

SECTION L-L

8 THREADS PER INCH, 0.125 PITCH

REFERENCE	TOLERANCE	DIMENSION	UNITS
E	±0.010 [0.25]	0.704 [17.88]	in [mm]
T	±0.010 [0.25]	0.786 [19.96]	in [mm]
H [Seated]	REFERENCE	0.400 [10.16]	in [mm]
H [Inner]	±0.008 [0.25]	0.360 [9.14]	in [mm]
OD	±0.010 [0.25]	1.070 [27.18]	in [mm]
OAH	±0.010 [0.25]	0.575 [14.61]	in [mm]
PART WEIGHT	± 0.50	3.47	g

**STATIC TORQUE RECOMMENDATION**  
**8-12in-lbs**  
 THIS REQUIREMENT MAY VARY DEPENDING  
 UPON BOTTLE MATERIAL, NECK FINISH, AND  
 CAPPING EQUIPMENT

DRAWING TYPE : **CUSTOMER**

REPLACES DRAWINGS:  
 PDT-20

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

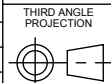
TOLERANCES UNLESS OTHERWISE SPECIFIED

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°

PROPRIETARY AND CONFIDENTIAL

THIS DRAWING IS PROTECTED BY COPYRIGHT AND CONTAINS INFORMATION  
 PROPRIETARY TO MOLD-RITE, WEATHERCHEM AND STULL TECHNOLOGIES.  
 ANY REPRODUCTION, DISCLOSURE, OR USE OF ITS CONTENTS OR ANY PART  
 THEREOF IS EXPRESSLY PROHIBITED EXCEPT AS MOLD-RITE, WEATHERCHEM  
 AND STULL TECHNOLOGIES OTHERWISE MAY AGREE IN WRITING



SOLIDWORKS



DISTRIBUTION  
 CODE

**D**

DRAWING NAME  
**20-400 CRC PDT ASSM**  
 PICTO

DRAWING NUMBER  
**CQA - 11115**

MATERIAL  
**POLYPROPYLENE**

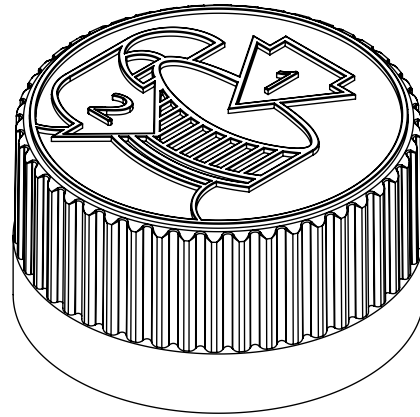
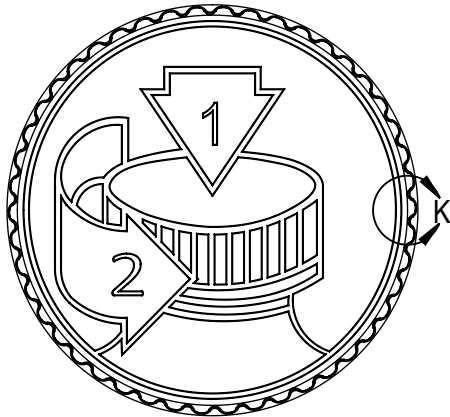
MODEL NUMBER:  
**PM 11010 20-400 CRC ASSM**

SCALE	SHEET SIZE	SHEET	REV NP
2:1	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  
 RESERVES THE RIGHT TO REVISE ANY OR ALL  
 SPECIFICATIONS AND REQUIREMENTS.

DATE	REV	N/P	DESCRIPTION	ENG	DRWN
03/16/18	00	AA	DRAWING RELEASE	BDG	BDG
6/7/18	00	AB	CORRECTED P/N REFERENCE ON PAGE 2	BDG	BDG



DETAIL K  
(54) EQUISPACED RIBS  
SCALE 4 : 1

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  
RESERVES THE RIGHT TO REVISE ANY OR ALL  
SPECIFICATIONS AND REQUIREMENTS.

DRAWING TYPE : CUSTOMER

REFERENCES:

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

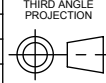
TOLERANCES UNLESS OTHERWISE SPECIFIED

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°

PROPRIETARY AND CONFIDENTIAL

THIS DRAWING IS PROTECTED BY COPYRIGHT AND CONTAINS INFORMATION  
PROPRIETARY TO MOLD-RITE, WEATHERCHEM AND STULL TECHNOLOGIES.  
ANY REPRODUCTION, DISCLOSURE, OR USE OF ITS CONTENTS OR ANY PART  
THEREOF IS EXPRESSLY PROHIBITED EXCEPT AS MOLD-RITE, WEATHERCHEM  
AND STULL TECHNOLOGIES OTHERWISE MAY AGREE IN WRITING



SOLIDWORKS

DISTRIBUTION  
CODE

D

DRAWING NAME

20-400 CRC PDT ASSM  
PCTO

DRAWING NUMBER

CQA - 11115

MATERIAL

POLYPROPYLENE

MODEL NUMBER:

PM 11010 20-400 CRC ASSM

SCALE

2:1

SHEET SIZE

8.5 X 11

SHEET

2 of 3

REV.NP

00.AB

DRAWN BY.

BDG

2/19/2018

ENG APPR.

BDG

3/16/2018

QA APPR.

REL

03/16/2018

0.050 MINIMUM FLAT FOR INDUCTION SEALING

.084  
[2.13]

S

45°

PITCH

10°

R.010  
[0.25]

DETAIL THREAD  
SCALE 4 : 1

THREAD START

THREAD

SECTION H-H  
SCALE 2 : 1

REFERENCE	TOLERANCE	UNITS	DIMENSION
E	± 0.008[0.20]	in [mm]	0.691 [17.55]
T	± 0.008[0.20]	in [mm]	0.775 [19.69]
I	MINIMUM	in [mm]	0.404 [10.26]
S	±0.015[0.38]	in [mm]	0.037[0.94]
H	MINIMUM	in [mm]	0.370 [9.40]
H1	MINIMUM	in [mm]	0.490 [12.45]
B	MAXIMUM	in [mm]	0.835 [21.21]
TPI			8
PITCH		in [mm]	0.125[3.18]

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.

DRAWING TYPE : CUSTOMER

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

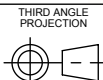
TOLERANCES UNLESS OTHERWISE SPECIFIED

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°

PROPRIETARY AND CONFIDENTIAL

THIS DRAWING IS PROTECTED BY COPYRIGHT AND CONTAINS INFORMATION PROPRIETARY TO MOLD-RITE, WEATHERCHEM AND STULL TECHNOLOGIES. ANY REPRODUCTION, DISCLOSURE, OR USE OF ITS CONTENTS OR ANY PART THEREOF IS EXPRESSLY PROHIBITED EXCEPT AS MOLD-RITE, WEATHERCHEM AND STULL TECHNOLOGIES OTHERWISE MAY AGREE IN WRITING



DISTRIBUTION CODE

D

DRAWING NAME

20-400 CRC PDT ASSM  
Recommended Neck Finish

DRAWING NUMBER

CQA - 11115

MATERIAL

DRAWN BY.

BDG

2/19/2018

ENG APPR.

BDG

3/16/2018

QA APPR.

REL

03/16/2018

MODEL NUMBER:

SCALE

SHEET SIZE

SHEET

REV/N/P

1:1

8.5 X 11

3 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 RESERVES THE RIGHT TO REVISE ANY OR ALL SPECIFICATIONS AND REQUIREMENTS.



# PRODUCT DATA SHEET

## HS 035 HEAT SEAL// 25 WHITE LINED PULP

MRP Description - (P21)HS035.025 PLP R SFYP

### PRODUCT DESCRIPTION

**Description:** A paper-backed aluminum foil coated with a clear heat sealable coating blend of high molecular weight ethylene and vinyl acetate copolymers wax bonded to white lined board.

**FDA Status:** Complies with Federal Regulations of H.E.W., FDA, sections 175.105, 175.300, 176.170, 176.180, 176.200, 177.1350, 178.3710, 182.1, 182.90, and 186.173. It is entered in SANCAP Liner's food master file FMF 166 and drug master file DMF 2518.

### PHYSICAL AND CHEMICAL PROPERTIES

1. **Color** Aluminum
2. **Thickness, mils**
  - a) Overall 28.80 - 33.78
  - b) Heat Seal Coating 1.50 - 3.00
  - c) Aluminum Foil 0.31 - 0.38
  - d) Paper 2.60 - 3.00
  - e) Wax 0.90 - 1.10
  - f) White Lined Pulp 23.50 - 26.50
3. **Basis Wt. Lbs./Ream 3000 ft.<sup>2</sup>**
  - a) Overall 316.80 - 372.40
  - b) Heat Seal Coating 20.7 - 41.9
  - c) Aluminum Foil 13.3 - 16.2
  - d) Paper 33.3 - 36.8
  - e) Wax 13.5 - 16.5
  - f) White Lined Pulp 236.0 - 261.0
4. **Heat Seal Coating**
  - a) Melting Point °F 150 - 160
  - b) Blocking Point °F 130 - 135
5. **Gas Transmission: cc/cin<sup>2</sup>/24hrs/1atm**
  - a) Oxygen nil
6. **Water Vapor Transmission**
  - a) gm/cin<sup>2</sup>/24hrs/100°F/90%RH Near zero

PRODUCT NAME: HS035 HEAT SEAL//25 WHITE LINED PULP  
REV. 050311

### RECOMMENDED STORAGE CONDITIONS

The material should be stored in well-ventilated area (temp. 60° - 80°F; RH - 40% - 60%). Material and lined closures are heat sensitive. Storage or shipping temperatures should not be in excess of 105°F. Curling, blocking, splitting, or foil separation may result. If material becomes chilled, it should be stored under the recommended conditions until stabilized. Avoid storing closure liner materials over 60 days. Metal foil is prone to corrosion.

### SUGGESTED PRODUCT USES

Material is an induction heat sealable tamper indicating innerseal which can be used for over-the-counter drug products on Polyethylene, Glass\*, PET, PVC, Polystyrene and Polypropylene.

**Dry Products**  
**Milk**  
**Peroxide**

**Fruit Juices**  
**Glass Cleaner**  
**Spices**

Product applications listed above are a partial listing and do not cover all suitable applications. These are suggestions for general categories and user must test for suitability for their specific product. Not suitable for products containing oil.

**\*Glass must be treated for proper adhesion.**

The technical information and suggestions for use made herein are based on SANCAP Liner research and experience and are believed to be reliable, but such information and suggestions do not constitute a warranty, and no patent liability can be assumed. Since SANCAP Liner has no control over the conditions under which the product is transported, stored, handled, used, or applied, buyer must determine for themselves, by preliminary tests or otherwise, the suitability of the product for their purposes. All products are sold subject to SANCAP Liner's written warranty, which is in lieu of all other warranties or merchantability and fitness for a particular purpose. SANCAP Liner's liability on any basis is limited to the price of the product used.