



SIZE	T	E	S	H	I MIN.	R MAX.	B	CUT. DIA.	T.P.I.
20	0.773 ±.010	0.689 ±.010	0.095 ±.010	0.386 ^{+.008} / _{-.007}	0.404	0.042	2° 30'	0.375	10
22	0.852 ±.010	0.768 ±.010	0.095 ±.010	0.386 ^{+.008} / _{-.007}	0.483	0.042	2° 15'	0.375	10
24	0.930 ±.010	0.846 ±.010	0.095 ±.010	0.386 ^{+.008} / _{-.007}	0.516	0.042	2° 3'	0.375	10
26	0.996 ^{+.012} / _{-.013}	0.902 ^{+.012} / _{-.013}	0.095 ±.010	0.427 ^{+.008} / _{-.007}	0.535	0.062	2° 24'	0.500	8
28	1.076 ^{+.012} / _{-.013}	0.982 ^{+.012} / _{-.013}	0.095 ±.010	0.427 ^{+.008} / _{-.007}	0.680	0.062	2° 13'	0.500	8
30	1.115 ^{+.012} / _{-.013}	1.021 ^{+.012} / _{-.013}	0.095 ±.010	0.430 ±.010	0.693	0.062	2° 8'	0.500	8
33	1.253 ^{+.012} / _{-.013}	1.159 ^{+.012} / _{-.013}	0.095 ±.010	0.430 ±.010	0.791	0.078	1° 53'	0.500	8
35	1.347 ^{+.017} / _{-.018}	1.253 ^{+.017} / _{-.018}	0.095 ±.010	0.430 ±.010	0.875	0.078	1° 49'	0.500	8
38	1.459 ^{+.017} / _{-.018}	1.365 ^{+.017} / _{-.018}	0.095 ±.010	0.430 ±.010	0.987	0.078	1° 37'	0.500	8
43	1.637 ^{+.017} / _{-.018}	1.543 ^{+.017} / _{-.018}	0.063 ±.010	0.476 ±.010	1.165	0.078	1° 55'	0.500	6
48	1.853 ^{+.017} / _{-.018}	1.759 ^{+.017} / _{-.018}	0.063 ±.010	0.476 ±.010	1.381	0.078	1° 41'	0.500	6
53	2.050 ^{+.017} / _{-.018}	1.956 ^{+.017} / _{-.018}	0.063 ±.010	0.481 ±.015	1.578	0.078	1° 31'	0.500	6
58	2.207 ^{+.017} / _{-.018}	2.113 ^{+.017} / _{-.018}	0.063 ±.010	0.481 ±.015	1.735	0.078	1° 25'	0.500	6
63	2.441 ±.020	2.347 ±.020	0.063 ±.010	0.481 ±.015	1.972	0.078	1° 16'	0.500	6
70	2.716 ±.020	2.622 ±.020	0.063 ±.010	0.481 ±.015	2.247	0.078	1° 8'	0.500	6
77	3.015 ±.020	2.921 ±.020	0.063 ±.010	0.481 ±.015	2.546	0.078	1° 1'	0.500	6
83	3.222 ±.020	3.128 ±.020	0.063 ±.010	0.481 ±.015	2.753	0.078	0° 57'	0.500	6
89	3.463 ^{+.022} / _{-.023}	3.369 ^{+.022} / _{-.023}	0.063 ±.010	0.481 ±.015	2.918	0.078	0° 53'	0.500	6
100	3.889 ^{+.022} / _{-.023}	3.795 ^{+.022} / _{-.023}	0.063 ±.010	0.481 ±.015	3.344	0.078	0° 47'	0.500	6

- 'H' DIMENSION REPRESENTS DISTANCE FROM TOP OF FINISH DOWN TO POINT WHERE LINE TANGENT TO 'T' INTERSECTS TOP OF BEAD. WHEN BEAD DIAMETER & CONSTRUCTION IS AT OR NEAR SPECIFIED 'T' DIAMETER, THE PLUS TOLERANCE IS NOT REQUIRED. WHEN FINISH IS MADE WITHOUT BEAD, 'H' DIMENSION IS MEASURED TO SHOULDER & ITS PLUS TOLERANCE IS INCREASED BY .015 ON SIZES TO & INCLUDING 28 & BY .025 ON SIZES LARGER THAN 28.
- B = HELIX ANGLE OR ANGLE OF FIXTURE TO CUTTER.
- TANGENT B = $\frac{\text{PITCH}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
- A MINIMUM OF ONE TURN OF THREAD SHOULD BE MAINTAINED, WITH FULL PROJECTION EXCEPT WHEN DEPRESSED OR INTERRUPTED AT MOLD SEAMS. REFER TO GLASS FINISH NO. 405 FOR DEPRESSED THREAD DETAIL.
- CONTOUR OF BEAD OR TRANSFER RING TO BE OPTIONAL PROVIDED TOP OF BEAD CLEARS A 5° MINIMUM DOWNWARD ANGLE.
- 'I' DIMENSION IS MEASURED THROUGH FULL LENGTH OF FINISH.
- THIS FINISH TO BE MADE SMOOTH TOP CONSTRUCTION.

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Edward Grant CHAIRMAN	PRINTED AND DISTRIBUTED AS A VOLUNTARY STANDARD BY GLASS PACKAGING INSTITUTE COMMITTEE ON DESIGN AND SPECIFICATIONS	APPROVED FOR PUBLICATION 6-21-01	SUPERSEDES DWG. NO. 4206
GLASS FINISH NUMBER 420		GPI DWG. NO.	
CONTINUOUS THREAD FINISH FOR POLYPROPYLENE LINERLESS CLOSURE		4207	