



SIZE	E		T		I MIN.	P	B	T.P.I.
	IDEAL	TOL.	IDEAL	TOL.				
100	3.784	+ .017 - .018	3.908	+ .017 - .018	2.969	3.456	4° 45'	1

1. THIS IS A TOP SEAL FINISH AND PROPER FUNCTION OF CLOSURE REQUIRES THAT THE SEALING SURFACE MUST BE SMOOTH AND FREE OF CRIZZLES, CHECKS, DIPS AND OTHER SUCH 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 .540 DIMENSION.
3. WHEN 'E' AND 'T' DIAMETERS ARE AT MAXIMUM, THEY MUST BE CONCENTRIC TO PREVENT POSSIBLE INTERFERENCE DURING CAP APPLICATION.
4. 'B' IS HELIX ANGLE AT PITCH DIAMETER. THE CUTTER IS INCLINED AT 'B' ANGLE.
5. SIX LEAD THREAD - ONE THREAD PER INCH. 30° MINIMUM TRAVEL ON PARTING LINE THREADS. 38° MINIMUM TRAVEL ON THE OTHER FOUR LEADS.
6. SHADED SECTION SHOWS CLOSURE POSITION. TOP RING CONTOUR AT THIS SECTION MUST CLEAR THE LIMITS SPECIFIED.
7. MAINTAIN 'T' DIAMETER TO A DEPTH OF .480. FROM .480 TO .540, 'T' DIAMETER MAY BE BELOW MINIMUM BUT NOT OVER MAXIMUM.
8. START AND END OF THREADS CONFORM TO 1" CUTTER DIAMETER EXCEPT WHERE RIFFLING IS REQUIRED TO PERMIT MOLD OPENING.
9. $TANGENT\ B = \frac{LEAD}{\pi (MEAN\ BETWEEN\ MEAN\ 'T'\ AND\ MEAN\ 'E')}$

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GLASS FINISH NUMBER 2055		GPI DWG. NO.	
TOP SEAL VACUUM LUG FINISH, SIZE 100, (6 LEAD)		20551	