



SIZE	C	T	E	B	L CONS'T	S MAX.	K MIN.	I MIN.
26	0.780 ^{+0.013} / _{-.012}	1.050 ^{+0.013} / _{-.012}	1.010 ^{+0.013} / _{-.012}	1.062 ^{+0.031} / _{-.015}	0.255	0.088	0.234	0.635

- FOR IDEAL SEALING OF CROWN LINER THE INNER LIP MUST BE SHARP CORNERED TO .031 MAX. RADIUS.
- CERTAIN CAPPING EQUIPMENT REQUIRES THAT NECK CONTOUR BE WITHIN LIMITS OF RECOMMENDED GAUGE CONTOUR.
- THE ANGLE OF THE CUTTER TO THE FIXTURE IS EQUAL TO THE HELIX ANGLE.
- THE SEALING SURFACE IS SHOWN BY THE HEAVY LINE.
- 'I' DIMENSION IS MEASURED THROUGH ENTIRE FINISH AND NECK OF BOTTLE.
- THE 'C' DIMENSION MUST BE MAINTAINED AS SHOWN, USING A CYLINDRICAL TYPE GAUGE, MEASURED .031 DOWN FROM TOP OF FINISH.
- THE 'S' DIMENSION REPRESENTS THE DISTANCE FROM THE TOP OF FINISH TO A CONSTRUCTION POINT MEASURED AT THE FIRST FULL START OF THREAD. THE 'K' DIMENSION IS THE VERTICAL DISTANCE FROM THE TOP OF THE FINISH TO THE BOTTOM SWING OF .016 CREST RADIUS OF THE THREAD CONTOUR AT THE LOWEST POINT AT THE END OF THREAD.
- SEALING SURFACE OF THE FINISH NOT TO BE OUT OF PARALLEL WITH BASE OF BOTTLE IN EXCESS OF .025.
- THREADS MUST NOT BE DEPRESSED.
- TOP OF FINISH SHOULD BE FREE OF RADIAL SEAMS AND IN ORDER TO PREVENT CHIPPING WHEN USING CERTAIN TYPES OF OPENERS, ITS DIAMETER MUST NOT EXCEED 'E' DIAMETER AT HORIZONTAL PARTING LINE. UNDERMATCH AT GUIDE RING IS CONSIDERED TO BE IDEAL IF MADE .000 TO .005. TO PROVIDE FOR GUIDE RING SHIFT, +.008 UNDERMATCH IS PERMITTED ON MAXIMUM SIDE ONLY.
- NECK RING IS PARTED THROUGH SINGLE THREAD.
- PROPER APPLICATION AND FUNCTION OF CLOSURE REQUIRES THAT VARIATIONS IN THE 'E' DIAMETER SHOULD FOLLOW THOSE OF 'T' SUBJECT TO NORMAL MANUFACTURING CONDITIONS, INCLUDING THE THREAD PROFILE ILLUSTRATED.
- THE .007 FLAT SHOWN IN THE THREAD CROSS SECTION DETAIL IS OPTIONAL. WHEN THE FLAT IS NOT USED, THE 'S' DIMENSION SHOULD BE ADJUSTED TO .095 MAX.
- TANGENT B = $\frac{\text{LEAD}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
- IT IS THE RESPONSIBILITY OF THE GLASS CONTAINER PURCHASER TO CONSULT WITH ITS CLOSURE AND CONTAINER SUPPLIERS TO DETERMINE THE APPROPRIATE PRESSURE LIMITS FOR THE COMBINATION OF THE CONTAINER, ITS FINISH, AND THE CLOSURE CHOSEN, WHEN THE CONTAINER WILL BE SUBJECTED TO PRESSURE OR USED FOR CONTENTS UNDER PRESSURE.

THREAD IS 4 LEADS, EACH OF WHICH IS 2.7 T.P.I.
 THREAD LEAD = .370
 CUTTER DIAMETER = .500
 HELIX ANGLE (B) = 6° 31'
 START THREADS 90° APART
 THREAD TRAVEL 108° MIN.

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GLASS FINISH NUMBER 535		GPI DWG. NO.	
THREADED CROWN FINISH		5357	

PARTING LINE THROUGH SINGLE THREAD