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 gap limits shown by shaded area above .461 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: one thread per inch. 35° minimum travel on passing line threads. 30° minimum travel on the other four leads.

5. Shaded section shows closure position. Top ring contour at this section must clear the limits specified.

6. For proper closure can-off, maintain 'T' diameter to a depth of .400 inches. Below .400, 'T' diameter may be below minimum but not over maximum.

7. Start and end of threads conform to 'T' cutter diameter except where ruffling is required to permit seal opening.

8. 'B' is helix angle at pitch diameter. The cutter is inclined at 'B' angle for all threads and all cuts.

9. Tangent B = Lead

T (mean between 'T' and mean 'E')

GAGE LINE FOR LOWEST CAP POSITION SEE NOTE 2

CUTTER INLINED AT 3° ANGLE

180° DEVELOPMENT

See Note 3

30° MIN. CUTTER TRAVEL

30° MIN. CUTTER TRAVEL