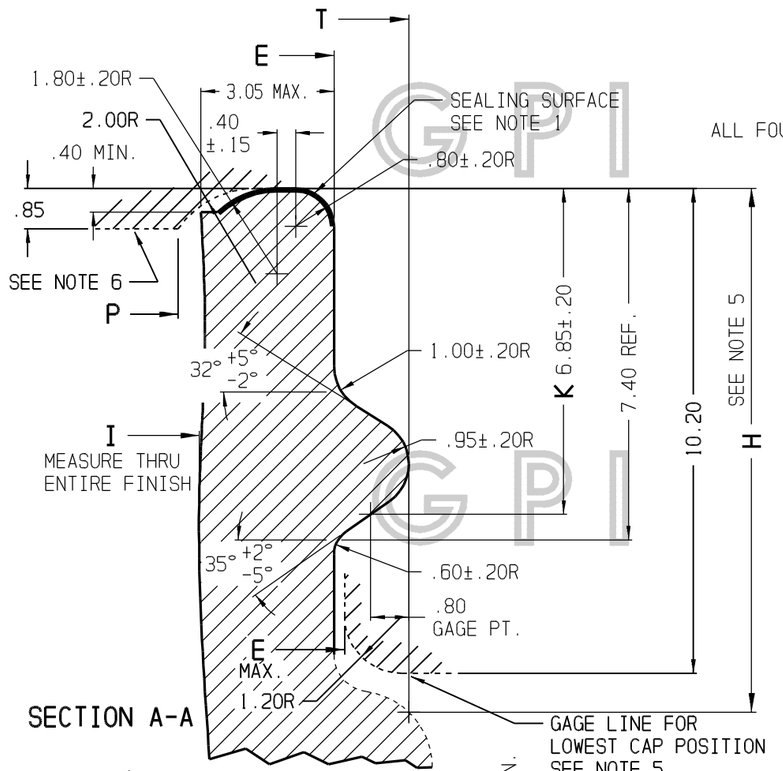
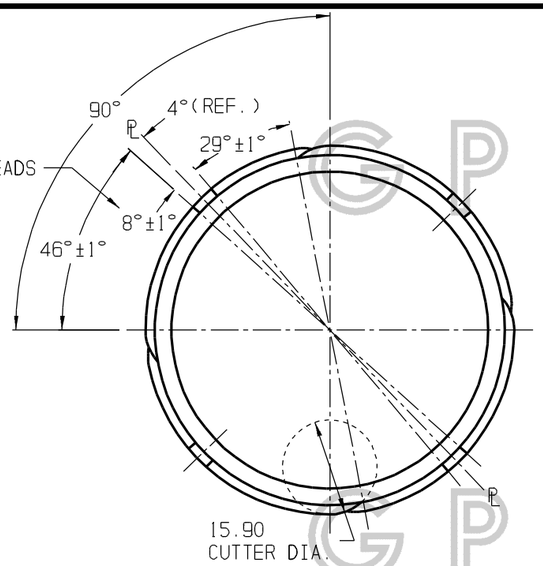
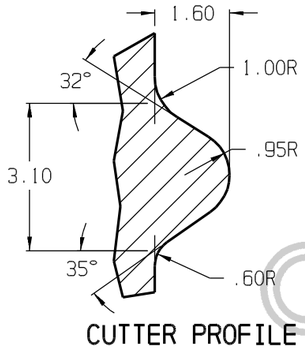
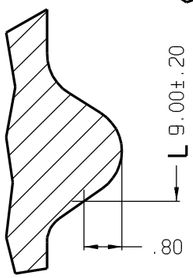
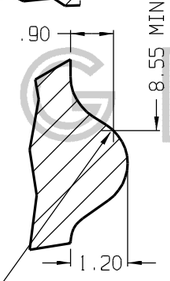
FM-20304

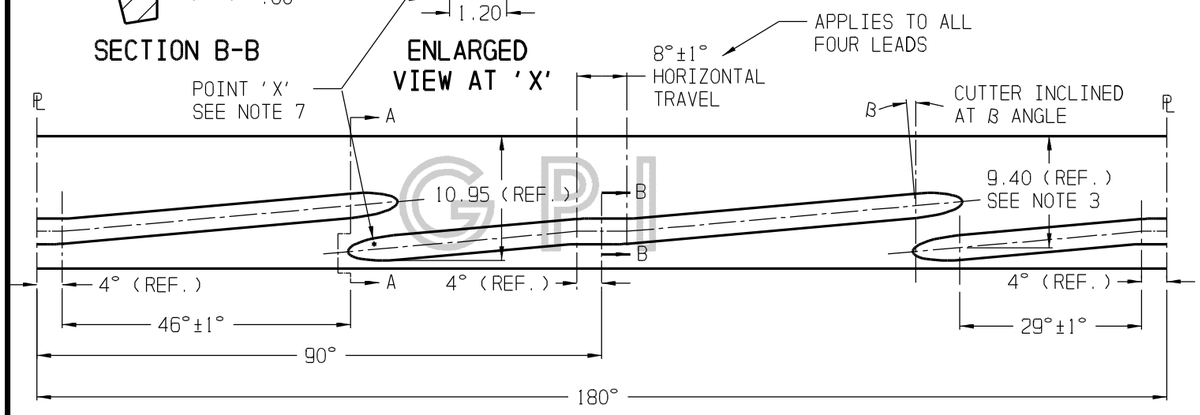












SIZE	E SEE NOTE 2		T SEE NOTE 2		I	P	ß	T.P.I.	LEAD
	IDEAL	TOL.	IDEAL	TOL.	MIN.	SEE NOTE 6			
63	58.90	±.45	62.05	±.45	46.45	52.35	5° 06′	1.50	16.95
66	61.80	±.45	64.95	±.45	49.20	55.25	4° 52′	1.50	16.95
70	65.80	±.45	68.95	±.45	53.20	59.25	4° 34′	1.50	16.95
77	72.50	±.45	75.65	±.45	59.95	65.95	4° 10′	1.50	16.95

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. VARIATION OF .40 FLAT SHOULD NOT EXCEED CURVATURE OF A 2.35 RADIUS.

2. BEST SEALING RESULTS ARE OBTAINED WHEN GLASS FINISH IS ROUND AND TO THE DIAMETERS SHOWN IN COLUMNS HEADED "IDEAL." THE AVERAGE OF THE MAXIMUM AND MINIMUM EXTREMES OF THE 'E' AND 'T' DIAMETERS SHOULD BE AS CLOSE AS POSSIBLE TO DIMENSIONS SHOWN IN COLUMNS HEADED "IDEAL."

3. 'T' DIAMETER MUST BE MAINTAINED THROUGHOUT THREAD TRAVEL. REF. DEPTH 9.40

4. CONSTRUCTION IS IDENTICAL FOR ALL FOUR THREADS.

5. DOTTED CONTOUR IS OPTIONAL, BUT MUST CLEAR CAP LIMITS SHOWN BY SHADED AREA ABOVE 10.20 DIMENSION.

6. SHADED AREA SHOWS CONTOUR TO BE CLEARED BY THE TOP OF THE GLASS FINISH FOR CORRECT SEALING RESULTS.

7. IN ORDER TO PROVIDE CAM-OFF ACTION FOR CAP REMOVAL TOP SURFACE OF TWO OPPOSING THREADS FROM POINT 'X' UPWARD ALONG HELIX ANGLE SHOULD BE SMOOTH AND SUBSTANTIALLY FILLED.

8. 'ß' IS HELIX ANGLE AT PITCH DIAMETER. THE CUTTER IS INCLINED AT 'ß' ANGLE FOR ALL THREADS AND ALL CUTS.

9. TANGENT $\beta = \frac{\text{LEAD}}{\pi\ (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$

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	GLASS FINISH NUMBER 2030M	GPI DWG. NO. FM-20304	
METRIC TOP SEAL VACUUM LUG FINISH, SIZES 63 THROUGH 77 (4 LEADS)			