



SIZE	T		E		E ₁		B		B ₁	S	I	P	B	CTR. DIA.	LEADS	T.P.I.
	IDEAL	TOL.	IDEAL	TOL.	IDEAL	TOL.	IDEAL	TOL.	±.025	+ .008 - .007	MIN.					
48	1.750	±.015	1.700	±.015	1.694	±.015	1.760	±.015	1.945	.101	1.375	1.430	5°16'	.500	4	2.0 & 1.75
51	1.948	±.015	1.898	±.015	1.892	±.015	1.958	±.015	2.145	.101	1.562	1.608	4°44'	.500	4	2.0 & 1.75

- TOP AND SIDE SEALING SURFACE SHOULD BE FREE OF IRREGULARITIES TO A .300 DEPTH.
- FOUR LEADS, .500 IN. CUTTER DIAMETER, CUTTER INCLINED TO THE BETA ANGLE FOR ALL CUTS. TWO CUTTER PASSES REQUIRED PER LEAD. THE BETA ANGLE CORRESPONDS TO THE CUT AT 2.0 T.P.I., HOWEVER, THE CUTTER IS HELD AT THE SAME INCLINATION FOR THE SECOND CUT AT 1.75 T.P.I.
- PROPER FUNCTION OF CLOSURE REQUIRES THAT "E₁", "E", "T" & "B" DIAMETERS TO BE AS LITTLE OUT-OF-ROUND AS POSSIBLE AND THE LATTER THREE DIAMETERS BE PERPENDICULAR TO THE TOP OF FINISH. THE MAX. AND MIN. AVERAGES OF THESE DIAMETERS SHOULD BE AS CLOSE TO "IDEAL" AS POSSIBLE.
- PROPER CAM-OFF OF CLOSURE REQUIRES THAT THE THREADS PROJECT .025 +.003/- .002 OUT FROM THE 'E' DIA. BUT NEVER TO EXCEED THE 'B' DIA. THREAD PROFILE MUST BE WELL DEFINED AND WITHIN THE .025R +.003/- .002 AND THE THREAD ROOT RADII MUST NOT EXCEED .010.
- CROSS HATCHED AREA SHOWS CONTOUR TO BE CLEARED BY THE TOP OF GLASS FINISH.
- CONTOUR BELOW .300 MUST CLEAR CAP LIMITS SHOWN BY CROSS-HATCHED AREAS ABOVE .400 DIMENSION. WHERE MAXIMUM CONTAINER GRIPABILITY IS NECESSARY, THE CONTOUR BELOW .300 CAN FOLLOW THE OPTIONAL BEAD CONTOUR. IT IS RECOMMENDED THAT THE OPTIONAL BEAD CONSTRUCTION BE SPECIFIED FOR QUART SIZE AND LARGER WHERE IMPROVED CONTAINER GRIPABILITY IS NECESSARY.
- OPTIONAL - THIS AREA AS SPECIFIED MAY BE FILLED IN WITH GLASS NOT TO EXCEED THE THREAD PROJECTION.
- A LEVEL TOP FINISH IS IDEAL. MAXIMUM SADDLE IS .010" WITHIN 180°. CORRECTIONS SHOULD BE MADE IF A GLASS LOT CHECK SHOWS IT "RUNNING TOWARD MAX. SADDLES".
- OPTIONAL - FOR RELIEF OF MOLD OPENINGS. THREAD PROJECTION MAY BE DEPRESSED AT THE PARTING LINE. MAXIMUM ALLOWABLE DEPRESSION IS .005 PER SIDE FROM THE AVERAGE OF ACTUAL THREAD PROJECTIONS MEASURED ON A 6° ARC ON EITHER SIDE OF THE PARTING LINE.
- THE .432 DIMENSION REPRESENTS THE DISTANCE FROM TOP OF SEALING SURFACE DOWN TO HORIZONTAL LINE TANGENT TO BOTTOM SWING OF .062 RADIUS.
- "B" SPECIFICATION TO BE MAINTAINED TO .275 DOWN. BELOW THIS POINT A SLIGHTLY UNDER MINIMUM "B" IS ACCEPTABLE, HOWEVER THE MAXIMUM SPECIFICATION CANNOT BE EXCEEDED.
- VERTICAL DIMENSIONS WITH ASTERISKS (*) DENOTE THE GAGING DEPTHS FOR THE 'E₁', 'E', 'T', & 'B' DIAMETERS.
- PARTING LINE OFFSET AT .065 MIN. DEPTH MAY BE UP TO .010 ON A SIDE WITH .015 MAX. PER DIAMETER I.E. AMOUNT ON ONE SIDE ADDED TO AMOUNT ON OTHER SIDE SAME DIAMETER CAN BE EQUAL TO OR LESS THAN .015. AN OVERHANG OF THE .065 MIN. SECTION OUTSIDE OF THE "E" DIAMETER IS NOT PERMITTED.
- SECTION OF FINISH DENOTED BY HEAVY BLACK LINE IS TO BE FORMED IN A ONE PIECE "SLEEVE" OR "GUIDE RING". NO SEAMS OR PARTING LINES PERMITTED.
- TANGENT B = $\frac{\text{LEAD}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
- "E" DIAMETER IS MEASURED AT THIS LOCATION AND REPRESENTS ENTIRE "E" HEIGHT. THEREFORE, IT MUST BE AS VERTICAL AS POSSIBLE WITHOUT IRREGULARITIES THAT INFLUENCE "E" DIA. MEASUREMENTS.

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48mm & 51mm PRESS ON TWIST OFF MULTI-PASS FINISH (4 LEAD)