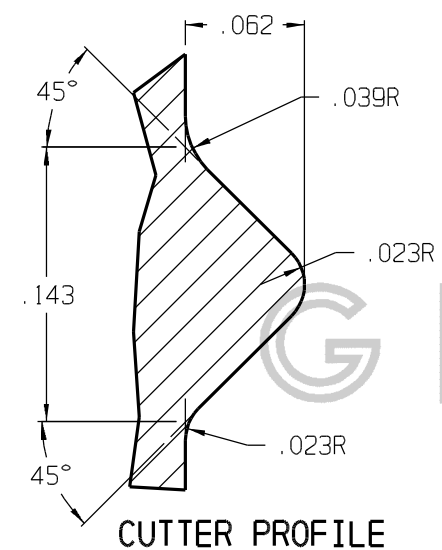
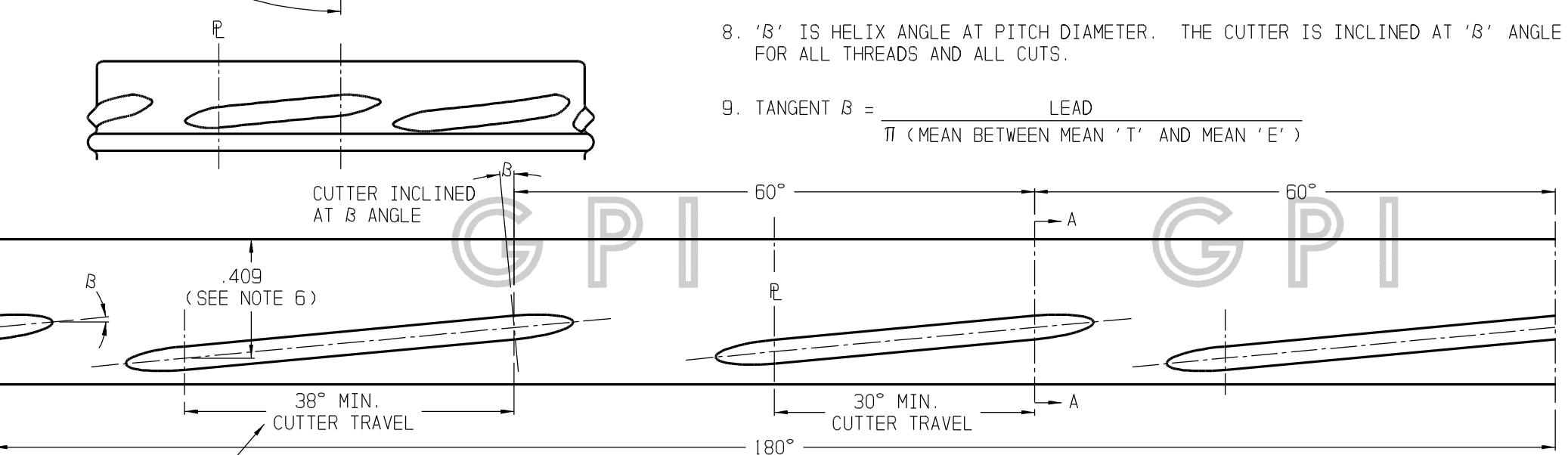
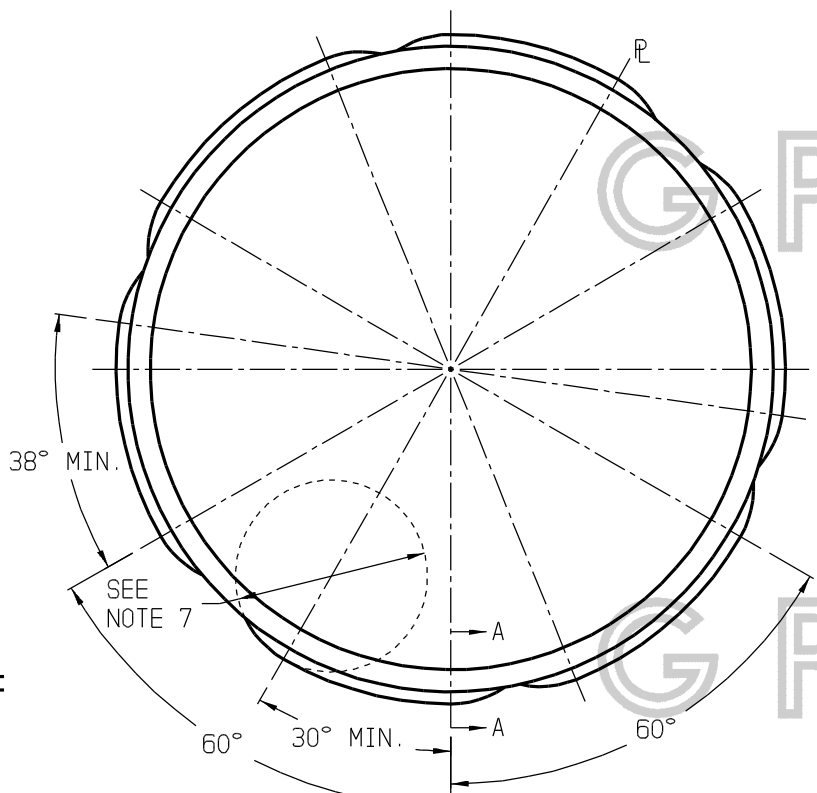
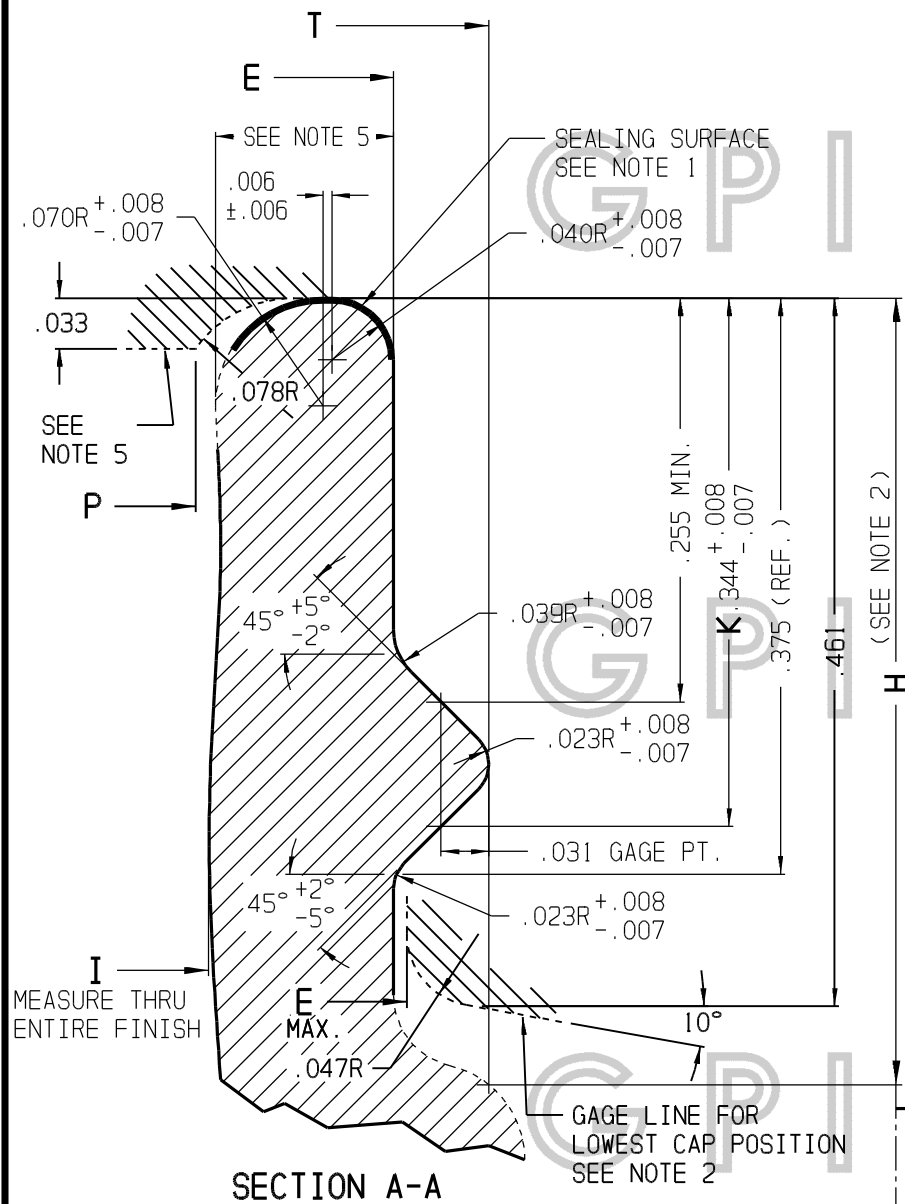


SIZE	E		T		I MIN.	P	B	T.P.I.
	IDEAL	TOL.	IDEAL	TOL.				
89	3.363	+0.017 -.018	3.487	+0.017 -.018	2.781	3.105	5° 19'	1



1. THIS IS A TOP SEAL FINISH AND PROPER FUNCTION OF CLOSURE REQUIRES THAT THE SEALING SURFACE MUST BE SMOOTH AND FREE OF IRREGULARITIES THAT WOULD PREVENT A VACUUM SEAL BEING MADE, OR INTERFERE WITH ROTATION OF CLOSURE.
2. DOTTED CONTOUR IS OPTIONAL, BUT MUST CLEAR CAP LIMITS SHOWN BY SHADED AREA ABOVE .461 DIMENSION.
3. WHEN 'E' AND 'T' DIAMETERS ARE AT MAXIMUM, THEY MUST BE CONCENTRIC TO PREVENT POSSIBLE INTERFERENCE DURING CAP APPLICATION.
4. SIX LEAD THREAD - ONE THREAD PER INCH. 30° MINIMUM TRAVEL ON PARTING LINE THREADS. 38° MINIMUM TRAVEL ON THE OTHER FOUR LEADS.
5. SHADED SECTION SHOWS CLOSURE POSITION. TOP RING CONTOUR AT THIS SECTION MUST CLEAR THE LIMITS SPECIFIED.
6. FOR PROPER CLOSURE CAM-OFF, MAINTAIN 'T' DIAMETER TO A DEPTH OF .409 INCHES. BELOW .409, 'T' DIAMETER MAY BE BELOW MINIMUM BUT NOT OVER MAXIMUM.
7. START AND END OF THREADS CONFORM TO 1" CUTTER DIAMETER EXCEPT WHERE RIFFLING IS REQUIRED TO PERMIT MOLD OPENING.
8. 'B' IS HELIX ANGLE AT PITCH DIAMETER. THE CUTTER IS INCLINED AT 'B' ANGLE FOR ALL THREADS AND ALL CUTS.
9. $TANGENT B = \frac{LEAD}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$

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Edward A. Grant CHAIRMAN	PRINTED AND DISTRIBUTED AS A VOLUNTARY STANDARD BY GLASS PACKAGING INSTITUTE SUBCOMMITTEE ON DESIGN AND SPECIFICATIONS	APPROVED FOR PUBLICATION 02-05-99	SUPERSEDES DWG. NO. 20504
GLASS FINISH NUMBER 2050		GPI DWG. NO.	
TOP SEAL VACUUM LUG FINISH, SIZE 89 (6 LEADS)		20505	