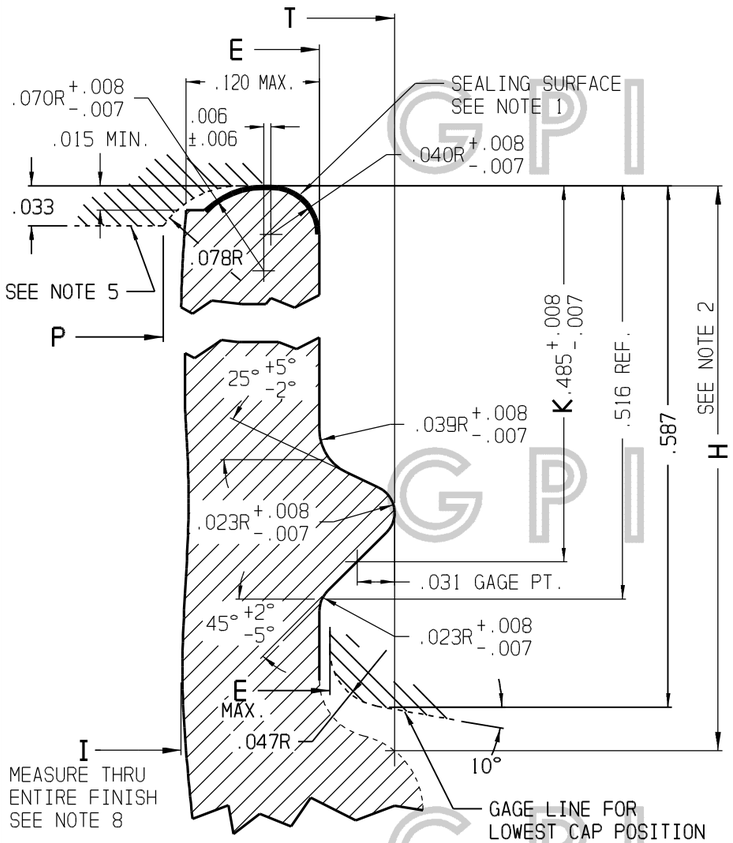
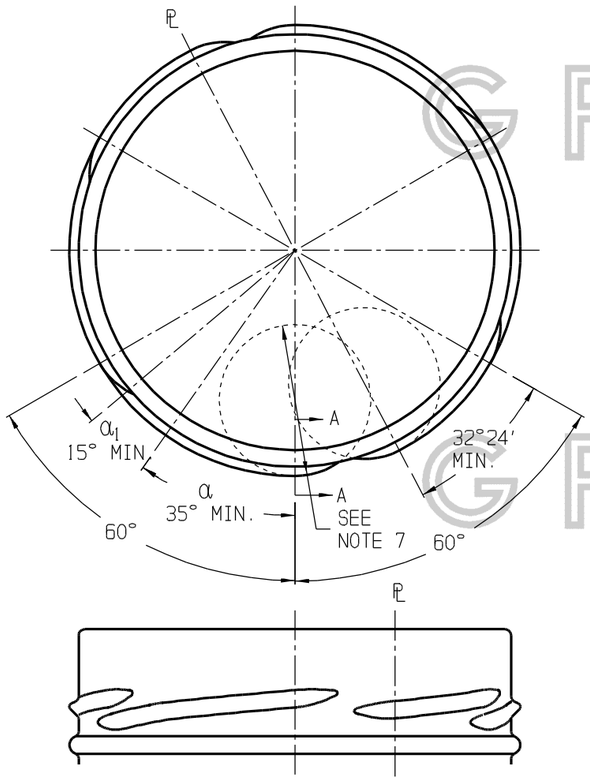
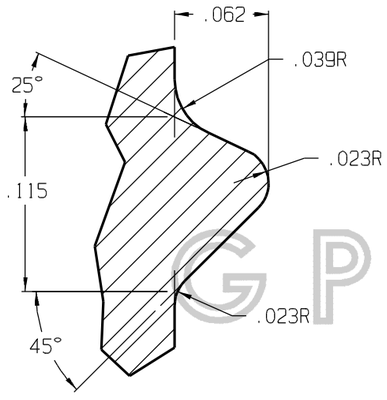
20451

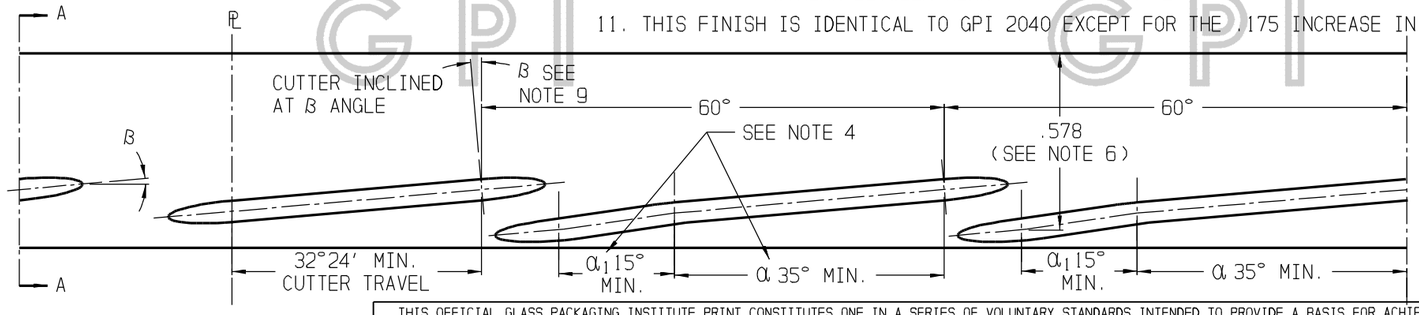


SECTION A-A





CUTTER PROFILE



180° DEVELOPMENT

SIZE	E		T		I MIN.	P	β	T.P.I.	T.P.I.
	IDEAL	TOL.	IDEAL	TOL.	SEE NOTE 8	SEE NOTE 6	HELIX ANGLE	α	α_1
82	3.056	+.017 -.018	3.180	+.017 -.018	2.563	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 CROSS-HATCHED AREA ABOVE .587 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 - 1.250 THREADS PER INCH. STANDARD CONSTRUCTION OF ALL FOUR LONG THREADS IS 35° MINIMUM "ALPHA" (α) TRAVEL AT 1.250 THREADS PER INCH, THEN CHANGE TO .750 THREADS PER INCH FOR 15° MINIMUM "ALPHA 1" (α_1) TRAVEL HOLDING CUTTER INCLINATION AT THE "BETA" (β) ANGLE.
5. CROSS-HATCHED AREA 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 .578 INCHES. BELOW .578, '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. 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. 'β' IS HELIX ANGLE AT PITCH DIAMETER. THE CUTTER IS INCLINED AT 'β' ANGLE FOR ALL THREADS AND ALL CUTS.
10. TANGENT $\beta = \frac{\text{LEAD}}{\pi(\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
11. THIS FINISH IS IDENTICAL TO GPI 2040 EXCEPT FOR THE .175 INCREASE IN HEIGHT.

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TOP SEAL VACUUM LUG DEEP FINISH, SIZE 82 (6 LEADS)