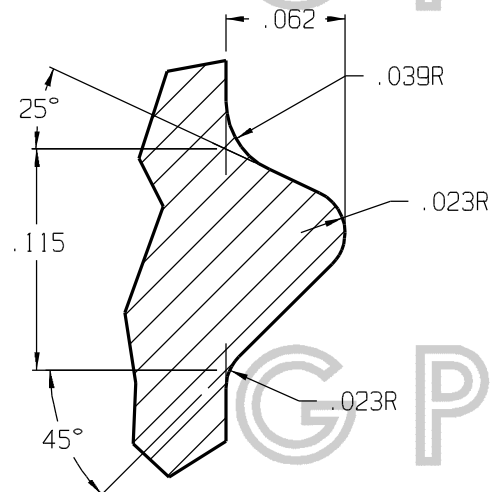
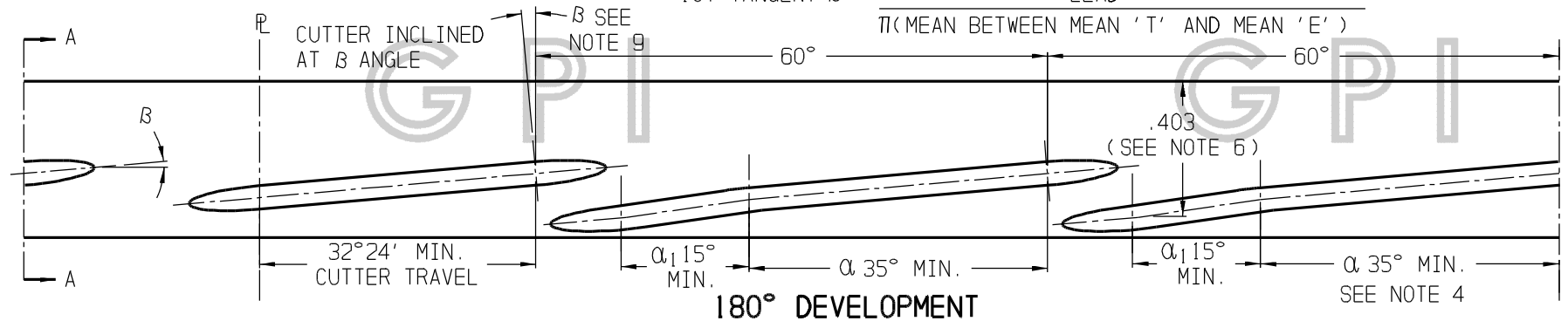
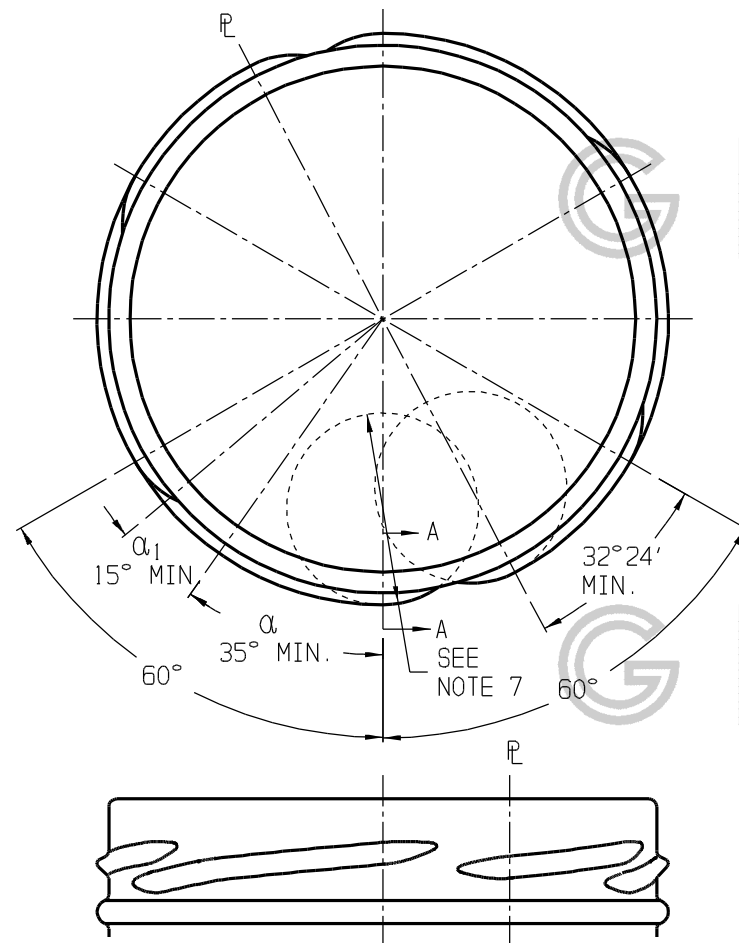


SECTION A-A



CUTTER PROFILE



SIZE	E		T		I MIN.	P	B	T.P.I. α	T.P.I. α ₁
	IDEAL	TOL.	IDEAL	TOL.					
77	2.854	+ .017 - .018	2.978	+ .017 - .018	2.359	2.596	4° 59'	1.250	.750
82	3.056	+ .017 - .018	3.180	+ .017 - .018	2.562	2.798	4° 40'	1.250	.750

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 .430 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 - 1.25 THREADS PER INCH. STANDARD CONSTRUCTION OF ALL FOUR LONG THREADS IS 35° MINIMUM α TRAVEL AT 1.25 THREADS PER INCH, THEN CHANGE TO .75 THREADS PER INCH FOR 15° MINIMUM α₁ TRAVEL HOLDING CUTTER INCLINATION AT 'B'.
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 .403 INCHES. BELOW .403, '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. ON THE 82mm SIZE, CERTAIN FILLING EQUIPMENT REQUIRES A 2.739 MIN. OPENING. TO ACCOMPLISH THIS, THIS FINISH MUST BE MADE BEAD STYLE WITH A RECOMMENDED NECK DIAMETER OF 3.062.
9. 'B' IS HELIX ANGLE AT PITCH DIAMETER. THE CUTTER IS INCLINED AT 'B' ANGLE FOR ALL THREADS AND ALL CUTS.

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

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GLASS FINISH NUMBER 2040		GPI DWG. NO.	
TOP SEAL VACUUM LUG FINISH, SIZES 77&82 (6 LEADS)		20408	