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P A C K A G I N G

## Product Specification Sheet

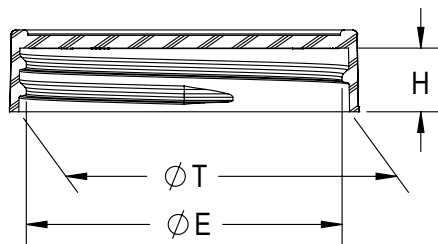
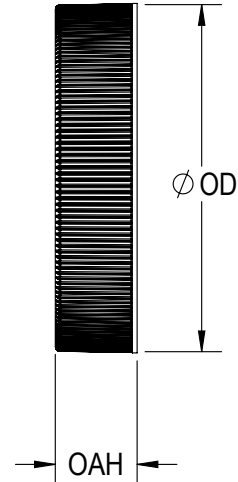
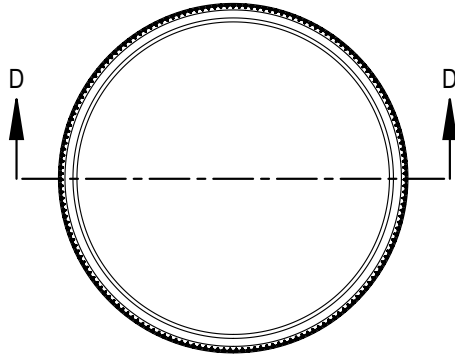
Illing Part#

3633MR

# 53-400 WHITE PLASTIC CAP WITH PRESSURE SEAL-20 PRINTED BLACK LINER

Part #: 3633MR

|                  |                                              |
|------------------|----------------------------------------------|
| Size:            | 53-400MM                                     |
| Color:           | WHITE                                        |
| Material:        | PP - CAP ; POLYSTYRENE LINER                 |
| Style:           | RIBBED SIDE, MATTE TOP                       |
| Additional Info: | PRINTED LINER: SEALED FOR YOUR PROTECTION (S |
| Case Pack:       | 1,300/EACH                                   |
| Pallet Pack:     |                                              |



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] | 0.477 [12.12] | in [mm] |
| OD          | ±0.015 [0.38] | 2.195 [55.75] | 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-4012

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  
RM (RIBBED SIDE, MATTE TOP)**  
DRAWING NUMBER  
**CQA - 10505**

DRAWN BY: DAS 3/1/2017  
ENG APPR: JDM 4/4/2018  
QA APPR: REL 05/02/2018

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

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

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| REVISIONS |      |     |                                                                                                                  |     |     |
|-----------|------|-----|------------------------------------------------------------------------------------------------------------------|-----|-----|
| DATE      | REV. | N/P | DESCRIPTION                                                                                                      | ENG | DRW |
| 3/1/2017  | 00   | AA  | UPDATED DRAWING FORMAT AND ASSIGNED NEW DRAWING NUMBER, CORRECT OAH PER VALIDATION RUN (WAS 0.484")              | JDM | DAS |
| 8/16/2017 | 00   | AB  | ADDED GATE LOCATION TABLE. SPECIFICATIONS UPDATED BASED ON PRODUCTION CAPABILITY. NO STEEL CHANGES HAVE OCCURED. | JDM | DAS |

SEE TABLE FOR GATE LOCATION

RIBS

175 EQUALLY SPACED RIBS  
DETAIL RIBS  
SCALE 6 : 1

| MOLD NUMBER | GATE LOCATION |
|-------------|---------------|
| 53002       | SIDE          |
| 53006       | SIDE          |
| 53008       | SIDE          |

|                                                                                                                                                                                                                                                                                                                        |                                                                                                           |                |           |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|----------------|-----------|
| DRAWING TYPE : CUSTOMER                                                                                                                                                                                                                                                                                                |                                                                                                           |                |           |
| REFERENCES:<br>53002, 53006, 53008                                                                                                                                                                                                                                                                                     | DIMENSIONS ENCLOSED IN ( )<br>INDICATE REFERENCE<br>DIMENSIONS AND NO TOLERANCE<br>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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|                                        |                                                          |
|----------------------------------------|----------------------------------------------------------|
| <br>Innovative • Reliable • Responsive |                                                          |
| THIRD ANGLE PROJECTION                 | DISTRIBUTION CODE<br><b>D</b>                            |
| DRAWN BY: DAS                          | DRAWING NAME<br>53-400 CT<br>RM (RIBBED SIDE, MATTE TOP) |
| ENG APPR: JDM                          | DRAWING NUMBER<br>CQA - 10505                            |
| QA APPR: REL                           | MATERIAL<br>POLYPROPYLENE                                |
| DATE: 3/1/2017                         | MODEL NUMBER:<br>PM 10504 53-400 CT                      |
| DATE: 4/4/2018                         | SCALE<br>3:2                                             |
| DATE: 05/02/2018                       | SHEET SIZE<br>8.5" X 11"                                 |
|                                        | SHEET<br>2 of 3                                          |
|                                        | REV.NP<br>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.

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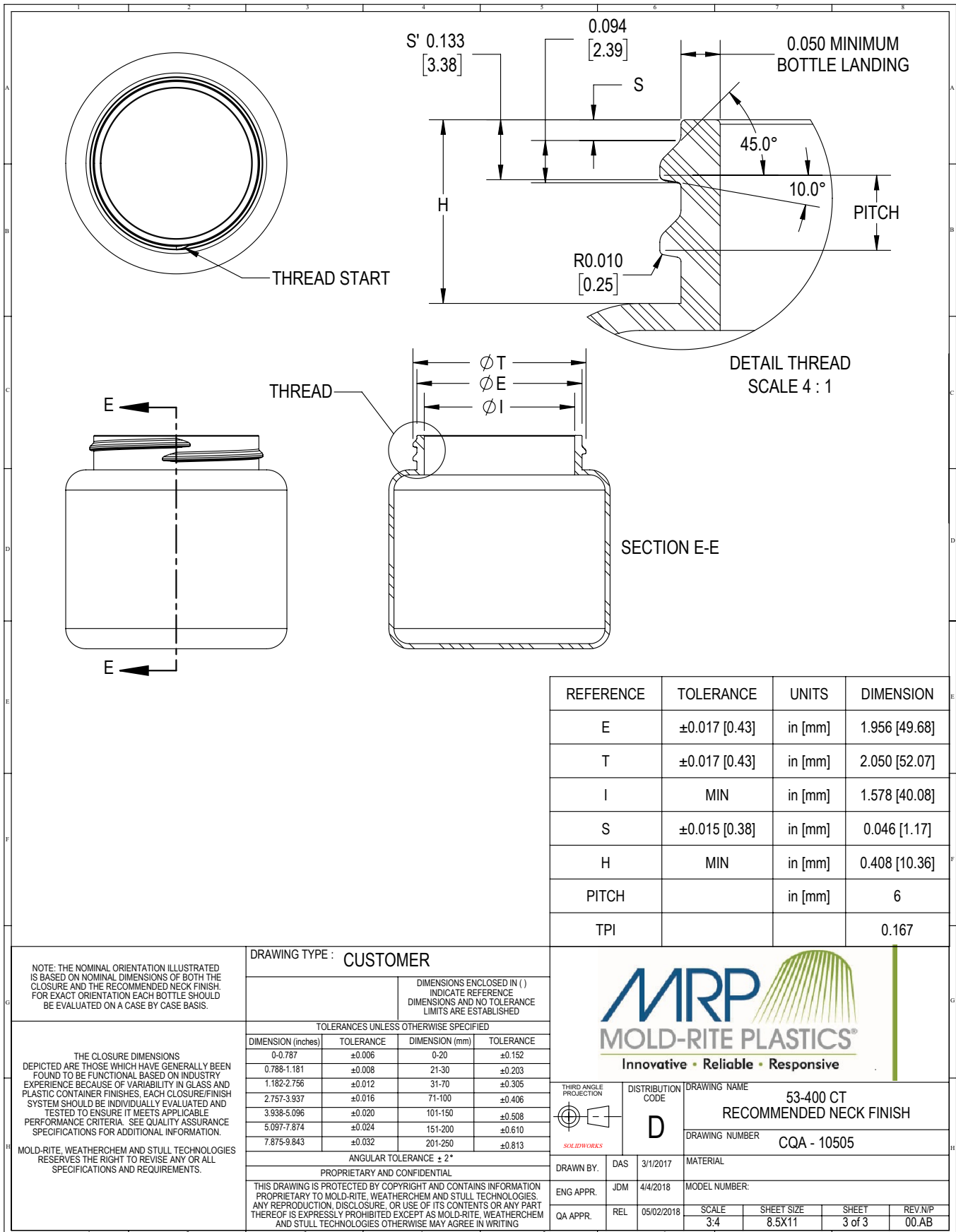


**ILLING**  
PACKAGING

# Product Specification Sheet

Illing Part#

3633MR



Represented by



**ILLING**<sup>TM</sup>  
P A C K A G I N G

# Product Specification Sheet

Illing Part#

3633MR



MRP DESCRIPTION - (023)PRESSURE SEAL.020 B SFYP

## 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<br>Pressure Sensitive Adhesive<br><br>Thickness Tolerance<br>Minimum Width<br>Width Tolerance |  | SI (µm)              | US (Mils)             |
|                                                                                                                |  | 508,0<br>50,8 – 76,2 | 20.0<br>2.0 – 3.0     |
|                                                                                                                |  | ± 10%                | ± 10%                 |
|                                                                                                                |  | 25,4 mm<br>± 1,6 mm  | 1.0 in<br>± 0.0625 in |

##### Properties

|                                         |            |
|-----------------------------------------|------------|
| Oxygen Transmission (O <sub>2</sub> TR) | Not Tested |
| Water Vapor Transmission (WVTR)         | Not Tested |

##### Regulatory Compliance

|                                   |                                                                                                                                                                                                                                                                                                    |
|-----------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| FDA Compliance                    | 21 CFR 177.1640 Polystyrene and rubber-modified polystyrene.<br>21 CFR 177.1210 Closures with sealing gaskets for food containers.<br>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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