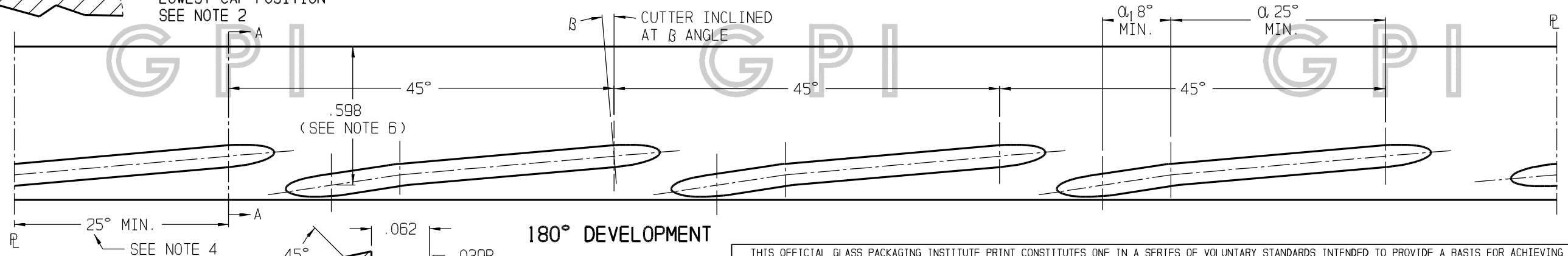


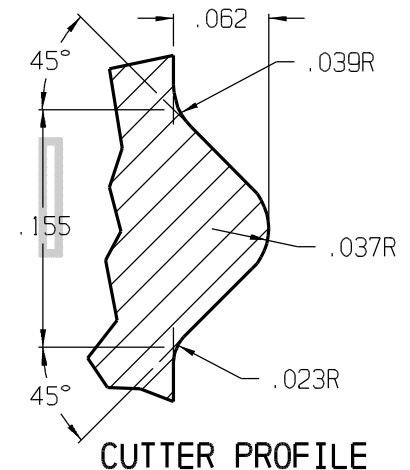
SIZE	E		T		I MIN.	P	B	T.P.I.	
	IDEAL	TOL.	IDEAL	TOL.				α	α ₁
110	4.141	±.025	4.265	±.025	3.500	3.871	4° 57'	.875	.500

- 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.
- DOTTED CONTOUR IS OPTIONAL, BUT MUST CLEAR CAP LIMITS SHOWN BY SHADED AREA ABOVE .647 DIMENSION.
- WHEN 'E' AND 'T' DIAMETERS ARE AT MAXIMUM, THEY MUST BE CONCENTRIC TO PREVENT POSSIBLE INTERFERENCE DURING CAP APPLICATION.
- EIGHT LEAD THREAD - .875 THREADS PER INCH. ALL THREADS ARE 25° MIN. α TRAVEL AT .875 THREADS PER INCH FOR SEALING. 6 CAM-OFF THREADS ARE 25° MIN. α TRAVEL AT .875 THREADS PER INCH, THEN CHANGE TO .5 THREADS PER INCH FOR 8° MIN. α₁ TRAVEL HOLDING CUTTER INCLINATION AT β ANGLE.
- SHADED SECTION SHOWS CLOSURE POSITION. TOP RING CONTOUR AT THIS SECTION MUST CLEAR THE LIMITS SPECIFIED.
- FOR PROPER CLOSURE CAM-OFF, MAINTAIN 'T' DIAMETER TO A DEPTH OF .598 INCHES. BELOW .598, 'T' DIAMETER MAY BE BELOW MINIMUM BUT NOT OVER MAXIMUM.
- START AND END OF THREADS CONFORM TO 1" CUTTER DIAMETER EXCEPT WHERE RIFFLING IS REQUIRED TO PERMIT MOLD OPENING.
- 'B' IS HELIX ANGLE AT PITCH DIAMETER. THE CUTTER IS INCLINED AT 'B' ANGLE FOR ALL THREADS AND ALL CUTS.
- TANGENT $B = \frac{\text{LEAD}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$

SECTION A-A



180° DEVELOPMENT



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GLASS FINISH NUMBER 2070		GPI DWG. NO.	
TOP SEAL VACUUM LUG FINISH, SIZE 110 (8 LEADS)		20705	