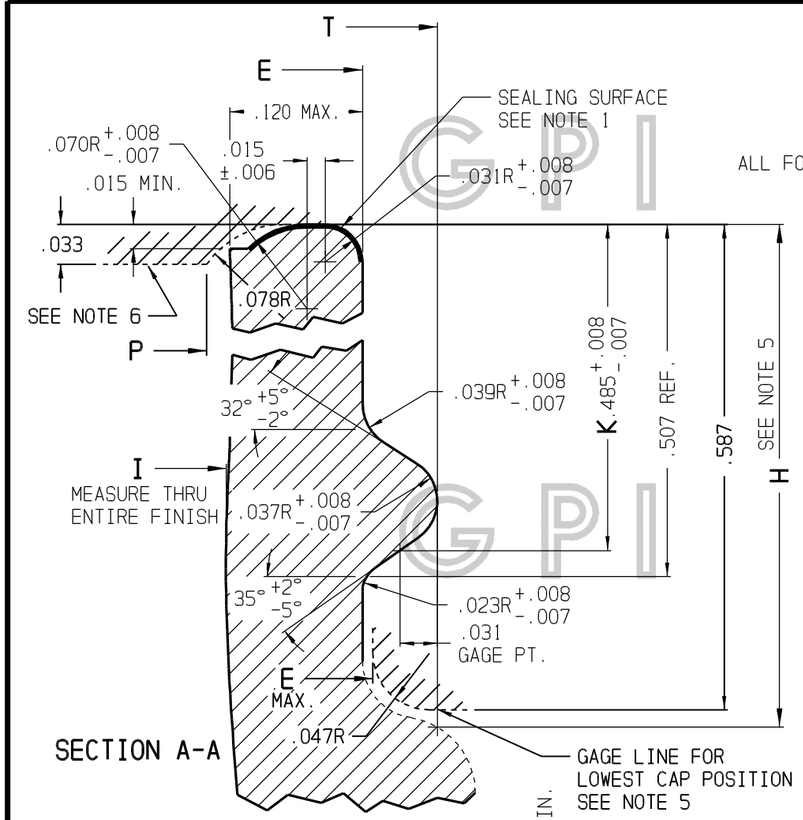
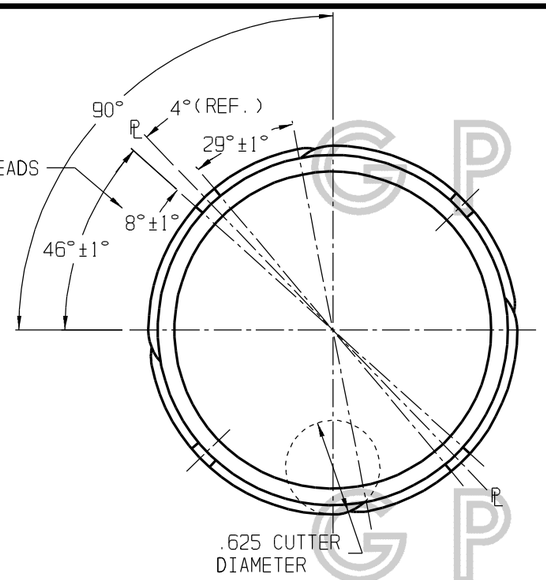
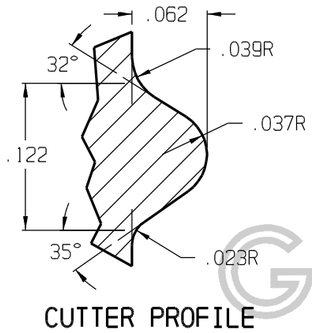
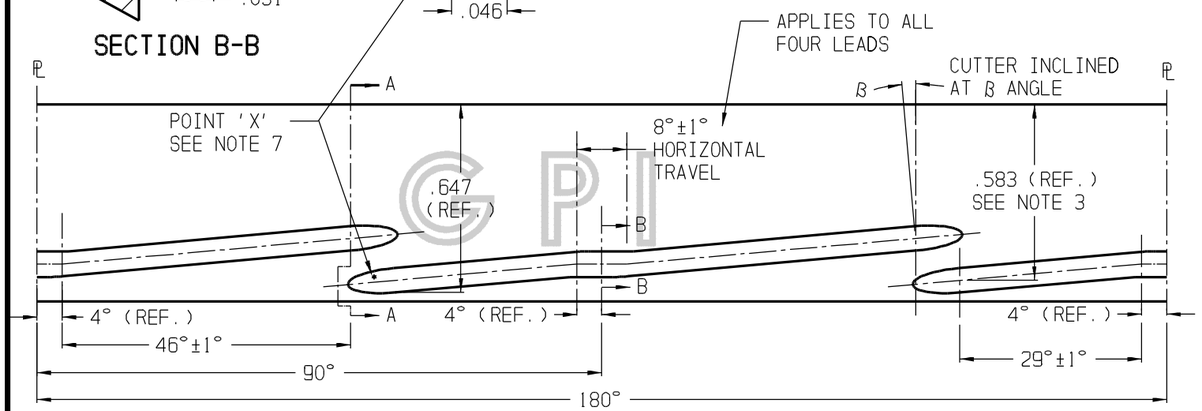
20351




| SIZE | E SEE NOTE 2 IDEAL | E SEE NOTE 2 TOL. | T SEE NOTE 2 IDEAL | T SEE NOTE 2 TOL. | I MIN. | P SEE NOTE 6 | β | T.P.I. |
|---|---|---|---|---|---|---|---|---|
| 63 | 2.320 | +.017 -.018 | 2.444 | +.017 -.018 | 1.828 | 2.062 | 5° 05′ | 1.50 |
| 66 | 2.433 | +.017 -.018 | 2.557 | +.017 -.018 | 1.937 | 2.175 | 4° 52′ | 1.50 |
| 70 | 2.591 | +.017 -.018 | 2.715 | +.017 -.018 | 2.093 | 2.333 | 4° 34′ | 1.50 |

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 .015 FLAT SHOULD NOT EXCEED CURVATURE OF A .093 RADIUS.

2. PROPER FUNCTION OF CLOSURE REQUIRES THAT THE "T" AND "E" DIAMETERS BE AS LITTLE OUT OF ROUND AS POSSIBLE AND BE AS CLOSE TO "IDEAL" AS POSSIBLE. THE AVERAGE OF THE MAXIMUM AND MINIMUM DIAMETERS OF THE "T" AND "E" SHOULD ALSO BE AS CLOSE TO "IDEAL" AS POSSIBLE.

3. 'T' DIAMETER MUST BE MAINTAINED THROUGHOUT THREAD TRAVEL. REF. DEPTH .583

4. CONSTRUCTION IS IDENTICAL FOR ALL FOUR THREADS.

5. DOTTED CONTOUR IS OPTIONAL, BUT MUST CLEAR CAP LIMITS SHOWN BY CROSS-HATCHED AREA ABOVE .587 DIMENSION.

6. CROSS-HATCHED 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. 'β' IS HELIX ANGLE AT PITCH DIAMETER. THE CUTTER IS INCLINED AT 'β' ANGLE FOR ALL THREADS AND ALL CUTS.

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

10. THIS FINISH IS IDENTICAL TO GPI 2030 EXCEPT FOR THE .215 INCREASE IN HEIGHT.

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| Edward A. Grant, CHAIRMAN | PRINTED AND DISTRIBUTED AS A VOLUNTARY STANDARD BY GLASS PACKAGING INSTITUTE, COMMITTEE ON DESIGN AND SPECIFICATIONS | APPROVED FOR PUBLICATION 02-05-99 | SUPERSEDES DWG. NO. 20350 |
| | GLASS FINISH NUMBER 2035 | GPI DWG. NO. 20351 | |

TOP SEAL VACUUM LUG DEEP FINISH, SIZES 63,66 & 70 (4 LEADS)