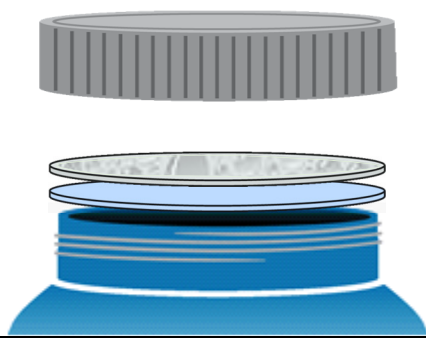


PRODUCT DATA SHEET

PressureSeal 20

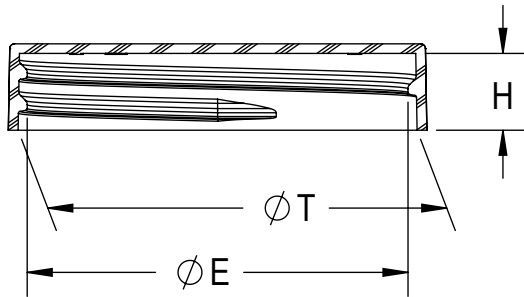
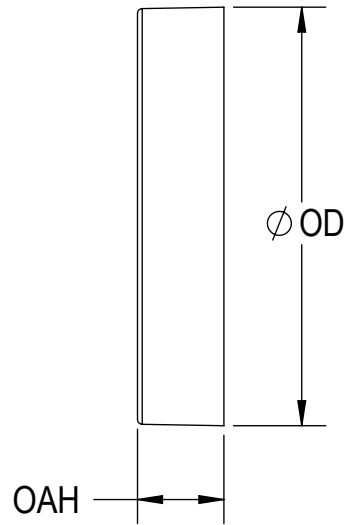
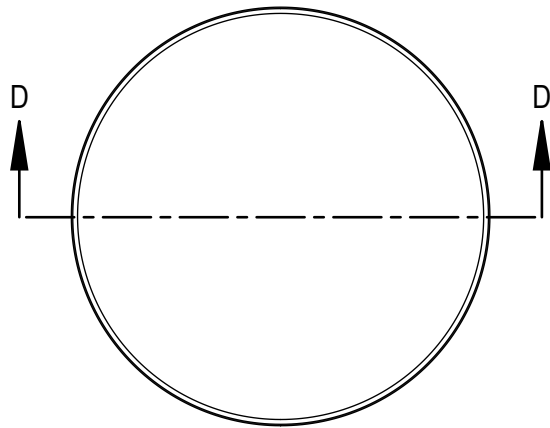
- PressureSeal 20 is an inner seal with a construction of polystyrene foam coated with pressure sensitive adhesive.
- The US FDA does not consider liners applied with pressure sensitive adhesive to be an effective tamper-resistant feature.
- Recommended for use with dry products.
- Available with standard or custom print.

Typical Product Attributes

Construction			
Polystyrene Foam Pressure Sensitive Adhesive		SI (µm)	US (Mils)
Thickness Tolerance Minimum Width Width Tolerance		508,0 50,8 – 76,2 ± 10% 25,4 mm ± 1,6 mm	20.0 2.0 – 3.0 ± 10% 1.0 in ± 0.0625 in
Properties			
Oxygen Transmission (O ₂ TR)	Not Tested		
Water Vapor Transmission (WVTR)	Not Tested		
Regulatory Compliance			
FDA Compliance	21 CFR 177.1640 Polystyrene and rubber-modified polystyrene. 21 CFR 177.1210 Closures with sealing gaskets for food containers. 21 CFR 175.125 Pressure-sensitive adhesives.		
Drug Master File (DMF)	002518		
Other Compliances	USFDA Food Allergen Guidelines California Proposition 65 Labeling Requirements Limitations of Heavy Metals in Packaging per CONEG & EU 94/62/EC, Article 11		
Safety Data Sheet (SDS) Statement	Safety Data Sheets (SDS) are not required for articles as defined in 29 CFR 1910.1200, the OSHA Hazard Communication Standard (HazCom). This product is an article as defined by HazCom and is not considered to be, or to contain, a hazardous chemical based on evaluations made by our company.		
Please note that construction does not reflect adhesive or resin bonding layers, if present.			

Revision Number: 4
Revised Date: 2018-06-08

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SECTION D-D

THREAD DETAIL INFORMATION
6 THREADS PER INCH, 0.167 PITCH

REFERENCE	TOLERANCE	DIMENSION	UNITS
E	±0.015 [0.38]	1.984 [50.39]	in [mm]
T	±0.015 [0.38]	2.078 [52.78]	in [mm]
H	±0.010 [0.25]	0.400 [10.16]	in [mm]
OAH	±0.010 [0.25]	0.450 [11.43]	in [mm]
OD	±0.015 [0.38]	2.180 [55.37]	in [mm]
PART WEIGHT	± 0.80	5.10	g

STATIC TORQUE RECOMMENDATION
21-36 in-lbs
THIS REQUIREMENT MAY VARY DEPENDING
UPON BOTTLE MATERIAL, NECK FINISH, AND
CAPPING EQUIPMENT

DRAWING TYPE : **CUSTOMER**

REPLACES DRAWINGS:
C-1012

DIMENSIONS ENCLOSED IN ()
INDICATE REFERENCE
DIMENSIONS AND NO TOLERANCE
LIMITS ARE ESTABLISHED

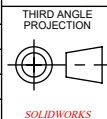
TOLERANCES UNLESS OTHERWISE SPECIFIED

DIMENSION (inches)	TOLERANCE	DIMENSION (mm)	TOLERANCE
0-0.787	±0.006	0-20	±0.152
0.788-1.181	±0.008	21-30	±0.203
1.182-2.756	±0.012	31-70	±0.305
2.757-3.937	±0.016	71-100	±0.406
3.938-5.096	±0.020	101-150	±0.508
5.097-7.874	±0.024	151-200	±0.610
7.875-9.843	±0.032	201-250	±0.813

ANGULAR TOLERANCE ± 2°

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DISTRIBUTION
CODE
D

DRAWING NAME
53-400 CT
S (SMOOTH SIDE, SMOOTH TOP)

DRAWING NUMBER
CQA - 10509

DRAWN BY: DAS 3/1/2017

MATERIAL
POLYPROPYLENE

ENG APPR: JDM 4/4/2018

MODEL NUMBER: **PM 10504 53-400 CT**

QA APPR: REL 05/02/2018

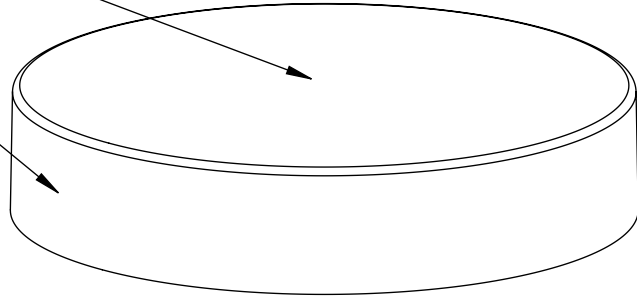
SCALE	SHEET SIZE	SHEET	REV.NP
1:1	8.5 X 11	1 of 3	00.AB

THE CLOSURE DIMENSIONS
DEPICTED ARE THOSE WHICH HAVE GENERALLY BEEN
FOUND TO BE FUNCTIONAL BASED ON INDUSTRY
EXPERIENCE BECAUSE OF VARIABILITY IN GLASS AND
PLASTIC CONTAINER FINISHES. EACH CLOSURE/FINISH
SYSTEM SHOULD BE INDIVIDUALLY EVALUATED AND
TESTED TO ENSURE IT MEETS APPLICABLE
PERFORMANCE CRITERIA. SEE QUALITY ASSURANCE
SPECIFICATIONS FOR ADDITIONAL INFORMATION.

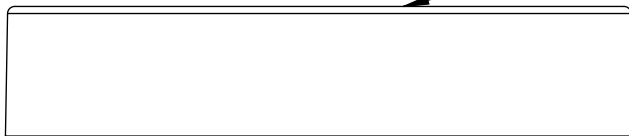
MOLD-RITE, WEATHERCHEM AND STULL TECHNOLOGIES
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SPECIFICATIONS AND REQUIREMENTS.

REVISIONS					
DATE	REV.	N/P	DESCRIPTION	ENG	DRW
3/1/2017	00	AA	UPDATED DRAWING FORMAT AND ASSIGNED NEW DRAWING NUMBER	JDM	DAS
4/4/2018	00	AB	ADDED GATE LOCATION TABLE. SPECIFICATIONS UPDATED BASED ON PRODUCTION CAPABILITY. NO STEEL CHANGES HAVE OCCURED.	JDM	DAS

SEE TABLE FOR GATE LOCATION



SMOOTH SIDES AND TOP



MOLD NUMBER	GATE LOCATION
53001	SIDE
53002	SIDE
53006	SIDE
53008	SIDE
53013	TOP

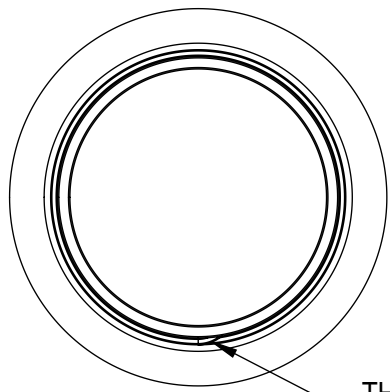
DRAWING TYPE : CUSTOMER			
REFERENCES: 53001, 53002, 53006, 53008, 53013		DIMENSIONS ENCLOSED IN () INDICATE REFERENCE DIMENSIONS AND NO TOLERANCE LIMITS ARE ESTABLISHED	
TOLERANCES UNLESS OTHERWISE SPECIFIED			
DIMENSION (inches)	TOLERANCE	DIMENSION (mm)	TOLERANCE
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2.757-3.937	±0.016	71-100	±0.406
3.938-5.096	±0.020	101-150	±0.508
5.097-7.874	±0.024	151-200	±0.610
7.875-9.843	±0.032	201-250	±0.813
ANGULAR TOLERANCE ± 2°			
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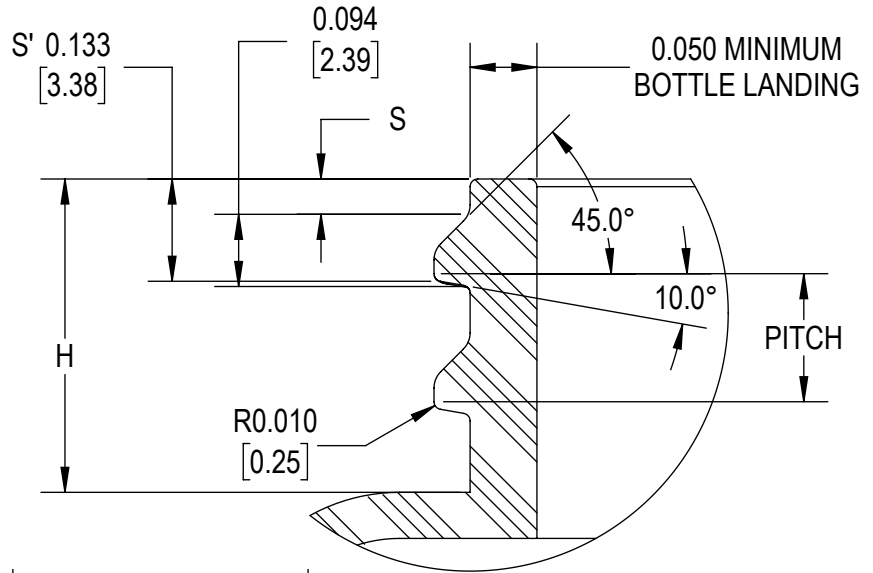
THE CLOSURE DIMENSIONS DEPICTED ARE THOSE WHICH HAVE GENERALLY BEEN FOUND TO BE FUNCTIONAL BASED ON INDUSTRY EXPERIENCE BECAUSE OF VARIABILITY IN GLASS AND PLASTIC CONTAINER FINISHES. EACH CLOSURE/FINISH SYSTEM SHOULD BE INDIVIDUALLY EVALUATED AND TESTED TO ENSURE IT MEETS APPLICABLE PERFORMANCE CRITERIA. SEE QUALITY ASSURANCE SPECIFICATIONS FOR ADDITIONAL INFORMATION.

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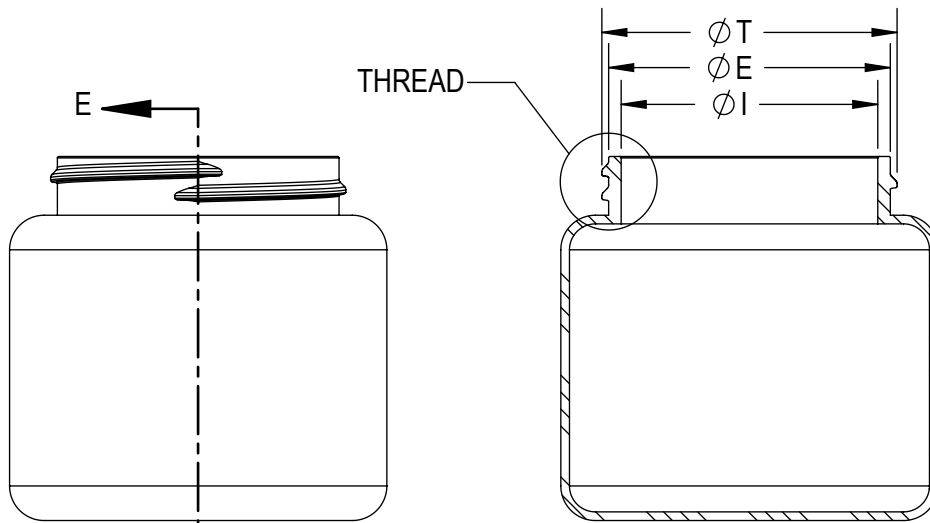
THIRD ANGLE PROJECTION	DISTRIBUTION CODE	DRAWING NAME			
	D	53-400 CT S (SMOOTH SIDE, SMOOTH TOP)			
DRAWN BY: DAS 3/1/2017		DRAWING NUMBER: CQA - 10509			
MATERIAL: POLYPROPYLENE		MODEL NUMBER: PM 10504 53-400 CT			
ENG APPR. JDM 4/4/2018	QA APPR. REL 05/02/2018	SCALE: 3:2	SHEET SIZE: 8.5" X 11"	SHEET: 2 of 3	REV.NP: 00.AB



THREAD START



DETAIL THREAD
SCALE 4 : 1



SECTION E-E

REFERENCE	TOLERANCE	UNITS	DIMENSION
E	±0.017 [0.43]	in [mm]	1.956 [49.68]
T	±0.017 [0.43]	in [mm]	2.050 [52.07]
I	MIN	in [mm]	1.578 [40.08]
S	±0.015 [0.38]	in [mm]	0.046 [1.17]
H	MIN	in [mm]	0.408 [10.36]
PITCH		in [mm]	6
TPI			0.167

NOTE: THE NOMINAL ORIENTATION ILLUSTRATED IS BASED ON NOMINAL DIMENSIONS OF BOTH THE CLOSURE AND THE RECOMMENDED NECK FINISH. FOR EXACT ORIENTATION EACH BOTTLE SHOULD BE EVALUATED ON A CASE BY CASE BASIS.

THE CLOSURE DIMENSIONS DEPICTED ARE THOSE WHICH HAVE GENERALLY BEEN FOUND TO BE FUNCTIONAL BASED ON INDUSTRY EXPERIENCE BECAUSE OF VARIABILITY IN GLASS AND PLASTIC CONTAINER FINISHES, EACH CLOSURE/FINISH SYSTEM SHOULD BE INDIVIDUALLY EVALUATED AND TESTED TO ENSURE IT MEETS APPLICABLE PERFORMANCE CRITERIA. SEE QUALITY ASSURANCE SPECIFICATIONS FOR ADDITIONAL INFORMATION.

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DRAWING TYPE : CUSTOMER

DIMENSIONS ENCLOSED IN () INDICATE REFERENCE DIMENSIONS AND NO TOLERANCE LIMITS ARE ESTABLISHED

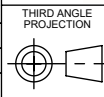
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7.875-9.843	±0.032	201-250	±0.813

ANGULAR TOLERANCE ± 2°

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DISTRIBUTION CODE

D

DRAWING NAME

53-400 CT
RECOMMENDED NECK FINISH

DRAWING NUMBER

CQA - 10509

DRAWN BY.

DAS

3/1/2017

MATERIAL

ENG APPR.

JDM

4/4/2018

MODEL NUMBER:

QA APPR.

REL

05/02/2018

SCALE

SHEET SIZE

SHEET

REV/N/P

3:4

8.5X11

3 of 3

00.AB