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. Adapt dimension.

3. When 'E' and 'T' diameters are at maximum, they must be concentric so as to prevent possible interference during cap application.

4. Eight lead thread - .075 threads per inch. All threads are .025 in. O. Travel at .085 threads per inch for sealing. O. Cap-off threads are .025 in. O. Travel at .095 threads per inch, then change to .5 threads per inch for 8 in. O. Travel holding cutter inclination at 8° angle.

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

6. For proper closure can-off, minimum 1.00 in. diameter to a depth of .020 inches below .006. 'T' diameter may be between minimum but not over maximum.

7. Start and end of threads conformed to 1.00 cut-off diameter except where replying is required to prevent hold openings.

8. 3° is helix angle at pitch diameter. The cutter is inclined at 8° angle for all threads and all cuts.

9. Tangent 0 = Lead

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Edward A. Grant

Glass Finish Number 2070

Top Seal Vacuum Lug Finish, Size 1.10 (8 Leads)

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TOP SEAL VACUUM LUG FINISH, SIZE 110 (8 LEADS)