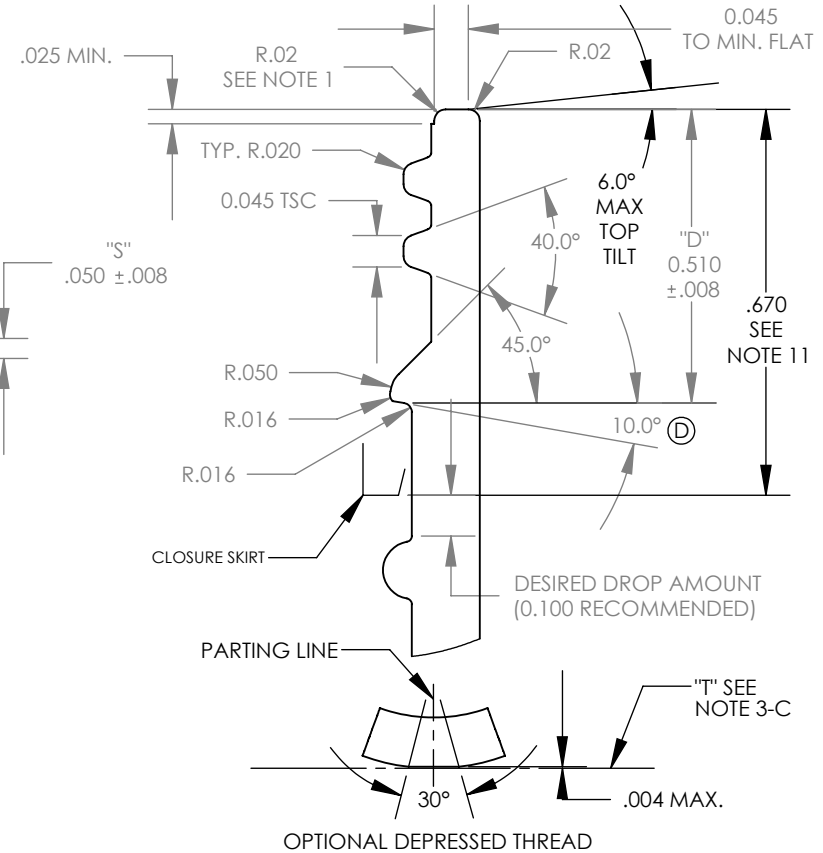
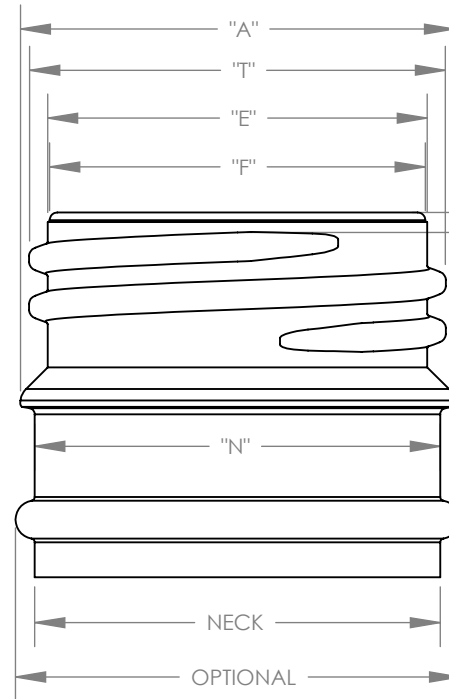


REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CHANGED NAME IN TITLE BLOCK FROM ALCOA TO HOFFER	9/6/98	SJL
	B	REMOVED 43 MM FINISH	9/7/00	SJL
	B1	REDRAWN IN CAD	5/3/2008	WEI
	C	REVISED 33, 38 AND 48MM DIMENSIONS.	4/10/2012	WEI
	D	REVISED ANGLE BELOW THE TAMPER BAND FROM 20° TO 10° TO IMPROVE TAMPER-EVIDENCE	10/1/2014	WEI

SIZE (MM)	"A"	"T"	"E"	"F" (see note 8)	"N"	TILT	TPI
28	1.130 ±0.10	1.085 ±0.10	0.988 ±0.12	0.978 ±0.10	1.056 ±0.13	2.22°	8
33	1.290 ±0.12	1.237 ±0.12	1.155 ±0.14	1.145 ±0.12	1.220 ±0.14	1.88°	8
38	1.505 ±0.14	1.445 ±0.14	1.343 ±0.16	1.333 ±0.14	1.435 ±0.15	1.60°	8
48	1.900 ±0.16	1.843 ±0.16	1.751 ±0.18	1.741 ±0.16	1.805 ±0.16	1.25°	8

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NOTES:

- THIS IS A PRESSURE TOP AND SIDE SEAL FINISH AND SHOULD BE SMOOTH AND FREE OF ANY DEFECTS SUCH AS CRIZZLES, CHECKS, OVERPRESS, PRESS-UP, ETC., THAT WILL CONTRIBUTE TO LOSS OF PRESSURE. CRITICAL SURFACE IS MARKED WITH A HEAVY LINE.
- THREAD TO HAVE 1-7/8 TURNS OF FULL THREAD.
- REQUIREMENTS FOR GOOD CAP APPLICATION ON PILFERPROOF GLASS:
  - .020" MAX. OUT OF PARALLEL SEALING SURFACE WITH BOTTOM OF THE BOTTLE FOR COCKED NECKS AND SLANTED FINISHES.
  - .094" MAX. OUT OF PERPENDICULAR WHEN THE BOTTLE LEANS FROM THE BASE OF THE BOTTLE THROUGH THE FINISH.
  - OFFSET OR VERTICAL MISMATCH OF THE THREAD NOT TO EXCEED .004" AT MOLD SEAM. IT IS PERMISSABLE TO RELIEVE THE THREAD AT THE MOLD SEAM, NOT TO EXCEED .008" ON THE DIAMETER IN AN ARC OF 30°. THE "T" DIMENSION IS NOT MEASURED IN THE DEPRESSED AREA.
- AN UNDER MINIMUM "F" DIAMETER WILL CONTRIBUTE TO LEAKERS.
- IT IS PERMISSABLE TO BE UNDER MINIMUM ON THE "D" DIMENSION, NOT TO EXCEED AN ARC OF 30°, PROVIDING THE REST OF THE "D" DIMENSION AREA IS WITHIN SPECIFICATION.
- HIGH APPLICATION AND REMOVAL TORQUE CAN BE CAUSED BY ROUGH GLASS AND PROJECTING MOLD SEAMS.
- PROPER APPLICATION AND FUNCTION OF CLOSURE REQUIRES THAT THE "A", "E" AND "T" DIAMETERS FOLLOW UNIFORMLY.
- THE "F" DIAMETER IS TO BE MEASURED AT .025" DOWN.
- THE "F" STEP IS NOT REQUIRED. IT IS PERMISSABLE TO MANUFACTURE THE "E" DIAMETER THE SAME DIMENSION AS GIVEN FOR THE "F" DIAMETER.
- CAUTION: HOT END TREATMENTS ON FINISH (THREADS, "A" DIA. ETC.) COULD CAUSE UNUSUALLY HIGH APPLICATION AND REMOVAL TORQUES.
- .670 DIMENSION SHOWN IS TO THE BOTTOM OF THE CLOSURE IN THE APPLIED POSITION. AMOUNT OF DESIRED DROP MUST BE ADDED.

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UNLESS OTHERWISE SPECIFIED:	NAME	DATE
DIMENSIONS ARE IN INCHES/MM	WEI	5/3/08
TOLERANCES:	DESIGN APPROVED	
FRACTIONAL ±	COMMENTS:	
ANGULAR: ± 1°	THREAD CUTTER SIZE - .750 DIA.	
TWO PLACE DECIMAL ± .010	FILLETS NOT GIVEN - MAX .030R	
THREE PLACE DECIMAL ± .005	NECK I.D. & O.D. AND TRANSFER BEAD IS OPTIONAL	
INTERPRET GEOMETRIC TOLERANCING PER:		
MATERIAL		
FINISH		
DO NOT SCALE DRAWING		

Hoffer Plastics Corp.  
500 N. Collins St.  
So. Elgin, IL 60177

TITLE:  
**GLASS FINISH FOR DROP-LOK®**

SIZE	DWG. NO.	REV
<b>A</b>	<b>1768</b>	<b>D</b>
SCALE: 2:1	Shrink:	SHEET 1 OF 1