1. THIS IS A VACUUM TOP & SIDE SEAL FINISH AND PROPER FUNCTION OF SEALING REQUIRES A SMOOTH SEALING SURFACE FREE OF IMPERFECTIONS THAT COULD PREVENT A VACUUM SEAL FROM BEING MAINTAINED. SEALING SURFACE IS DEFINED BY A HEAVY BLACK LINE AND IS TO BE FORMED IN A ONE PIECE "SLEEVE" OR "GUIDE RING" NO SEAMS OR PARTING LINES ALLOWED. THE RADIUS TO BE MAINTAINED.

2. A MINIMUM OF ONE COMPLETE TURN OF THREAD PROJECTION SHOULD BE MAINTAINED.

3. OPTIONAL - FOR RELIEF OF HOLD OPENING THREAD PROJECTION MAY BE DEPRESSED AT THE PARTING LINE. MAXIMUM ALLOWABLE DEPRESSION IS .006 PER SIDE FROM THE AVERAGE OF ACTUAL THREAD PROJECTIONS MEASURED ON A 60° ARC ON EITHER SIDE OF THE PARTING LINE.

4. PARTING LINE OFFSET AT .005 MAX. DEPTH MAY BE UP TO .010 IN ONE SIDE WITH .015 MAXIMUM PER DEPTH. I.E. HANG ON THE SIDE ADD TO HEIGHT ON OTHER SIDE OF BEAVER HEAD CAN BE EQUAL TO OR LESS THAN .015. AN OVERSIGHT OF THE .005 MAX. SECTION OUTSIDE OF THE "E" DIAMETER IS NOT PERMITTED.

5. "L" DIMENSION IS MEASURED THROUGH ENTIRE LENGTH OF FINISH.

6. CROSS-HATCHED AREA SHOWS CONTOUR TO BE CLEANED BY THE TOP OF GLASS FINISH.

7. SUGGESTED CONSTRUCTION IS SHOWN BUT MUST CLEAR CAP LIMITS SHOWN BY CROSS-HATCHED AREA ABOVE .505 DIMENSION.

8. S = HELIX ANGLE OR ANGLE OF FIXTURE TO CUTTER.

9. "T" = PITCH = MEAN BETWEEN "T" AND "E" "PITCH".

10. MINIMUM SPECIFICATION DOES NOT APPLY TO "E" BELOW BOTTOM RADIUS.

11. A LEVEL TOP FINISH IS IDEAL. MAXIMUM MIDDLE IS .005 WITHIN .005."  CORRECTIONS SHOULD BE MADE IF GLASS LOT CHECK SHOWS IT "RUNNING TOO HIGH" MIDDLE.

12. FOR OPTIMUM PACKAGE PERFORMANCE A DRAFT ANGLE OF 0° TO 3° IS PREFERRED. INDIVIDUALS OVER 5° ARE NOT PERMITTED.

13. VERTICAL DIMENSIONS WITH (*) DENOTES THE GAGING DEPTH FOR THE "E1" AND "E" DIAMETERS.

14. "E" DIAMETER IS MEASURED AT THIS LOCATION AND REPRESENTS ENTIRE "E" DIAMETER. THEREFORE IT MUST BE AS VERTICAL AS POSSIBLE WITHOUT IMPERFECTIONS THAT INFLUENCE "E" DIAMETER.

EDWARD A. GRANT
GLASS PACKAGING INSTITUTE
COMMITTEE ON DESIGN AND SPECIFICATIONS

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GLASS FINISH NUMBER 465
PRESS ON CONTINUOUS FINISH

GPI DIAG. NO. 4660

GPI DIAG. NO. 4659

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