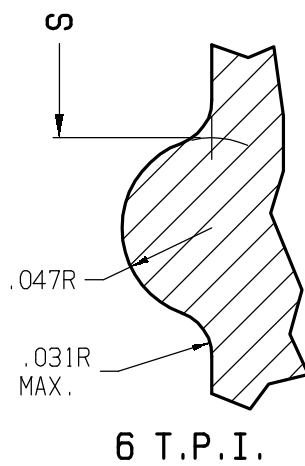
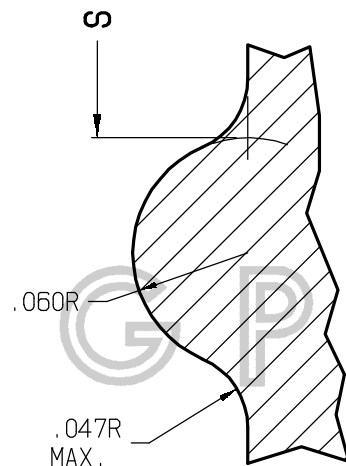


SECTION X-X

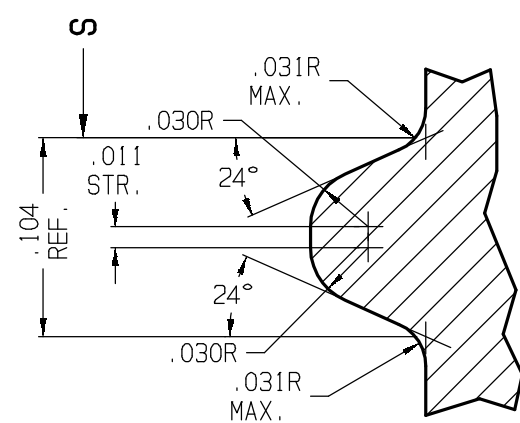


6 T.P.I.



5 T.P.I.

THREAD CROSS SECTIONS



5 & 6 T.P.I.

MODIFIED "B" THREAD
(PREFERRED FOR PLASTIC CLOSURES)

SIZE	T	E	H	I	R	S	B	CUT. DIA.	T.P.I.
			SEE NOTE 1	MIN.	MAX.				
45	1.723 ^{+0.017} / _{-.018}	1.629 ^{+0.017} / _{-.018}	0.648 ^{+0.018} / _{-.017}	1.251	0.078	0.175 ^{+0.016} / _{-.015}	1° 49'	0.500	6
53	2.050 ^{+0.017} / _{-.018}	1.956 ^{+0.017} / _{-.018}	0.648 ^{+0.018} / _{-.017}	1.578	0.078	0.175 ^{+0.016} / _{-.015}	1° 31'	0.500	6
56	2.128 ^{+0.017} / _{-.018}	2.034 ^{+0.017} / _{-.018}	0.648 ^{+0.018} / _{-.017}	1.656	0.078	0.175 ^{+0.016} / _{-.015}	1° 28'	0.500	6
58	2.207 ^{+0.017} / _{-.018}	2.113 ^{+0.017} / _{-.018}	0.648 ^{+0.018} / _{-.017}	1.735	0.078	0.175 ^{+0.016} / _{-.015}	1° 25'	0.500	6
63	2.441 ±.020	2.347 ±.020	0.648 ^{+0.018} / _{-.017}	1.972	0.078	0.175 ^{+0.016} / _{-.015}	1° 16'	0.500	6
73	2.844 ±.020	2.750 ±.020	0.648 ^{+0.018} / _{-.017}	2.375	0.078	0.175 ^{+0.016} / _{-.015}	1° 5'	0.500	6
75	2.893 ±.020	2.799 ±.020	0.648 ^{+0.018} / _{-.017}	2.424	0.078	0.175 ^{+0.016} / _{-.015}	1° 4'	0.500	6
77	3.041 ±.020	2.921 ±.020	0.648 ^{+0.018} / _{-.017}	2.546	0.078	0.140 ^{+0.016} / _{-.015}	1° 14'	0.500	5
79	3.090 ±.020	2.970 ±.020	0.648 ^{+0.018} / _{-.017}	2.595	0.078	0.140 ^{+0.016} / _{-.015}	1° 12'	0.500	5
83	3.248 ±.020	3.128 ±.020	0.648 ^{+0.018} / _{-.017}	2.753	0.078	0.140 ^{+0.016} / _{-.015}	1° 9'	0.500	5

- 'H' DIMENSION REPRESENTS DISTANCE FROM TOP OF FINISH DOWN TO POINT WHERE LINE TANGENT TO 'T' INTERSECTS TOP OF BEAD. WHEN FINISH IS MADE WITHOUT BEAD, 'H' DIMENSION IS MEASURED TO SHOULDER AND ITS PLUS TOLERANCE IS INCREASED BY .025.
- 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.
- FOR THE 73 SIZE AND ABOVE, A 1.500 DIAMETER CUTTER IS PREFERRED.
- FOR ALL SPECIAL APPLICATIONS, THE END USER SHOULD OBTAIN SPECIFICATIONS FROM THE SPECIFIC CLOSURE MANUFACTURER.

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GLASS FINISH NUMBER 445		GPI DWG. NO.	
DEEP 'S' CONTINUOUS THREAD FINISH		4465	